

HiFill® PEI GF30

 Techmer Polymer Modifiers - *Polyetherimide*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight
Appearance	• Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.51		ASTM D792
Molding Shrinkage - Flow (0.125 in)	2.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.16	%	ASTM D570
Mechanical			
Nominal Value Unit Test Method			
Tensile Strength (Break)	23400	psi	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	1.30E+6	psi	ASTM D790
Flexural Strength	33000	psi	ASTM D790
Impact			
Nominal Value Unit Test Method			
Notched Izod Impact (73°F, 0.125 in)	1.6	ft·lb/in	ASTM D256
Unnotched Izod Impact (0.125 in)	9.0	ft·lb/in	ASTM D4812
Hardness			
Nominal Value Unit Test Method			
Rockwell Hardness (R-Scale)	121		ASTM D785
Thermal			
Nominal Value Unit Test Method			
Deflection Temperature Under Load (66 psi, Unannealed)	415	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	410	°F	ASTM D648
CLTE - Flow	1.1E-5	in/in/°F	ASTM D696
Electrical			
Nominal Value Unit Test Method			
Volume Resistivity	1.0E+16	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	630	V/mil	ASTM D149

Processing Information

	Nominal Value	Unit
Injection		
Drying Temperature	285	°F
Drying Time	3.0	hr
Rear Temperature	675 to 735	°F
Middle Temperature	675 to 735	°F
Front Temperature	675 to 735	°F
Processing (Melt) Temp	670 to 730	°F
Mold Temperature	275 to 325	°F
Back Pressure	50.0 to 100	psi
Screw Speed	50 to 100	rpm

