

**HiFill® PEI HF BK**

 Techmer Polymer Modifiers - *Polyetherimide*
**General Information**
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Material Status	<ul style="list-style-type: none"> <li>Commercial: Active</li> </ul>
Availability	<ul style="list-style-type: none"> <li>North America</li> </ul>
Features	<ul style="list-style-type: none"> <li>High Flow</li> </ul>
Appearance	<ul style="list-style-type: none"> <li>Black</li> </ul>
Forms	<ul style="list-style-type: none"> <li>Pellets</li> </ul>
Processing Method	<ul style="list-style-type: none"> <li>Injection Molding</li> </ul>

**Properties <sup>1</sup>**

	Nominal Value	Unit	Test Method
<b>Physical</b>			
Density / Specific Gravity	1.26		ASTM D792
Molding Shrinkage - Flow (0.125 in)	6.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.30	%	ASTM D570
<b>Mechanical</b>			
<b>Nominal Value Unit Test Method</b>			
Tensile Strength (Yield)	16000	psi	ASTM D638
Tensile Elongation (Break)	7.0	%	ASTM D638
Flexural Modulus	510000	psi	ASTM D790
Flexural Strength (Yield)	25000	psi	ASTM D790
<b>Impact</b>			
<b>Nominal Value Unit Test Method</b>			
Notched Izod Impact (0.125 in)	1.0	ft·lb/in	ASTM D256
Unnotched Izod Impact (0.125 in)	24	ft·lb/in	ASTM D4812
<b>Hardness</b>			
<b>Nominal Value Unit Test Method</b>			
Rockwell Hardness (R-Scale)	121		ASTM D785
<b>Thermal</b>			
<b>Nominal Value Unit Test Method</b>			
Deflection Temperature Under Load (66 psi, Unannealed)	418	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	388	°F	ASTM D648
CLTE - Flow	3.0E-5	in/in/°F	ASTM D696
<b>Electrical</b>			
<b>Nominal Value Unit Test Method</b>			
Volume Resistivity	1.0E+16	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	500	V/mil	ASTM D149

**Processing Information**

	Nominal Value	Unit
<b>Injection</b>		
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

