

HiFill® PEI GF20

 Techmer Polymer Modifiers - *Polyetherimide*
General Information
General

Material Status	<ul style="list-style-type: none"> Commercial: Active
Availability	<ul style="list-style-type: none"> North America
Filler / Reinforcement	<ul style="list-style-type: none"> Glass Fiber, 20% Filler by Weight
Appearance	<ul style="list-style-type: none"> Colors Available
Forms	<ul style="list-style-type: none"> Pellets
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.41		ASTM D792
Molding Shrinkage - Flow (0.125 in)	4.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.22	%	ASTM D570
Mechanical			
Nominal Value Unit Test Method			
Tensile Strength (Break)	21500	psi	ASTM D638
Flexural Modulus	950000	psi	ASTM D790
Flexural Strength	31500	psi	ASTM D790
Impact			
Nominal Value Unit Test Method			
Notched Izod Impact (73°F, 0.125 in)	1.5	ft·lb/in	ASTM D256
Thermal			
Nominal Value Unit Test Method			
Deflection Temperature Under Load (264 psi, Unannealed)	415	°F	ASTM D648
Flammability			
Nominal Value Unit Test Method			
Flame Rating	V-0		UL 94

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

