

**HiFill® PP CL GY446 OPT A**

 Techmer Polymer Modifiers - *Polypropylene*
**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>
Appearance	<ul style="list-style-type: none"> <li>Grey</li> </ul>
Processing Method	<ul style="list-style-type: none"> <li>Injection Molding</li> </ul>

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

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.900		ASTM D792
Molding Shrinkage - Flow (0.125 in)	3.0E-3 to 5.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	195000	psi	ASTM D638
Tensile Strength (Yield)	4000	psi	ASTM D638
Tensile Strength (Break)	2500	psi	ASTM D638
Tensile Elongation (Break)	250	%	ASTM D638
Flexural Modulus	170000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.80	ft·lb/in	ASTM D256

**Processing Information**

Injection	Nominal Value	Unit
Drying Temperature	150	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	430 to 470	°F
Middle Temperature	440 to 480	°F
Front Temperature	450 to 490	°F
Nozzle Temperature	455 to 495	°F
Processing (Melt) Temp	440 to 495	°F
Mold Temperature	50 to 150	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow	

