

**HiFill FR® PP CO FR HS BK**

 Techmer Polymer Modifiers - *Polypropylene Copolymer*
**General Information**

<b>General</b>		
Material Status	• Commercial: Active	
Availability	• North America	
Additive	• Flame Retardant	• Heat Stabilizer
Features	• Flame Retardant	• Heat Stabilized
Appearance	• Black	
Processing Method	• Injection Molding	

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

<b>Physical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Density / Specific Gravity	1.23		ASTM D792
Molding Shrinkage - Flow (0.125 in)	7.0E-3 to 9.0E-3	in/in	ASTM D955
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Modulus	120000	psi	ASTM D638
Tensile Strength (Yield)	2900	psi	ASTM D638
Tensile Strength (Break)	2400	psi	ASTM D638
Tensile Elongation (Break)	150	%	ASTM D638
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact (0.125 in)	2.0	ft·lb/in	ASTM D256
<b>Flammability</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Flame Rating			UL 94
0.06 in	V-0		
0.12 in	V-0		

**Processing Information**

<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>
Drying Temperature	150	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	440 to 480	°F
Middle Temperature	450 to 490	°F
Front Temperature	460 to 500	°F
Nozzle Temperature	465 to 505	°F
Processing (Melt) Temp	450 to 505	°F
Mold Temperature	75 to 150	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow	

**Notes**
<sup>1</sup> Typical properties: these are not to be construed as specifications.
