

HiFill® PP 13R9A GF30 NAT

 Techmer Polymer Modifiers - *Polypropylene Copolymer*
General Information
General

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

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.12		ASTM D792
Molding Shrinkage - Flow (0.125 in)	7.0E-3 to 0.010	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	700000	psi	ASTM D638
Tensile Strength (Yield)	5500	psi	ASTM D638
Tensile Strength (Break)	5500	psi	ASTM D638
Tensile Elongation (Break)	2.0	%	ASTM D638
Flexural Modulus	650000	psi	ASTM D790
Flexural Strength	7200	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.70	ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	170	°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	470 to 510	°F
Processing (Melt) Temp	440 to 500	°F
Mold Temperature	75 to 150	°F
Injection Rate	Slow	
Back Pressure	50.0 to 100	psi
Screw Speed	Moderate	

Notes

¹ Typical properties: these are not to be construed as specifications.

