

HiFill FR® PP TM20 FR BK

 Techmer Polymer Modifiers - *Polypropylene*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Mineral
Additive	• Flame Retardant
Features	• Flame Retardant
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.35		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	620000	psi	ASTM D638
Tensile Strength (Yield)	3900	psi	ASTM D638
Tensile Strength (Break)	3400	psi	ASTM D638
Tensile Elongation (Break)	3.5	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.70	ft·lb/in	ASTM D256
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.06 in	V-0		
0.12 in	V-0		

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 490	°F
Mold Temperature	50 to 150	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow	

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