

HiFill® PP 0230 S1

 Techmer Polymer Modifiers - *Polypropylene*
General Information
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Material Status	• Commercial: Active
Availability	• North America
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	2.44		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	233000	psi	ASTM D638
Tensile Strength (Yield)	1900	psi	ASTM D638
Tensile Strength (Break)	1700	psi	ASTM D638
Tensile Elongation (Break)	37	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.1	ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	150	°F
Drying Time	1.0 to 2.0	hr
Rear Temperature	430 to 450	°F
Middle Temperature	440 to 460	°F
Front Temperature	450 to 470	°F
Nozzle Temperature	445 to 465	°F
Processing (Melt) Temp	430 to 475	°F
Mold Temperature	70 to 120	°F
Injection Rate	Slow	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow-Moderate	

