

HiFill® PP GB40 BK

 Techmer Polymer Modifiers - *Polypropylene*
General Information
General

| | |
|------------------------|------------------------------------|
| Material Status | • Commercial: Active |
| Availability | • North America |
| Filler / Reinforcement | • Glass Bead, 40% Filler by Weight |
| Appearance | • Black |
| Processing Method | • Injection Molding |

Properties ¹

| Physical | Nominal Value | Unit | Test Method |
|---|----------------------|-------------|--------------------|
| Density / Specific Gravity | 1.22 | | ASTM D792 |
| Melt Mass-Flow Rate (MFR) (230°C/2.16 kg) | 8.0 | g/10 min | ASTM D1238 |
| Molding Shrinkage - Flow (0.125 in) | 7.0E-3 to 9.0E-3 | in/in | ASTM D955 |
| Mechanical | Nominal Value | Unit | Test Method |
| Tensile Modulus | 400000 | psi | ASTM D638 |
| Tensile Strength (Yield) | 4000 | psi | ASTM D638 |
| Tensile Strength (Break) | 3000 | psi | ASTM D638 |
| Tensile Elongation (Break) | 40 | % | ASTM D638 |
| Impact | Nominal Value | Unit | Test Method |
| Notched Izod Impact (0.125 in) | 0.40 | 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 | 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 | 450 to 510 | °F |
| Mold Temperature | 75 to 150 | °F |
| Injection Rate | Slow-Moderate | |
| Back Pressure | 25.0 to 75.0 | psi |
| Screw Speed | Moderate | |

