

**HiFill® TPO CM30 D2 BK**

 Techmer Polymer Modifiers - *Polypropylene*
**General Information**
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Material Status	<ul style="list-style-type: none"> <li>Commercial: Active</li> </ul>
Availability	<ul style="list-style-type: none"> <li>North America</li> </ul>
Filler / Reinforcement	<ul style="list-style-type: none"> <li>Filler</li> </ul>
Appearance	<ul style="list-style-type: none"> <li>Black</li> </ul>
Processing Method	<ul style="list-style-type: none"> <li>Injection Molding</li> </ul>

**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)	8.0E-3 to 0.011	in/in	ASTM D955
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Modulus	410000	psi	ASTM D638
Tensile Strength (Yield)	3100	psi	ASTM D638
Tensile Strength (Break)	2800	psi	ASTM D638
Tensile Elongation (Break)	7.4	%	ASTM D638
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact (0.125 in)	0.80	ft·lb/in	ASTM D256

**Processing Information**

<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>
Drying Temperature	150	°F
Drying Time	1.0 to 2.0	hr
Rear Temperature	440 to 490	°F
Middle Temperature	450 to 500	°F
Front Temperature	460 to 510	°F
Nozzle Temperature	455 to 505	°F
Processing (Melt) Temp	450 to 510	°F
Mold Temperature	50 to 150	°F
Injection Rate	Slow	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow	

**Notes**

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

