

HiFill® TPX-PP-05004 LE

 Techmer Polymer Modifiers - *Polypropylene*
General Information
General

Material Status	<ul style="list-style-type: none"> Commercial: Active
Availability	<ul style="list-style-type: none"> North America
Features	<ul style="list-style-type: none"> Homopolymer
Appearance	<ul style="list-style-type: none"> Natural Color
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.900		ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	20	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	310000	psi	ASTM D638
Tensile Strength (Yield)	5500	psi	ASTM D638
Tensile Strength (Break)	5000	psi	ASTM D638
Tensile Elongation (Break)	8.0	%	ASTM D638
Flexural Modulus	260000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.40	ft·lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	230	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	150	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	420 to 460	°F
Middle Temperature	430 to 470	°F
Front Temperature	440 to 480	°F
Nozzle Temperature	450 to 490	°F
Processing (Melt) Temp	425 to 485	°F
Mold Temperature	75 to 125	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Moderate	

