

HiFill® TPX-HTN-01040 A GY378

 Techmer Polymer Modifiers - *Polyphthalamide*
General Information
General

Material Status	<ul style="list-style-type: none"> Commercial: Active
Availability	<ul style="list-style-type: none"> North America
Filler / Reinforcement	<ul style="list-style-type: none"> Glass Fiber
Appearance	<ul style="list-style-type: none"> Grey
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.61		ASTM D792
Molding Shrinkage - Flow (0.125 in)	5.0E-3 to 7.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2.30E+6	psi	ASTM D638
Tensile Strength (Yield)	34500	psi	ASTM D638
Tensile Strength (Break)	34000	psi	ASTM D638
Tensile Elongation (Break)	2.4	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.6	ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	550 to 590	°F
Middle Temperature	560 to 600	°F
Front Temperature	570 to 610	°F
Nozzle Temperature	580 to 625	°F
Processing (Melt) Temp	560 to 620	°F
Mold Temperature	200 to 300	°F
Injection Rate	Slow	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow	

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