

**HiFill® TPU 70A NAT**

 Techmer Polymer Modifiers - *Polyurethane*
**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>
Appearance	<ul style="list-style-type: none"> <li>Natural Color</li> </ul>
Processing Method	<ul style="list-style-type: none"> <li>Injection Molding</li> </ul>

**Properties <sup>1</sup>**

Physical	Nominal Value	Unit	Test Method
Density	1.08	g/cm <sup>3</sup>	ISO 1183
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			DIN 53504
20% Strain	188	psi	
100% Strain	290	psi	
300% Strain	700	psi	
Tensile Strength (Yield)	4350	psi	DIN 53504
Tensile Elongation (Break)	850	%	DIN 53504
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	No Break		ISO 179
Hardness	Nominal Value	Unit	Test Method
Shore Hardness (Shore A)	70		ISO 7619

**Processing Information**

Injection	Nominal Value	Unit
Drying Temperature	150	°F
Drying Time	1.0 to 2.0	hr
Rear Temperature	345 to 375	°F
Middle Temperature	355 to 385	°F
Front Temperature	365 to 395	°F
Nozzle Temperature	370 to 405	°F
Processing (Melt) Temp	350 to 410	°F
Mold Temperature	50 to 100	°F
Injection Rate	Slow	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow-Moderate	

