

**HiFill FR® TPU FR BN711334**

 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>
Additive	<ul style="list-style-type: none"> <li>Flame Retardant</li> </ul>
Features	<ul style="list-style-type: none"> <li>Flame Retardant</li> </ul>
Appearance	<ul style="list-style-type: none"> <li>Brown</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	1.22		ASTM D792
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Modulus	4500	psi	ASTM D638
Tensile Strength (Yield)	500	psi	ASTM D638
Tensile Elongation (Break)	150	%	ASTM D638
Flexural Modulus	5200	psi	ASTM D790
Flexural Strength	600	psi	ASTM D790
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact (0.125 in)	3.0	ft-lb/in	ASTM D256
<b>Hardness</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Durometer Hardness (Shore A)	84		ASTM D2240
<b>Flammability</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Flame Rating			UL 94
0.06 in		V-0	
0.12 in		V-0	

**Processing Information**

<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>
Drying Temperature	150	°F
Drying Time	2.0 to 3.0	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	0.00 to 50.0	psi
Screw Speed		Slow-Moderate

