

**HiFill® TPU GF20 B7 BK**

 Techmer Polymer Modifiers - *Polyurethane*
**General Information**
**General**

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>Glass Fiber, 20% Filler by Weight</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	1.35		ASTM D792
Molding Shrinkage - Flow (0.125 in)	4.0E-3 to 8.0E-3	in/in	ASTM D955
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Modulus	440000	psi	ASTM D638
Tensile Strength (Yield)	8300	psi	ASTM D638
Tensile Strength (Break)	8000	psi	ASTM D638
Tensile Elongation (Break)	17	%	ASTM D638
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact (0.125 in)	1.9	ft-lb/in	ASTM D256

**Processing Information**

<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>
Drying Temperature	220	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	360 to 400	°F
Middle Temperature	370 to 410	°F
Front Temperature	380 to 420	°F
Nozzle Temperature	385 to 425	°F
Processing (Melt) Temp	370 to 420	°F
Mold Temperature	50 to 125	°F
Injection Rate	Moderate	
Back Pressure	50.0 to 150	psi
Screw Speed	Slow-Moderate	

