

**HiFill® PVDF CLS BL GN 17007845**

 Techmer Polymer Modifiers - *Polyvinylidene Fluoride*
**General Information**
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Material Status	• Commercial: Active
Availability	• North America
Appearance	• Blue
Processing Method	• Injection Molding

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

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.73		ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	22	g/10 min	ASTM D1238
Moisture (284°F)	0.040	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	7200	psi	ASTM D638

**Processing Information**

Injection	Nominal Value	Unit
Drying Temperature	150	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	375 to 400	°F
Middle Temperature	380 to 410	°F
Front Temperature	390 to 420	°F
Nozzle Temperature	385 to 420	°F
Processing (Melt) Temp	380 to 420	°F
Mold Temperature	125 to 200	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow	

**Notes**
<sup>1</sup> Typical properties: these are not to be construed as specifications.
