

HiFill® PVDF 1003

 Techmer Polymer Modifiers - *Polyvinylidene Fluoride*
General Information
General

Material Status	<ul style="list-style-type: none"> Commercial: Active
Availability	<ul style="list-style-type: none"> North America
Appearance	<ul style="list-style-type: none"> Natural Color
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.76		ASTM D792
Molding Shrinkage - Flow (0.125 in)	8.0E-3 to 0.010	in/in	ASTM D955
Water Absorption (24 hr)	< 0.040	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	290000	psi	ASTM D638
Tensile Strength (Yield)	7500	psi	ASTM D638
Tensile Strength (Break)	6500	psi	ASTM D638
Tensile Elongation (Break)	30	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	2.2	ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	150	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	340 to 380	°F
Middle Temperature	350 to 390	°F
Front Temperature	360 to 400	°F
Nozzle Temperature	370 to 410	°F
Processing (Melt) Temp	350 to 410	°F
Mold Temperature	50 to 150	°F
Injection Rate	Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

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