

**HiFill® TPEL 6356 GF25 NAT**

 Techmer Polymer Modifiers - *Thermoplastic Elastomer*
**General Information**
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Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 25% Filler by Weight
Processing Method	• Injection Molding

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

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.41		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.012 to 0.015	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	540000	psi	ASTM D638
Tensile Strength (Yield)	10000	psi	ASTM D638
Tensile Strength (Break)	9500	psi	ASTM D638
Tensile Elongation (Break)	8.0	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	4.0	ft·lb/in	ASTM D256

**Processing Information**

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	440 to 470	°F
Middle Temperature	450 to 480	°F
Front Temperature	460 to 500	°F
Nozzle Temperature	465 to 505	°F
Processing (Melt) Temp	450 to 500	°F
Mold Temperature	100 to 150	°F
Injection Rate	Slow	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

