

HiFill® TPE 1091 55A BK

 Techmer Polymer Modifiers - *Thermoplastic Elastomer*
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"> Black
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.950		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	420	psi	ASTM D638
Tensile Elongation (Break)	250	%	ASTM D638
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	55		ASTM D2240
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.06 in		HB	
0.12 in		HB	

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	3.0 to 4.0	hr
Rear Temperature	490 to 520	°F
Middle Temperature	500 to 530	°F
Front Temperature	510 to 540	°F
Nozzle Temperature	525 to 545	°F
Processing (Melt) Temp	500 to 545	°F
Mold Temperature	75 to 150	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow	

