

HiFill® TPU 85A 0152 S2 LE BK

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

Material Status	• Commercial: Active
Availability	• North America
Features	• Metal Detectable
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.52		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	6000	psi	ASTM D638
Tensile Strength (Yield)	3200	psi	ASTM D638
Tensile Strength (Break)	3200	psi	ASTM D638
Tensile Elongation (Break)	> 300	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	6.5	ft-lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	85		ASTM D2240

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	150	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	345 to 375	°F
Middle Temperature	355 to 385	°F
Front Temperature	365 to 395	°F
Nozzle Temperature	370 to 405	°F
Processing (Melt) Temp	350 to 410	°F
Mold Temperature	50 to 100	°F
Injection Rate	Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow-Moderate	

