

HiFill® TPU GF20 NAT

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

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.34		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	500000	psi	ASTM D638
Tensile Strength (Yield)	8500	psi	ASTM D638
Tensile Elongation (Break)	15	%	ASTM D638
Flexural Modulus	500000	psi	ASTM D790
Flexural Strength	13200	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	2.0	ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	220	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	325 to 400	°F
Middle Temperature	375 to 430	°F
Front Temperature	375 to 430	°F
Nozzle Temperature	375 to 430	°F
Processing (Melt) Temp	390 to 450	°F
Mold Temperature	70 to 130	°F
Injection Rate	Slow	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow	

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