

**HiFill® TPU STX-IM UV Carbon**

 Techmer Polymer Modifiers - *Thermoplastic Polyurethane Elastomer*
**General Information**
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Material Status	<ul style="list-style-type: none"> <li>Commercial: Active</li> </ul>
Availability	<ul style="list-style-type: none"> <li>North America</li> </ul>
Processing Method	<ul style="list-style-type: none"> <li>Injection Molding</li> </ul>

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

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.20		ASTM D792
Moisture (266°F)	0.050	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	7300	psi	ASTM D638
Tensile Elongation (Break)	88	%	ASTM D638
Flexural Modulus	275000	psi	ASTM D790
Flexural Strength	9900	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	12	ft·lb/in	ASTM D256

**Processing Information**

Injection	Nominal Value	Unit
Drying Temperature	220 to 250	°F
Drying Time	2.0 to 6.0	hr
Rear Temperature	455 to 475	°F
Middle Temperature	460 to 480	°F
Front Temperature	460 to 480	°F
Nozzle Temperature	470 to 490	°F
Processing (Melt) Temp	455 to 485	°F
Mold Temperature	110 to 150	°F
Injection Rate	Moderate	
Back Pressure	50.0 to 100	psi
Screw Speed	Moderate	

**Notes**
<sup>1</sup> Typical properties: these are not to be construed as specifications.
