

HiFill® HDPE GF30 CC BK

Techmer Polymer Modifiers - *High Density Polyethylene*

General Information

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.17		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	8300	psi	ASTM D638
Tensile Elongation (Break)	6.5	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	2.5	ft-lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	150	°F
Drying Time	1.0 to 2.0	hr
Rear Temperature	340 to 370	°F
Middle Temperature	350 to 380	°F
Front Temperature	360 to 390	°F
Nozzle Temperature	370 to 400	°F
Processing (Melt) Temp	350 to 405	°F
Mold Temperature	75 to 125	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow	

Notes

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

