

HiFill® PA FW23 Orange 3 Dark-PS3

Techmer Polymer Modifiers - *Polyamide*

General Information

General

Material Status	• Commercial: Active
Availability	• North America
Appearance	• Orange
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.63		ASTM D792
Moisture (311°F)	0.080	%	
Mechanical	Nominal Value	Unit	Test Method
Flexural Modulus	2.19E+6	psi	ISO 178
Flexural Stress	44300	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact (Area)	27.5	ft·lb/in ²	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	510 to 540	°F
Middle Temperature	520 to 550	°F
Front Temperature	530 to 560	°F
Nozzle Temperature	540 to 570	°F
Processing (Melt) Temp	515 to 565	°F
Mold Temperature	125 to 200	°F
Injection Rate	Slow	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow-Moderate	

Notes

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

