

## HiFill® PA FW24 Yellow 1 Dark-PS1

Techmer Polymer Modifiers - *Polyamide*

### General Information

#### General

|                   |                      |
|-------------------|----------------------|
| Material Status   | • Commercial: Active |
| Availability      | • North America      |
| Appearance        | • Yellow             |
| Processing Method | • Injection Molding  |

### Properties <sup>1</sup>

| Physical                       | Nominal Value | Unit                  | Test Method |
|--------------------------------|---------------|-----------------------|-------------|
| Density / Specific Gravity     | 1.70          |                       | ASTM D792   |
| Moisture (311°F)               | 0.14          | %                     |             |
| Mechanical                     | Nominal Value | Unit                  | Test Method |
| Flexural Modulus               | 2.51E+6       | psi                   | ISO 178     |
| Flexural Stress                | 48500         | psi                   | ISO 178     |
| Impact                         | Nominal Value | Unit                  | Test Method |
| Unnotched Izod Impact Strength | 28            | ft-lb/in <sup>2</sup> | ISO 180     |

### Processing Information

| Injection              | Nominal Value | Unit |
|------------------------|---------------|------|
| Drying Temperature     | 180           | °F   |
| Drying Time            | 4.0           | hr   |
| Rear Temperature       | 520 to 540    | °F   |
| Middle Temperature     | 520 to 540    | °F   |
| Front Temperature      | 530 to 550    | °F   |
| Nozzle Temperature     | 520 to 540    | °F   |
| Processing (Melt) Temp | 535 to 570    | °F   |
| Mold Temperature       | 150 to 180    | °F   |
| Injection Rate         | Slow          |      |
| Back Pressure          | 0.00 to 50.0  | psi  |
| Screw Speed            | Slow-Moderate |      |

### Notes

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

