

HiFill® PA HA21 StarDust-PS5-1

Techmer Polymer Modifiers - *Polyamide*

General Information

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

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.66		ASTM D792
Moisture (311°F)	0.090	%	
Mechanical	Nominal Value	Unit	Test Method
Flexural Modulus	2.28E+6	psi	ISO 178
Flexural Stress	43500	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact Strength	26	ft·lb/in ²	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 550	°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

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

