

HiFill® TPX-HDPE-01058

Techmer Polymer Modifiers - *High Density Polyethylene*

General Information

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Filler
Appearance	• Natural Color
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.20		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.010 to 0.015	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	320000	psi	ASTM D638
Tensile Strength (Yield)	3600	psi	ASTM D638
Tensile Strength (Break)	3000	psi	ASTM D638
Tensile Elongation (Break)	30	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.90	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	400 to 450	°F
Middle Temperature	410 to 460	°F
Front Temperature	420 to 470	°F
Nozzle Temperature	430 to 480	°F
Processing (Melt) Temp	390 to 480	°F
Mold Temperature	50 to 100	°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.

