

HiFill® HDPE GF10 CC

High Density Polyethylene

Techmer Engineered Solutions

Message:

HiFill® HDPE GF10 CC is a High Density Polyethylene product filled with 10% glass fiber. It can be processed by injection molding and is available in North America. Primary characteristic: chemically coupled.

General Information			
Filler / Reinforcement	Glass Fiber,10% Filler by Weight		
Features	Chemically Coupled		
Appearance	Colors Available		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.01	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	6.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.60	%	ASTM D955
Water Absorption (24 hr)	0.30	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	80		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	48.3	MPa	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	1590	MPa	ASTM D790
Flexural Strength	68.9	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	100	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	110	°C	
1.8 MPa, Unannealed	87.8	°C	
CLTE - Flow	7.2E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms · cm	ASTM D257
Dielectric Strength ¹	12	kV/mm	ASTM D149
Injection	Nominal Value	Unit	
Drying Temperature	76.7	°C	
Drying Time	2.0 to 3.0	hr	
Rear Temperature	232 to 260	°C	
Middle Temperature	232 to 260	°C	

Front Temperature	232 to 260	°C
Processing (Melt) Temp	218 to 246	°C
Mold Temperature	26.7 to 48.9	°C
Back Pressure	0.345 to 0.689	MPa
Screw Speed	30 to 60	rpm

NOTE

1. Method A (Short-Time)

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