HiFill® PVDF CF15 BK

Techmer Polymer Modifiers - *Polyvinylidene Fluoride*

General Information

General	
Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Carbon Fiber, 15% Filler by Weight
Appearance	• Black
Processing Method	• Injection Molding

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.76		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.020 to 0.025	in/in	ASTM D955
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	1.80E+6	psi	ASTM D638
Tensile Strength (Yield)	8000	psi	ASTM D638
Tensile Strength (Break)	7000	psi	ASTM D638
Tensile Elongation (Break)	1.0	%	ASTM D638
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (0.125 in)	1.2	ft·lb/in	ASTM D256
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	< 1.0E+6	ohms	ASTM D257

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	150	°F
Drying Time	1.0 to 2.0	hr
Rear Temperature	370 to 410	°F
Middle Temperature	380 to 420	°F
Front Temperature	390 to 430	°F
Nozzle Temperature	395 to 435	°F
Processing (Melt) Temp	380 to 435	°F
Mold Temperature	100 to 200	°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.