

HiFill® TPU 1209PA UV Black

 Techmer Polymer Modifiers - *Polyurethane*
General Information
General

Material Status	<ul style="list-style-type: none"> Commercial: Active
Availability	<ul style="list-style-type: none"> North America
Additive	<ul style="list-style-type: none"> UV Stabilizer
Features	<ul style="list-style-type: none"> UV Stabilized
Appearance	<ul style="list-style-type: none"> Black
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.05		ASTM D792
Moisture (284°F)	0.11	%	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	67		ASTM D2240

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	170	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	380 to 410	°F
Middle Temperature	390 to 420	°F
Front Temperature	400 to 430	°F
Nozzle Temperature	405 to 435	°F
Processing (Melt) Temp	390 to 430	°F
Mold Temperature	50 to 75	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow-Moderate	

