Wednesday, May 13, 2026

# HiFill® PEI 1000 Black

## Techmer Polymer Modifiers - *Polyetherimide*

Units SI

**Action** **Legend (Open)**

## General Information

| General | |
|---|---|
| Material Status | • Commercial: Active |
| Availability | • North America |
| Appearance | • Black |
| Processing Method | • Injection Molding |

## Properties [1]

| Physical | Nominal Value | Unit | Test Method |
|---|---|---|---|
| Density / Specific Gravity | 1.28 | g/cm³ | ASTM D792 |
| Melt Mass-Flow Rate (MFR) (337°C/6.6 kg) | 7.6 | g/10 min | ASTM D1238 |
| Moisture (150°C) | 0.060 | % | |
| **Mechanical** | **Nominal Value** | **Unit** | **Test Method** |
| Tensile Strength (Yield) | 110 | MPa | ASTM D638 |
| **Impact** | **Nominal Value** | **Unit** | **Test Method** |
| Notched Izod Impact (3.18 mm) | 44 | J/m | ASTM D256 |

## Processing Information

| Injection | Nominal Value | Unit |
|---|---|---|
| Drying Temperature | 135 | °C |
| Drying Time | 2.0 to 4.0 | hr |
| Rear Temperature | 343 to 377 | °C |
| Middle Temperature | 349 to 382 | °C |
| Front Temperature | 354 to 360 | °C |
| Nozzle Temperature | 360 to 391 | °C |
| Processing (Melt) Temp | 349 to 388 | °C |
| Mold Temperature | 121 to 163 | °C |
| Injection Rate | Slow | |
| Back Pressure | 0.00 to 0.345 | MPa |
| Screw Speed | Moderate | |

## Notes

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

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