Wednesday, May 13, 2026

HiFill® TPEL 6356 GF25 NAT

Techmer Polymer Modifiers - *Thermoplastic Elastomer*

Units SI

Action **Legend (Open)**

General Information

General	
Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 25% Filler by Weight
Processing Method	• Injection Molding

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.41	g/cm³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	1.2 to 1.5	%	ASTM D955
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	3720	MPa	ASTM D638
Tensile Strength (Yield)	68.9	MPa	ASTM D638
Tensile Strength (Break)	65.5	MPa	ASTM D638
Tensile Elongation (Break)	8.0	%	ASTM D638
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (3.18 mm)	210	J/m	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	82	°C
Drying Time	2.0 to 3.0	hr
Rear Temperature	227 to 243	°C
Middle Temperature	232 to 249	°C
Front Temperature	238 to 260	°C
Nozzle Temperature	241 to 263	°C
Processing (Melt) Temp	232 to 260	°C
Mold Temperature	38 to 66	°C
Injection Rate	Slow	
Back Pressure	0.00 to 0.345	MPa
Screw Speed	Slow-Moderate	

Notes

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

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