

HiFill® PEI BK

Polyether Imide

Techmer Engineered Solutions

Message:

HiFill® PEI BK is a Polyether Imide (PEI) product. It can be processed by injection molding and is available in North America.

General Information			
Appearance	Black		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.27	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.60	%	ASTM D955
Water Absorption (24 hr)	0.25	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	109		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	110	MPa	ASTM D638
Tensile Elongation (Break)	7.0	%	ASTM D638
Flexural Modulus	3520	MPa	ASTM D790
Flexural Strength	172	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	53	J/m	ASTM D256
Unnotched Izod Impact (3.18 mm)	1300	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	214	°C	
1.8 MPa, Unannealed	198	°C	
CLTE - Flow	5.4E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+16	ohms · cm	ASTM D257
Dielectric Strength ¹	20	kV/mm	ASTM D149
Injection	Nominal Value	Unit	
Drying Temperature	141	°C	
Drying Time	3.0	hr	
Rear Temperature	357 to 391	°C	
Middle Temperature	357 to 391	°C	
Front Temperature	357 to 391	°C	
Processing (Melt) Temp	354 to 388	°C	
Mold Temperature	135 to 163	°C	

Back Pressure	0.345 to 0.689	MPa
Screw Speed	50 to 100	rpm

NOTE

1. Method A (Short-Time)

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Recommended distributors for this material

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