HiFill® PBT/ASA GF10 BK

Techmer Polymer Modifiers - *Polybutylene Terephthalate*

General		
Material Status	• Commercial: Active	
Availability	• North America	
Filler / Reinforcement	• Glass Fiber, 10% Filler by Weight	
Features	• Foamable	
Appearance	• Colors Available	• Natural Color
Forms	• Pellets	
Processing Method	• Injection Molding	

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.35		ASTM D792
Molding Shrinkage - Flow (0.125 in)	5.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.12	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength	12500	psi	ASTM D638
Tensile Strength (Yield)	7500	psi	ASTM D638
Tensile Elongation (Break)	5.5	%	ASTM D638
Flexural Modulus	699000	psi	ASTM D790
Flexural Strength	22500	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact	1.2	ft·lb/in	ASTM D256
Unnotched Izod Impact	7.5	ft·lb/in	ASTM D4812
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	112		ASTM D785
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (66 psi, Unannealed)	• 400 • 199	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	• 375 • 374	°F	ASTM D648
CLTE - Flow	1.6E-5	in/in/°F	ASTM D696
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	1.0E+16	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	450	V/mil	ASTM D149
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (0.06 in)	HB		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	4.0	hr
Rear Temperature	450 to 525	°F
Middle Temperature	450 to 525	°F
Front Temperature	450 to 525	°F
Processing (Melt) Temp	450 to 475	°F
Mold Temperature	150 to 180	°F
Back Pressure	50.0 to 100	psi
Screw Speed	30 to 60	rpm