

## HiFill® PBT/SAN GF30 BK

Techmer Polymer Modifiers - *Polybutylene Terephthalate + SAN*

### General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight
Appearance	• Black
Processing Method	• Injection Molding

### Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.46		ASTM D792
Molding Shrinkage - Flow (0.125 in)	9.0E-3 to 0.011	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.40E+6	psi	ASTM D638
Tensile Strength (Yield)	16000	psi	ASTM D638
Tensile Strength (Break)	15500	psi	ASTM D638
Tensile Elongation (Break)	2.2	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.80	ft·lb/in	ASTM D256

### Processing Information

Injection	Nominal Value	Unit
Drying Temperature	160	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	450 to 480	°F
Middle Temperature	460 to 490	°F
Front Temperature	470 to 500	°F
Nozzle Temperature	480 to 510	°F
Processing (Melt) Temp	460 to 510	°F
Mold Temperature	125 to 200	°F
Injection Rate	Slow	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

