

HiFill® PBS WF230

 Techmer Polymer Modifiers - *Polybutylene Succinate*
General Information
Product Description

PBIO116289

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Wood Flour, 30% Filler by Weight
Features	• Biodegradable
Appearance	• Brown
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.29		ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	14	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	285000	psi	ASTM D638
Tensile Strength (Yield)	5600	psi	ASTM D638
Tensile Strength (Break)	5100	psi	ASTM D638
Tensile Elongation (Break)	4.2	%	ASTM D638
Flexural Modulus	295000	psi	ASTM D790
Flexural Strength	8200	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	0.70	ft·lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	226	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	196	°F	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	> 1.0E+14	ohms·cm	ASTM D257

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	130	°F
Drying Time	1.0 to 2.0	hr
Suggested Max Moisture	0.050	%
Rear Temperature	340 to 380	°F
Middle Temperature	350 to 390	°F
Front Temperature	360 to 400	°F
Nozzle Temperature	360 to 400	°F
Processing (Melt) Temp	350 to 395	°F
Mold Temperature	50 to 125	°F
Back Pressure ²	50.0 to 100	psi

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

² Minimize to maintain fiber integrity
