

**HiFill® PBS BF30**

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

PBIO116287

**General**

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

**Properties <sup>1</sup>**

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.27		ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	22	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	770000	psi	ASTM D638
Tensile Strength (Yield)	5700	psi	ASTM D638
Tensile Strength (Break)	5200	psi	ASTM D638
Tensile Elongation (Break)	2.8	%	ASTM D638
Flexural Modulus	370000	psi	ASTM D790
Flexural Strength	8600	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	1.0	ft·lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	230	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	205	°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 <sup>2</sup>	50.0 to 100	psi

**Notes**
<sup>1</sup> Typical properties: these are not to be construed as specifications.

<sup>2</sup> Minimize to maintain fiber integrity
