

HiFill FR® PBT FR-DE BK

 Techmer Polymer Modifiers - *Polybutylene Terephthalate*
General Information
General

Material Status	<ul style="list-style-type: none"> Commercial: Active
Availability	<ul style="list-style-type: none"> North America
Additive	<ul style="list-style-type: none"> Flame Retardant
Features	<ul style="list-style-type: none"> Flame Retardant
Appearance	<ul style="list-style-type: none"> Black
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.26		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	310000	psi	ASTM D638
Tensile Strength (Yield)	6200	psi	ASTM D638
Tensile Elongation (Break)	10	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.4	ft·lb/in	ASTM D256
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.12 in)	V-0		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	220	°F
Drying Time	4.0	hr
Rear Temperature	450 to 490	°F
Middle Temperature	460 to 500	°F
Front Temperature	480 to 520	°F
Nozzle Temperature	480 to 520	°F
Processing (Melt) Temp	480 to 520	°F
Mold Temperature	140	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 100	psi
Screw Speed	Slow	

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