

HiFill® PBT 2225 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"> Impact Modifier
Features	<ul style="list-style-type: none"> Impact Modified
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	1.20		ASTM D792
Molding Shrinkage - Flow (0.125 in)	8.0E-3 to 0.11	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	220000	psi	ASTM D638
Tensile Strength (Yield)	4700	psi	ASTM D638
Tensile Strength (Break)	3900	psi	ASTM D638
Tensile Elongation (Break)	55	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	3.2	ft-lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	72		ASTM D2240

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	450 to 490	°F
Middle Temperature	460 to 500	°F
Front Temperature	470 to 510	°F
Nozzle Temperature	480 to 520	°F
Processing (Melt) Temp	465 to 525	°F
Mold Temperature	150 to 225	°F
Injection Rate	Moderate-Fast	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Moderate	

