

HiFill® PBT 1226 GY236

 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
Appearance	<ul style="list-style-type: none"> Grey
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.32		ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	25 to 35	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	7.0E-3 to 9.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	370000	psi	ASTM D638
Tensile Strength (Yield)	8200	psi	ASTM D638
Tensile Strength (Break)	7500	psi	ASTM D638
Tensile Elongation (Break)	32	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.90	ft-lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	460 to 490	°F
Middle Temperature	470 to 500	°F
Front Temperature	480 to 510	°F
Nozzle Temperature	485 to 515	°F
Processing (Melt) Temp	465 to 520	°F
Mold Temperature	125 to 200	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow	

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