

HiFill® PBT 2210 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 | 1.24 | | ASTM D792 |
| Molding Shrinkage - Flow (0.125 in) | 5.0E-3 to 0.015 | in/in | ASTM D955 |
| Mechanical | Nominal Value | Unit | Test Method |
| Tensile Modulus | 250000 | psi | ASTM D638 |
| Tensile Strength (Yield) | 5800 | psi | ASTM D638 |
| Tensile Elongation (Break) | 25 | % | ASTM D638 |
| Impact | Nominal Value | Unit | Test Method |
| Notched Izod Impact (0.125 in) | 1.8 | ft·lb/in | ASTM D256 |

Processing Information

| Injection | Nominal Value | Unit |
|------------------------|----------------------|-------------|
| Drying Temperature | 250 | °F |
| Drying Time | 3.0 to 4.0 | 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 | 470 to 520 | °F |
| Injection Rate | Moderate-Fast | |
| Back Pressure | 0.00 to 100 | psi |
| Screw Speed | Fast | |

