

HiFill® PBT 0270 B3

 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
Features	<ul style="list-style-type: none"> High Specific Gravity
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	2.65		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.10E+6	psi	ASTM D638
Tensile Strength (Yield)	7100	psi	ASTM D638
Tensile Strength (Break)	7500	psi	ASTM D638
Tensile Elongation (Break)	1.3	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.61	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
Mold Temperature	100 to 200	°F
Injection Rate	Moderate-Fast	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Moderate-Fast	

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