

HiFill FR® PBT GF30 FR UV BK

 Techmer Polymer Modifiers - *Polybutylene Terephthalate*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight
Additive	• Flame Retardant
Features	• Flame Retardant • UV Resistant
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.68		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	16600	psi	ASTM D638
Tensile Elongation (Break)	2.4	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.5	ft·lb/in	ASTM D256
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	V-0		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	460 to 500	°F
Middle Temperature	470 to 510	°F
Front Temperature	480 to 520	°F
Nozzle Temperature	485 to 525	°F
Processing (Melt) Temp	465 to 525	°F
Mold Temperature	125 to 175	°F
Injection Rate	Slow	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

