

HiFill® E-I PBTUD 1700 BL339 BLUE

 Techmer Polymer Modifiers - *Polybutylene Terephthalate*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Appearance	• Blue
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.55		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	460000	psi	ASTM D638
Tensile Strength (Yield)	7200	psi	ASTM D638
Tensile Elongation (Break)	15	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.60	ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	2.0 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	460 to 525	°F
Mold Temperature	150 to 250	°F
Injection Rate	Moderate	
Back Pressure	0.00 to 100	psi
Screw Speed	Moderate	

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