

HiFill® PBT 1225 A NAT

 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"> Natural Color
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.30		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	8000	psi	ASTM D638
Tensile Elongation (Break)	> 80	%	ASTM D638
Flexural Strength	330000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	2.0	ft·lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	140	°F	ISO 75-2/A

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	4.0	hr
Rear Temperature	360 to 410	°F
Middle Temperature	435 to 480	°F
Front Temperature	445 to 490	°F
Nozzle Temperature	445 to 480	°F
Processing (Melt) Temp	450 to 490	°F
Mold Temperature	120 to 180	°F
Injection Rate	Moderate-Fast	
Back Pressure	0.00 to 200	psi
Screw Speed	Moderate-Fast	

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