

HiFill® PBT GF15

 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
Filler / Reinforcement	<ul style="list-style-type: none"> Glass Fiber, 15% Filler by Weight
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.42		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	13700	psi	ASTM D638
Tensile Elongation (Break)	4.5	%	ASTM D638

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	220	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	450 to 480	°F
Middle Temperature	460 to 490	°F
Front Temperature	470 to 500	°F
Nozzle Temperature	480 to 510	°F
Processing (Melt) Temp	460 to 510	°F
Mold Temperature	125 to 200	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow	

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