

HiFill® PBT VX Lt Prpl 17009127

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

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.31		ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/5.0 kg)	49	g/10 min	ASTM D1238
Moisture (284°F)	0.060	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	7800	psi	ASTM D638

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°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 515	°F
Mold Temperature	125 to 200	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow	

