

HiFill® PBT GF15 HR NAT

 Techmer Polymer Modifiers - *Polybutylene Terephthalate*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 15% Filler by Weight
Appearance	• Natural Color
Processing Method	• Injection Molding

Properties ¹

Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	11800	psi	ASTM D638
Tensile Elongation (Break)	6.8	%	ASTM D638
Flexural Strength	18800	psi	ASTM D790
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	407	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	347	°F	ASTM D648

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	

Notes

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

