

**HiFill® PBT VX Dk Blue 17011327**

 Techmer Polymer Modifiers - *Polybutylene Terephthalate*
**General Information**
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Material Status	• Commercial: Active
Availability	• North America
Appearance	• Blue
Processing Method	• Injection Molding

**Properties <sup>1</sup>**

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.30		ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/5.0 kg)	• 51 • 45	g/10 min	ASTM D1238
Moisture (284°F)	0.10	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	8100	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	

