

HiFill® PET GF30 FR 2000 NAT

 Techmer Polymer Modifiers - *Polyethylene Terephthalate*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber
Additive	• Flame Retardant
Features	• Flame Retardant
Appearance	• Colors Available
Processing Method	• Injection Molding

Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.67		ASTM D792
Molding Shrinkage - Flow (0.125 in)	3.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.050	%	ASTM D570
Mechanical			
Tensile Strength (Break)	18000	psi	ASTM D638
Tensile Elongation (Break)	2.0	%	ASTM D638
Flexural Modulus	1.40E+6	psi	ASTM D790
Flexural Strength	30000	psi	ASTM D790
Impact			
Notched Izod Impact (73°F, 0.125 in)	1.6	ft-lb/in	ASTM D256
Hardness			
Rockwell Hardness (R-Scale)	120		ASTM D785
Thermal			
Deflection Temperature Under Load (66 psi, Unannealed)	465	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	428	°F	ASTM D648
CLTE - Flow	1.3E-5	in/in/°F	ASTM D696
Electrical			
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Flammability			
Flame Rating (0.03 in)	• V-0 • 5VA		UL 94

Processing Information

	Nominal Value	Unit
Injection		
Drying Temperature	250	°F
Drying Time	4.0	hr
Rear Temperature	520 to 550	°F
Middle Temperature	520 to 550	°F
Front Temperature	520 to 550	°F
Processing (Melt) Temp	525	°F
Mold Temperature	200 to 230	°F
Back Pressure	50.0 to 100	psi
Screw Speed	30 to 60	rpm

