

HiFill® PET GF20 UV BK

Techmer Polymer Modifiers - *Polyethylene Terephthalate*

General Information

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight
Additive	• UV Stabilizer
Appearance	• Black
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.45		ASTM D792
Molding Shrinkage - Flow (0.125 in)	5.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.050	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	16500	psi	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	1.00E+6	psi	ASTM D790
Flexural Strength	22000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	1.7	ft-lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	112		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	475	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	435	°F	ASTM D648
CLTE - Flow	5.1E-5	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	500	V/mil	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		UL 94

Processing Information

Injection	Nominal Value	Unit
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

