

HiFill® PET GF30

 Techmer Polymer Modifiers - *Polyethylene Terephthalate*
General Information
General

Material Status	<ul style="list-style-type: none"> Commercial: Active
Availability	<ul style="list-style-type: none"> North America
Filler / Reinforcement	<ul style="list-style-type: none"> Glass Fiber
Appearance	<ul style="list-style-type: none"> Colors Available
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.56		ASTM D792
Molding Shrinkage - Flow (0.125 in)	3.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.050	%	ASTM D570
Mechanical			
	Nominal Value	Unit	Test Method
Tensile Strength (Break)	22500	psi	ASTM D638
Tensile Elongation (Break)	2.5	%	ASTM D638
Flexural Modulus	1.30E+6	psi	ASTM D790
Flexural Strength	34000	psi	ASTM D790
Impact			
	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	1.9	ft·lb/in	ASTM D256
Unnotched Izod Impact (73°F, 0.125 in)	18	ft·lb/in	ASTM D4812
Thermal			
	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	470	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	430	°F	ASTM D648
Melting Temperature	472	°F	
CLTE - Flow	6.0E-6	in/in/°F	ASTM D696
Flammability			
	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	HB		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

