

**HiFill® PET GF55 X NAT**

 Techmer Polymer Modifiers - *Polyethylene Terephthalate*
**General Information**
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Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 55% Filler by Weight
Appearance	• Natural Color
Processing Method	• Injection Molding

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

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.78		ASTM D792
Melt Mass-Flow Rate (MFR) (280°C/5.0 kg)	49	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2.47E+6	psi	ASTM D638
Tensile Strength (Yield)	19400	psi	ASTM D638
Tensile Strength (Break)	19400	psi	ASTM D638
Tensile Elongation (Break)	1.8	%	ASTM D638
Flexural Modulus	2.38E+6	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.8	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	414	°F	ASTM D648

**Processing Information**

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	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 510	°F
Mold Temperature	125 to 200	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow	

