

HiFill® PET GF15 IM

 Techmer Polymer Modifiers - *Polyethylene Terephthalate*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 15% Filler by Weight
Additive	• Impact Modifier
Features	• Impact Modified
Appearance	• Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.39		ASTM D792
Molding Shrinkage - Flow (0.125 in)	5.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.24	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	11000	psi	ASTM D638
Tensile Elongation (Break)	6.0	%	ASTM D638
Flexural Modulus	525000	psi	ASTM D790
Flexural Strength (Yield)	14000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	2.5	ft·lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	110		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	450	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	400	°F	ASTM D648
CLTE - Flow	5.1E-5	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+13	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	420	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

