

# HiFill® PET GF/M35

Polyethylene Terephthalate

Techmer Engineered Solutions

## Message:

HiFill® PET GF/M35 is a Polyethylene Terephthalate (PET) product filled with 35% glass\mineral. It can be processed by injection molding and is available in North America.

General Information			
Filler / Reinforcement	Glass\Mineral,35% Filler by Weight		
Appearance	Colors Available		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.59	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.40	%	ASTM D955
Water Absorption (24 hr)	0.050	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	119		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	91.0	MPa	ASTM D638
Tensile Elongation (Break)	2.5	%	ASTM D638
Flexural Modulus	9650	MPa	ASTM D790
Flexural Strength	170	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	69	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	216	°C	ASTM D648
Melting Temperature	254	°C	
CLTE - Flow	2.7E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+16	ohms · cm	ASTM D257
Dielectric Strength <sup>1</sup>	21	kV/mm	ASTM D149
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	4.0	hr	
Rear Temperature	271 to 288	°C	
Middle Temperature	271 to 288	°C	
Front Temperature	271 to 288	°C	
Processing (Melt) Temp	274	°C	
Mold Temperature	93.3 to 110	°C	

Back Pressure	0.345 to 0.689	MPa
Screw Speed	30 to 60	rpm
NOTE		

- Method A (Short-Time)

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#### Recommended distributors for this material

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