

Product Texts

Injection Molding, Unreinforced, UV Stabilized, Improved Impact, Low Warpage

ISO 1043 (PBT+PC)-I

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
^[C] Melt volume-flow rate, MVR	35	cm ³ /10min	ISO 1133
Temperature	270	°C	-
Load	5	kg	-
^[C] Molding shrinkage, parallel	1.2	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	1.2	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	2100	MPa	ISO 527
^[C] Yield stress	50	MPa	ISO 527
^[C] Yield strain	3.8	%	ISO 527
^[C] Charpy impact strength, +23°C	N	kJ/m ²	ISO 179/1eU
^[C] Charpy impact strength, -30°C	N	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	60	kJ/m ²	ISO 179/1eA
^[C] Charpy notched impact strength, -30°C	19	kJ/m ²	ISO 179/1eA

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
ISO Data			
^[C] Melting temperature, 10°C/min	225	°C	ISO 11357-1/-3
^[C] Temp. of deflection under load, 1.80 MPa	70	°C	ISO 75-1/-2
^[C] Temp. of deflection under load, 0.45 MPa	105	°C	ISO 75-1/-2
^[C] Coeff. of linear therm. expansion, parallel	110	E-6/K	ISO 11359-1/-2
^[C] Coeff. of linear therm. expansion, normal	110	E-6/K	ISO 11359-1/-2
^[C] Burning Behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.5	mm	-

[C]: CAMPUS

Electrical properties	Value	Unit	Test Standard
ISO Data			
^[C] Comparative tracking index	600	-	IEC 60112

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
^[C] Density	1210	kg/m ³	ISO 1183

[C]: CAMPUS

Test specimen production	Value	Unit	Test Standard
ISO Data			
^[C] Injection Molding, melt temperature	250	°C	ISO 294
Injection Molding, mold temperature	70	°C	ISO 294

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	120	°C	-
Pre-drying - Time	4 - 8	h	-
Processing humidity	≤0.02	%	-
Melt temperature	250 - 265	°C	-
Mold temperature	60 - 90	°C	-

Characteristics

Processing

Injection Molding

Delivery form

Pellets

Special Characteristics

High impact or impact modified, U.V. stabilized or stable to weather, Heat stabilized or stable to heat

Features

Low Warpage

Regional Availability

North America, Europe, Asia Pacific, South and Central America, Near East/Africa

Other text information

Injection molding

PREPROCESSING

Residual moisture content: 0.00 - 0.02 %

Drying temperature circulating air dryer: 120 °C

Drying time circulating air dryer: 4 - 8 h

PROCESSING

Melt temperature (Tmin - Tmax): 250 - 265 °C

Mold temperature: 60 - 90 °C