

NOVADURAN 5710G20S1

PBT-GF20

Mitsubishi Engineering-Plastics Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	50	cm ³ /10min	ISO 1133
Temperature	250	°C	-
Load	5	kg	-
Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577
Molding shrinkage, normal	1.1	%	ISO 294-4, 2577
Mechanical properties			
ISO Data			
Stress at break	110	MPa	ISO 527
Strain at break	8	%	ISO 527
Flexural modulus, 23°C	7000	MPa	ISO 178
Flexural strength	170	MPa	ISO 178
Charpy notched impact strength, +23°C	8	kJ/m ²	ISO 179/1eA
Thermal properties			
ISO Data			
Melting temperature, 10°C/min	224	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	195	°C	ISO 75-1/-2
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Other properties			
Water absorption	0.07	%	Sim. to ISO 62
Density	1430	kg/m ³	ISO 1183
Processing Recommendation Injection Molding			
Pre-drying - Temperature	120	°C	-
Pre-drying - Time	5 - 8	h	-
Mold temperature	60 - 100	°C	-
Zone 1	250 - 270	°C	-
Zone 2	250 - 270	°C	-
Zone 3	250 - 270	°C	-
Nozzle temperature	270	°C	-
Screw speed	80 - 150	rpm	-
Injection pressure	20 - 150	MPa	-

Characteristics**Processing**

Injection Molding

Features

Low Warpage

Applications

Automotive, Electrical and Electronical, General Purpose

Regional Availability

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