

PRL TP-HG40

PBT-GF40

Polymer Resources, Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	30	g/10min	ASTM D 1238
Temperature	265	°C	-
Load	2.16	kg	-
Mold Shrinkage, MD	0.0035	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength at Yield	138	MPa	ASTM D 638
Tensile Strength at Break	138	MPa	ASTM D 638
Flexural Modulus	10340	MPa	ASTM D 790
Flexural Strength	165	MPa	ASTM D 790
Izod Impact notched, 1/8 in	80.1	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
DTUL @ 66 psi	216	°C	ASTM D 648
DTUL @ 264 psi	193	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	1640	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	116 - 121	°C	-
Pre-drying - Time	3 - 4	h	-
Melt temperature	232 - 260	°C	-
Mold temperature	71.1 - 87.8	°C	-
Zone 1	238 - 254	°C	-
Zone 2	243 - 260	°C	-
Zone 3	249 - 266	°C	-

Characteristics**Processing**

Injection Molding

Regional Availability

North America

Delivery form

Pellets