

Product Texts

Injection Molding, 20% Glass Reinforced, Improved Impact, Excellent Surface Properties, Low Warpage

ISO 1043 (PBT+PET)-I-GF20

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
^[C] Melt volume-flow rate, MVR	18	cm ³ /10min	ISO 1133
Temperature	270	°C	-
Load	5	kg	-
^[C] Molding shrinkage, parallel	0.4	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	0.7	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	5500	MPa	ISO 527
^[C] Stress at break	75	MPa	ISO 527
^[C] Strain at break	3	%	ISO 527
^[C] Charpy impact strength, +23°C	50	kJ/m ²	ISO 179/1eU
^[C] Charpy impact strength, -30°C	45	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	10	kJ/m ²	ISO 179/1eA
^[C] Charpy notched impact strength, -30°C	10	kJ/m ²	ISO 179/1eA

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
ISO Data			
^[C] Temp. of deflection under load, 1.80 MPa	155	°C	ISO 75-1/-2
^[C] Temp. of deflection under load, 0.45 MPa	215	°C	ISO 75-1/-2
^[C] Coeff. of linear therm. expansion, parallel	30	E-6/K	ISO 11359-1/-2
^[C] Coeff. of linear therm. expansion, normal	130	E-6/K	ISO 11359-1/-2

[C]: CAMPUS

Electrical properties	Value	Unit	Test Standard
ISO Data			
^[C] Comparative tracking index	200	-	IEC 60112

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
^[C] Density	1380	kg/m ³	ISO 1183

[C]: CAMPUS

Test specimen production	Value	Unit	Test Standard
ISO Data			
^[C] Injection Molding, melt temperature	270	°C	ISO 294
Injection Molding, mold temperature	90	°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	260 - 280	°C	-
Mold temperature	80 - 100	°C	-

Characteristics**Processing**

Injection Molding

Delivery form

Pellets

Special Characteristics

High impact or impact modified, 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): 260 - 280 °C

Mold temperature: 80 - 100 °C