

Product Texts

Injection Molding, 20% Glass Reinforced, Hydrolysis resistant, Laser Weldable, Laser Transparent Black

ISO 1043 PBT-GF20

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
^[C] Molding shrinkage, parallel	0.4	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	0.9	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	7400	MPa	ISO 527
^[C] Stress at break	120	MPa	ISO 527
^[C] Strain at break	2.7	%	ISO 527

[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	175	°C	ISO 75-1/-2
^[C] Temp. of deflection under load, 0.45 MPa	215	°C	ISO 75-1/-2

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
^[C] Density	1430	kg/m ³	ISO 1183

[C]: CAMPUS

Test specimen production	Value	Unit	Test Standard
ISO Data			
^[C] Injection Molding, melt temperature	260	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294

[C]: CAMPUS

Characteristics

Processing

Injection Molding

Delivery form

Pellets, Black

Features

Laser Transparent, Weldable

Chemical Resistance

Hydrolytically Stable

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 - 270 °C

Mold temperature: 70 - 100 °C