

Product Texts

PBT, 20 % glass fibres, injection moulding, impact modified

Processing/Physical Characteristics

	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	18	cm ³ /10min	ISO 1133
Temperature	260	°C	-
Load	5	kg	-

Mechanical properties

	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	6700	MPa	ISO 527
Stress at break	115	MPa	ISO 527
Strain at break	3.3	%	ISO 527
Charpy impact strength, +23°C	60	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	10	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	10	kJ/m ²	ISO 179/1eA

Thermal properties

	Value	Unit	Test Standard
ISO Data			
Melting temperature, 10°C/min	225	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	200	°C	ISO 75-1/-2
Burning behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.6	mm	-
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	0.8	mm	-
Oxygen index	20	%	ISO 4589-1/-2

Other properties

	Value	Unit	Test Standard
Water absorption	0.4	%	Sim. to ISO 62
Humidity absorption	0.1	%	Sim. to ISO 62
Density	1450	kg/m ³	ISO 1183

Test specimen production

	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	260	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294

Characteristics

Processing

Injection Molding

Delivery form

Pellets

Additives

Release agent

Special Characteristics

Heat stabilized or stable to heat

Regional Availability

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

Other text information

Injection Molding

PREPROCESSING

Max. Water content: 0.04 %

Drying temperature: 120 °C

Drying time:

Circulating air drying oven (50 % fresh air) 4-8 h

Fresh air dryer (high speed dryer) 2-3 h
Dry air dryer 2-3 h

PROCESSING

Melt temperature: 250 - 270 °C

Mold temperature: 80 - 100 °C