

Product Texts

Injection Molding, 30% Glass Reinforced, Flame Retardant

ISO 1043 PBT-GF30 FR(17)

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
^[C] Melt volume-flow rate, MVR	14	cm ³ /10min	ISO 1133
Temperature	260	°C	-
Load	2.16	kg	-
^[C] Molding shrinkage, parallel	0.4	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	1.1	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	11000	MPa	ISO 527
^[C] Stress at break	140	MPa	ISO 527
^[C] Strain at break	2.2	%	ISO 527
^[C] Tensile creep modulus, 1h	11000	MPa	ISO 899-1
^[C] Tensile creep modulus, 1000h	10000	MPa	ISO 899-1
^[C] Charpy impact strength, +23°C	50	kJ/m ²	ISO 179/1eU
^[C] Charpy impact strength, -30°C	50	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] Puncture - maximum force, +23°C	661	N	ISO 6603-2
^[C] Puncture energy, +23°C	2.3	J	ISO 6603-2

[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	205	°C	ISO 75-1/-2
^[C] Temp. of deflection under load, 0.45 MPa	220	°C	ISO 75-1/-2
^[C] Coeff. of linear therm. expansion, parallel	20	E-6/K	ISO 11359-1/-2
^[C] Coeff. of linear therm. expansion, normal	90	E-6/K	ISO 11359-1/-2
^[C] Burning Behav. at 1.5 mm nom. thickn.	V-0	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
^[C] Burning Behav. 5V at thickness h	5VA	class	IEC 60695-11-20
Thickness tested	1.5	mm	-
^[C] Oxygen index	32	%	ISO 4589-1/-2

[C]: CAMPUS

Electrical properties	Value	Unit	Test Standard
ISO Data			
^[C] Relative permittivity, 100Hz	4	-	IEC 62631-2-1
^[C] Relative permittivity, 1MHz	3.9	-	IEC 62631-2-1
^[C] Dissipation factor, 100Hz	50	E-4	IEC 62631-2-1
^[C] Dissipation factor, 1MHz	160	E-4	IEC 62631-2-1
^[C] Volume resistivity	>1E13	Ohm*m	IEC 62631-3-1
^[C] Surface resistivity	>1E15	Ohm	IEC 62631-3-2
^[C] Electric strength	29	kV/mm	IEC 60243-1
^[C] Comparative tracking index	175	-	IEC 60112

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
^[C] Water absorption	0.4	%	Sim. to ISO 62
^[C] Humidity absorption	0.1	%	Sim. to ISO 62

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PBT-GF30 FR(17)

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[C] Density	1630	kg/m ³	ISO 1183
[C]: CAMPUS			

Test specimen production	Value	Unit	Test Standard
ISO Data			
[C] Injection Molding, melt temperature	250	°C	ISO 294
Injection Molding, mold temperature	80	°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	240 - 260	°C	-
Mold temperature	80 - 100	°C	-

Characteristics**Processing**

Injection Molding

Special Characteristics

Flame retardant, Heat stabilized or stable to heat

Delivery form

Pellets

Regional Availability

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

Additives

Release agent

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): 240 - 260 °C

Mold temperature: 80 - 100 °C