

Product Texts

Injection Molding, Unreinforced, Flame Retardant (halogen free)

ISO 1043 PBT FR(40+30)

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
^[C] Melt volume-flow rate, MVR	55	cm ³ /10min	ISO 1133
Temperature	250	°C	-
Load	2.16	kg	-
^[C] Molding shrinkage, parallel	2.3	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	2.3	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	2300	MPa	ISO 527
^[C] Yield stress	55	MPa	ISO 527
^[C] Yield strain	8	%	ISO 527
^[C] Nominal strain at break	10	%	ISO 527
^[C] Charpy impact strength, +23°C	75	kJ/m ²	ISO 179/1eU

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
ISO Data			
^[C] Melting temperature, 10°C/min	224	°C	ISO 11357-1/-3
^[C] Temp. of deflection under load, 1.80 MPa	75	°C	ISO 75-1/-2
^[C] Temp. of deflection under load, 0.45 MPa	160	°C	ISO 75-1/-2
^[C] Coeff. of linear therm. expansion, parallel	120	E-6/K	ISO 11359-1/-2
^[C] Coeff. of linear therm. expansion, normal	120	E-6/K	ISO 11359-1/-2
^[C] Burning Behav. at 1.5 mm nom. thickn.	V-2	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
^[C] Oxygen index	28	%	ISO 4589-1/-2

[C]: CAMPUS

Electrical properties	Value	Unit	Test Standard
ISO Data			
^[C] Volume resistivity	>1E13	Ohm*m	IEC 62631-3-1
^[C] Surface resistivity	>1E15	Ohm	IEC 62631-3-2
^[C] Electric strength	30	kV/mm	IEC 60243-1
^[C] Comparative tracking index	600	-	IEC 60112

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
^[C] Density	1320	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, Halogen-free, Heat stabilized or stable to heat

Delivery form

Pellets

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): 240 - 260 °C

admissible residence time at Tmax: <5 min

Mold temperature: 80 - 100 °C