

Product Texts

PIBITER NRV230AE is a 30% glass-filled flame retardant PBT

Flammability @0.8mm nom. thickn. V-0

UL recognition (0.8)

Flammability at thickness h (0.75 mm) V-0

UL recognition (h)

Mechanical properties	Value	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	11000	MPa	ISO 527
^[C] Stress at break	120	MPa	ISO 527
^[C] Strain at break	2	%	ISO 527

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
ISO Data			
^[C] Temp. of deflection under load, 1.80 MPa	213	°C	ISO 75-1/-2
^[C] Burning Behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	0.8	mm	-
Yellow Card available	yes	-	-

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
^[C] Humidity absorption	0.15	%	Sim. to ISO 62
^[C] Density	1700	kg/m ³	ISO 1183

[C]: CAMPUS

Characteristics

Processing

Injection Molding

Special Characteristics

Flame retardant

Delivery form

Pellets

Other text information

Injection molding

To avoid hydrolytic degradation during processing, Pibiter resins have to be dried to a moisture level equal to or less than 0.02%.

Drying should be done in a dehumidifying hopper dryer capable of dewpoints <-30°F (-34°C) at 250°F (121°C) for 4 hours..

Rear Temperature 450-470(230-240) deg F (deg C)

Center Temperature 460-480(235-250) deg F (deg C)

Front Temperature 470-490(240-255) deg F (deg C)

Nozzle Temperature 480-490(250-255) deg F (deg C)

Melt Temperature 460-490(235-255) deg F (deg C)

Mold Temperature 150-200(65-93) deg F (deg C)

Back Pressure 0-50 psi

Screw Speed Medium

Injection Speed Fast

Injection speed, injection pressure and holding pressure have to be optimized to the individual article geometry. To avoid material degradation during processing low back pressure and minimum screw speed have to be used. Overheating of the material has to be avoided, in particular for flame retardant grades.