

PBT Compound Glass Filled 15% flame retardant | Colour: RAL 7035

Property	Method	Measurement condition	Unit	Values
Melt Flow Rate	ISO 1133	260 °C/5 Kg	g /10 min	55
Ash Content	Inhouse method	640 °C	%	15
Izod Impact Strength at 23 °C	ISO 180	notched	kJ/m ²	5
Izod Impact Strength at 23 °C	ISO 180	unnotched	kJ/m ²	34
Tensile Modulus	ISO 527-1	1 mm/min	MPa	6800
Tensile Strenght	ISO 527	10mm/min	Mpa	110
Flexural Modulus	ISO 178	2 mm/min	MPa	6500
Heat Deflection temperature	ISO 75A	A	oC	210
Flammability	UL-94	1,5	mm	V-0
Density	ISO 1183-1	method A	g/cm ³	1,52
Moldshrinkage	Inhouse method		%	0,4

Application data

Description	PBT Compound Glassfilled 15%
Application	Injection Moulding
Drying conditions	100 - 120 °C , 4 -6 hours moisture content < 0,04%
Moulding temperature - Nozzle	250 - 270 °C
Moulding temperature - Barrel	240 - 280 °C
Mold Temperature	60 - 100 °C
Compression ratio	2:1 - 2,5:1
Injection Pressure	Low to medium
Injection Speed	Fast ram speed
Hold Pressure	Low to medium
Screw speed	0,05 - 0,2 m/s
Cushion	4 - 6 mm
Back Pressure	0 - 1,0 MPa

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