

## Technical Data Sheet

### Schuladur A GF15 HF FR1 NATURAL



Polybutylene Terephthalate

#### Product Description

High flow flame retardent halogenated PBT standard grade reinforced with 15% glass fiber; without PBDE

<b>Processing Method</b>	Injection Molding
<b>Attribute</b>	Filled; Good Dimensional Stability; Halogenated; High Flow
<b>Additive</b>	Flame Retardant
<b>Filler/Reinforcement</b>	Glass Fiber, 15%
<b>Resin ID</b>	PBT GF15 FR(17)

Typical Properties	Nominal Value	Units	Test Method
<b>Physical</b>			
Melt Volume Flow Rate, (260 °C/5.0 kg)	50	cm <sup>3</sup> /10 min	ISO 1133
Density, (Method A)	1.52	g/cm <sup>3</sup>	ISO 1183
<b>Mechanical</b>			
Tensile Strain at Break, (Type 1A, 5 mm/min)	3.0	%	ISO 527-2
Tensile Stress at Break, (Type 1A, 5 mm/min)	110	MPa	ISO 527-2
Tensile Modulus, (1 mm/min, Type 1A)	6800	MPa	ISO 527-1
<b>Impact</b>			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	4.5	kJ/m <sup>2</sup>	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	4.0	kJ/m <sup>2</sup>	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	34	kJ/m <sup>2</sup>	ISO 179
(-30 °C, Type 1, Edgewise)	30	kJ/m <sup>2</sup>	ISO 179
<b>Thermal</b>			
Vicat Softening Temperature			
(B (50N), 50 °C/h)	201	°C	ISO 306
(A (10N), 50 °C/h)	217	°C	ISO 306
Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise)	211	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	180	°C	ISO 75-2/A
RTI Elec			
(1.5 mm)	75.0	°C	UL 746B
(3.0 mm)	75.0	°C	UL 746B
(0.75 mm)	75.0	°C	UL 746B

<b>RTI Imp</b>			
(1.5 mm)	75.0	°C	UL 746B
(3.0 mm)	75.0	°C	UL 746B
(0.75 mm)	75.0	°C	UL 746B
<b>RTI Str</b>			
(1.5 mm)	75.0	°C	UL 746B
(3.0 mm)	75.0	°C	UL 746B
(0.75 mm)	75.0	°C	UL 746B

<b>Electrical</b>			
Volume Resistivity	>1.0E+13	ohm*m	IEC 62631-3-1
Dielectric Strength, (in Oil, 1.00 mm, 23 °C, 2000 V/sec)	34	kV/mm	IEC 60243-1
Comparative Tracking Index (CTI)	225	V	IEC 60112
Surface Resistivity	>1.0E+15	ohm	IEC 60093

<b>Flammable</b>			
<b>Glow Wire Flammability Index</b>			
(0.75 mm)	960	°C	IEC 60695-2-12
(1.5 mm)	960	°C	IEC 60695-2-12
(3.0 mm)	960	°C	IEC 60695-2-12
<b>Glow Wire Ignition Temperature</b>			
(0.75 mm)	675	°C	IEC 60695-2-13
(1.5 mm)	675	°C	IEC 60695-2-13
(3.0 mm)	675	°C	IEC 60695-2-13
Oxygen Index	29	%	ISO 4589-2

<b>UL Information</b>			
<b>Flame Rating</b>			
(1.5 mm)	V-0		UL 94
(1.5 mm)	5VA		UL 94
(3.0 mm)	V-0		UL 94
(0.75 mm)	V-0		UL 94
<b>Flammability Classification</b>			
(0.75 mm)	V-0		IEC 60695-11-10, -20
(1.5 mm)	V-0		IEC 60695-11-10, -20
(1.5 mm)	5VA		IEC 60695-11-10, -20
(3.0 mm)	V-0		IEC 60695-11-10, -20

<b>Injection Parameters</b>	<b>Nominal Value</b>	<b>Units</b>
Drying Time	2.0 to 4.0	hr
Drying Temperature	120	°C
Suggested Max Moisture	0.02	%
Screw Speed	<250	mm/sec
Processing (Melt) Temp	250 to 260	°C
Injection Rate	Slow-Moderate	
Back Pressure	2.00 to 8.00	MPa
Mold Temperature	70 to 90	°C