Technical Data Sheet

Schuladur PCR GF15 K1947 KU BLK968094

Polybutylene Terephthalate + PET

Product Description

15% glass fibre reinforced PBT/PET compound based on mechanical recycled sourcing. Standard color is black, color matching for dark colors possible. Automotive structural applications are possible.According to ISO 14021:2016 Schuladur PCR GF15 K1947 is a compound containing 40% of recycled material.Recycled content according to DIN SPEC 91446:2021-12: R40Data Quality Level according to DIN SPEC 91446:2021-12: DQL4Data Quality Level according to VDA 284: DQL Automotive

Processing Method	Injection Molding
Filler/Reinforcement	Glass Fiber, 15%

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Volume Flow Rate, (260 °C/2.16 kg)	18	cm³/10 min	ISO 1133
Density, (Method A)	1.43	g/cm³	ISO 1183
Apparent (Bulk) Density	0.60 to 0.80	g/cm³	ISO 60
Mechanical			
Tensile Strain at Break, (Type 1A, 5 mm/min)	2.4	%	ISO 527-2
Tensile Stress at Break, (Type 1A, 5 mm/min)	112	MPa	ISO 527-2
Tensile Modulus, (1 mm/min, Type 1A)	6700	MPa	ISO 527-1
Impact			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	5.0	kJ/m²	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	4.0	kJ/m²	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	25	kJ/m²	ISO 179
(-30 °C, Type 1, Edgewise)	18	kJ/m²	ISO 179
Thermal			
Vicat Softening Temperature			
(B (50N), 50 °C/h)	194	°C	ISO 306
(A (10N), 120 °C/h)	215	°C	ISO 306
Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise)	213	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	186	°C	ISO 75-2/A
Electrical			
Volume Resistivity	>1.0E+13	ohm*m	IEC 62631-3-1
Surface Resistivity	>1.0E+15	ohm	IEC 60093

Injection Parameters	Nominal Value	Units
Drying Time	4.0 to 6.0	hr
Drying Temperature	120	°C
Suggested Max Moisture	0.02	%
Processing (Melt) Temp	260 to 280	°C
Mold Temperature	80 to 110	°C