

## Technical Data Sheet

### Schuladur PCR GF20 K206 8BLK968001



Polybutylene Terephthalate + PET

#### Product Description

20% 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 GF20 is a compound containing 35% of recycled material. Recycled content according to DIN SPEC 91446:2021-12: R35 Data Quality Level according to DIN SPEC 91446:2021-12: DQL4 Data Quality Level according to VDA 284: DQL Automotive

<b>Processing Method</b>	Injection Molding
<b>Filler/Reinforcement</b>	Glass Fiber, 20%
<b>Resin ID</b>	(PBT+PET)-GF20

Typical Properties	Nominal Value	Units	Test Method
<b>Physical</b>			
Melt Volume Flow Rate, (260 °C/2.16 kg)	20	cm <sup>3</sup> /10 min	ISO 1133
Density, (Method A)	1.47	g/cm <sup>3</sup>	ISO 1183
Apparent (Bulk) Density	0.60 to 0.80	g/cm <sup>3</sup>	ISO 60
<b>Mechanical</b>			
Tensile Strain at Break, (Type 1A, 5 mm/min)	2.5	%	ISO 527-2
Tensile Stress at Break, (Type 1A, 5 mm/min)	120	MPa	ISO 527-2
Tensile Modulus, (1 mm/min, Type 1A)	7600	MPa	ISO 527-1
<b>Impact</b>			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	6.0	kJ/m <sup>2</sup>	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	5.0	kJ/m <sup>2</sup>	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	30	kJ/m <sup>2</sup>	ISO 179
(-30 °C, Type 1, Edgewise)	28	kJ/m <sup>2</sup>	ISO 179
<b>Hardness</b>			
Ball Pressure Test, (200 °C)	Pass		IEC 60695-10-2
<b>Thermal</b>			
Vicat Softening Temperature			
(B (50N), 50 °C/h)	190	°C	ISO 306
(A (10N), 50 °C/h)	215	°C	ISO 306
Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise)	215	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	190	°C	ISO 75-2/A
<b>Electrical</b>			

Volume Resistivity	>1.0E+13	ohm*m	IEC 62631-3-1
Surface Resistivity	>1.0E+15	ohm	IEC 60093

**Flammable**

Burning Rate			
(2.00 mm)	30	mm/min	ISO 3795
(2.00 mm)	30	mm/min	FMVSS 302
Glow Wire Flammability Index, (2.0 mm)	650	°C	IEC 60695-2-12

**Additional Information**

Water Absorption 23C/50RH	0.3	%	ISO 62
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**UL Information**

Flammability Classification			
(0.75 mm)	HB		IEC 60695-11-10, -20
(1.5 mm)	HB		IEC 60695-11-10, -20
(3.0 mm)	HB		IEC 60695-11-10, -20

<b>Injection Parameters</b>	<b>Nominal Value</b>	<b>Units</b>
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