

PRL TP-G20**Polymer Resources Ltd. - Polybutylene Terephthalate**Units **Action****Legend (Open)****General Information****General**

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight
Features	• High Heat Resistance
RoHS Compliance	• RoHS Compliant
Forms	• Pellets
Processing Method	• Injection Molding

ASTM & ISO Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.43		ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	8.0 to 20	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	6.0E-3 to 9.0E-3	in/in	ASTM D955
Mechanical			
Tensile Strength (Yield, 0.125 in)	16000	psi	ASTM D638
Tensile Strength (Break, 0.125 in)	16000	psi	ASTM D638
Flexural Modulus (0.125 in)	850000	psi	ASTM D790
Flexural Strength (Break, 0.125 in)	24000	psi	ASTM D790
Impact			
Notched Izod Impact (73°F, 0.125 in)	1.0	ft-lb/in	ASTM D256
Thermal			
Deflection Temperature Under Load (66 psi, Unannealed, 0.125 in)	405	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed, 0.125 in)	385	°F	ASTM D648

Processing Information

	Nominal Value	Unit
Injection		
Drying Temperature	240 to 250	°F
Drying Time	3.0 to 4.0	hr
Drying Time, Maximum	8.0	hr
Rear Temperature	460 to 490	°F
Middle Temperature	470 to 500	°F
Front Temperature	480 to 510	°F
Processing (Melt) Temp	450 to 500	°F
Mold Temperature	160 to 190	°F

Notes

¹ Typical properties: these are not to be construed as specifications.

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