

PRECITE® PRELIMINARY

V GF 30 2 natural (7722)

PBT-ASA- GF 30

PRECITE V GF 30 2 natural (7722) is a 30% glass fibre reinforced, UV-stabilised PBT/ASA blend with low warpage, good surface finish and lower density compared to neat PBT.

Features

UV-stabilised low warpage reduced density

Properties

Modulus

9.800 MPa

Strength

140 MPa

Impact

60 kJ/m²

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

9800 MPa

Tensile stress at break

ISO 527-2

5 mm/min | d.a.m.

140 MPa

Tensile strain at break

ISO 527-2

5 mm/min | d.a.m.

2,5 %

Charpy impact strength

ISO 179-1/1eU

23°C | d.a.m.

60 kJ/m²

Charpy notched impact strength

ISO 179-1/1eA

23°C | d.a.m.

10 kJ/m²

Thermal Properties

Temperature of deflection under load HDT/A

ISO 75

1,8 MPa

190 °C

Melting temperature

ISO 11357-3

DSC, 10K/min

225 °C

Flammability

Flammability UL 94	0,8 mm Wall thickness	HB Class
Burning rate (<100 mm/min) FMVSS 302	> 1 mm Thickness	+

General Properties

Density ISO 1183	23°C	1,43 g/cm³
Molding shrinkage ISO 294-4	flow transverse	0,2 - 0,4 % 0,5 - 0,7 %

Electrical Properties

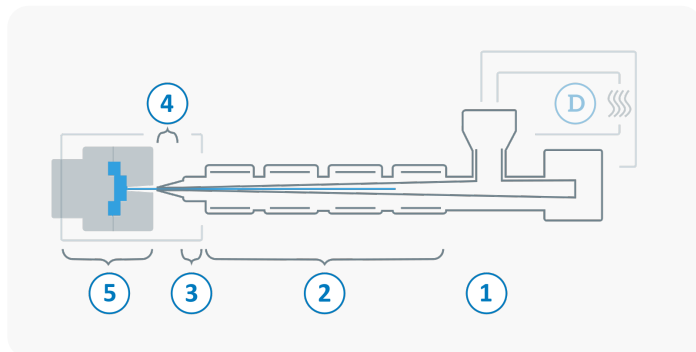
Volume resistivity IEC 62631-3-1	d.a.m.	> 10¹³ Ω x cm
Surface resistivity IEC 62631-3-2	d.a.m.	10¹² Ω

Rheological Properties

MVR ISO 1133	250°C/2,16kg	6 cm³/10 min
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Processing

The values mentioned are recommendations. We only recommend desiccant / dry air dryers or vacuum dryers. Too long a drying time and the resulting residual moisture content below the lower limit can lead to filling problems and surface defects. The specified drying time refers to closed and undamaged bagged material. When processing from previously opened bags or from octabins with polyolefin inliners, a longer drying time may be necessary. It is recommended to check the residual moisture content after the drying process.



D	Drying time	3 - 4 h
	Drying temperature ($\tau \leq -30^{\circ}\text{C}$)	100 - 120 $^{\circ}\text{C}$
	Processing moisture	0,02 - 0,04 %
1	Feed section	60 - 80 $^{\circ}\text{C}$
2	Temperature Zone 1 - Zone 4	250 - 275 $^{\circ}\text{C}$
3	Nozzle temperature	250 - 280 $^{\circ}\text{C}$
4	Melt temperature	260 - 275 $^{\circ}\text{C}$
5	Mold temperature	80 - 100 $^{\circ}\text{C}$
→	Holding pressure, spec.	300 - 800 bar
←	Back pressure, spec.	30 - 100 bar
	Injection speed	medium to high
	Screw speed	8 - 15 m/min