

Pocan® B1204 000000
PBT

Envalior

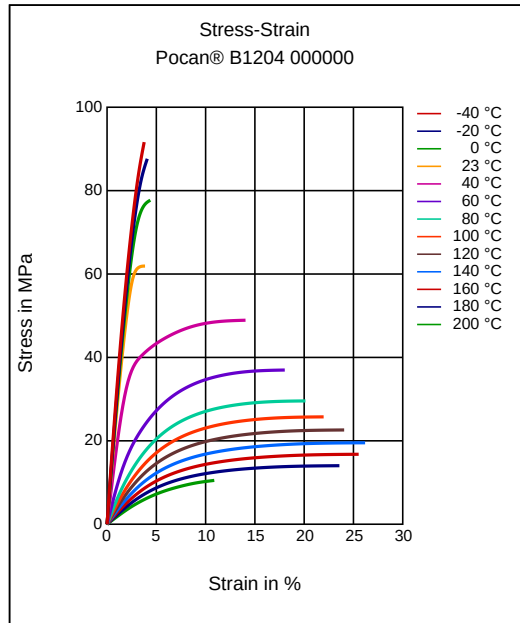
Injection Molding, Unreinforced, Excellent Surface Properties

ISO 1043 PBT

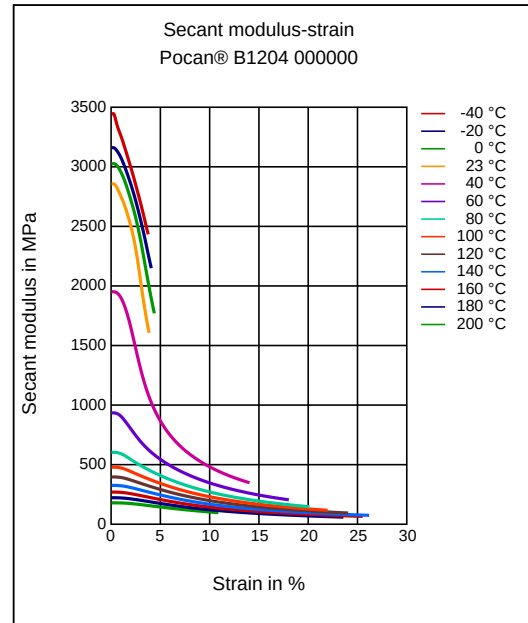
Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	60	cm ³ /10min	ISO 1133
Temperature	260	°C	-
Load	2.16	kg	-
Molding shrinkage, parallel	2.0	%	ISO 294-4, 2577
Molding shrinkage, normal	2.0	%	ISO 294-4, 2577
Mechanical Properties			
ISO Data			
Tensile Modulus	2600	MPa	ISO 527
Yield stress	60	MPa	ISO 527
Yield strain	9	%	ISO 527
Impact Strength (Charpy), +23°C	180	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	10	kJ/m ²	ISO 179/1eA
Thermal Properties			
ISO Data			
Melting Temperature (10°C/min)	225	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	70	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	160	°C	ISO 75-1/-2
Coeff. of Linear Therm. Expansion, parallel	111	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	107	E-6/K	ISO 11359-1/-2
Other Properties			
ISO Data			
Density	1310	kg/m ³	ISO 1183
Test specimen production			
ISO Data			
Injection Molding, melt temperature	250	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294
Processing Recommendation Injection Molding			
Pre-drying - Temperature	120	°C	-
Pre-drying - Time	4 - 8	h	-
Processing humidity	≤0.02	%	-
Melt temperature	250 - 270	°C	-
Mold temperature	80 - 100	°C	-

Diagrams

Stress-strain



Secant modulus-strain



Characteristics

Processing

Injection Molding

Delivery form

Pellets

Injection Molding

PREPROCESSING

Residual moisture content: 0.00 - 0.02 %

Drying temperature circulating air dryer: 120 °C

Drying time circulating air dryer: 4 - 8 h

PROCESSING

Melt temperature (Tmin - Tmax): 250 - 270 °C

Mold temperature: 80 - 100 °C

Disclaimer

Liability Exclusion

These guide values are measured and provided by the product manufacturer and have been determined on standardised test specimens and can be affected by pigmentation, mould design and processing conditions. M-Base has taken the guide values from the producer's original Technical Data Sheet. **ALBIS AND M-BASE ARE THEREFORE NOT RESPONSIBLE FOR THE ACCURACY OF THE GUIDE VALUES AND CANNOT GIVE ANY WARRANTY WITH REGARD TO THEIR CORRECTNESS.**

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