Pocan® B3225LT 904040

PBT-GF20 Envalior

Injection Molding, 20% Glass Reinforced, Laser Transparent Black

ISO 1043 PBT-GF20

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	20	cm³/10min	ISO 1133
Temperature	260	°C	-
Load	2.16	kg	-
Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577
Molding shrinkage, normal	1.0	%	ISO 294-4, 2577

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	7100	MPa	ISO 527
Stress at Break	120	MPa	ISO 527
Strain at Break	3.2	%	ISO 527
Flexural Modulus (23°C)	7000	MPa	ISO 178
Impact Strength (Izod), 23°C	35	kJ/m²	ISO 180/1U

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	225	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	205	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	220	°C	ISO 75-1/-2

Other Properties	Value	Unit	Test Standard
ISO Data			
Density	1440	kg/m³	ISO 1183
Bulk density	700	kg/m³	-

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	260	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294

Processing Recommendation Injection Molding	Value	Unit	Test Standard
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	-

Characteristics

Processing
Injection Molding

Special Characteristics
Heat aging stabilized

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
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