

PRECITE® PRELIMINARY

V GF 20 2 LA black (8984)

PBT+ASA GF20

PRECITE V GF 20 2 LA black (8984) is a 20% glass fibre reinforced, UV-stabilised PBT/ASA blend with low warpage and good surface quality. Compared to neat PBT, this grade has a lower density and is suitable for precision parts in the automotive, E&E and household goods industries. The grade is laser markable.

Features

UV-stabilised laser markable low warpage

Properties

Modulus	Strength	Impact
6.000 MPa	100 MPa	50 kJ/m ²

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min d.a.m.	6000 MPa
Tensile stress at break ISO 527-2	5 mm/min d.a.m.	100 MPa
Tensile strain at break ISO 527-2	5 mm/min d.a.m.	2,7 %
Charpy impact strength ISO 179-1/1eU	23°C d.a.m.	50 kJ/m²
Charpy notched impact strength ISO 179-1/1eA	23°C d.a.m.	6 kJ/m²

Flammability

Flammability UL 94	0,8 mm Wall thickness	HB Class
------------------------------	-----------------------	-----------------

General Properties

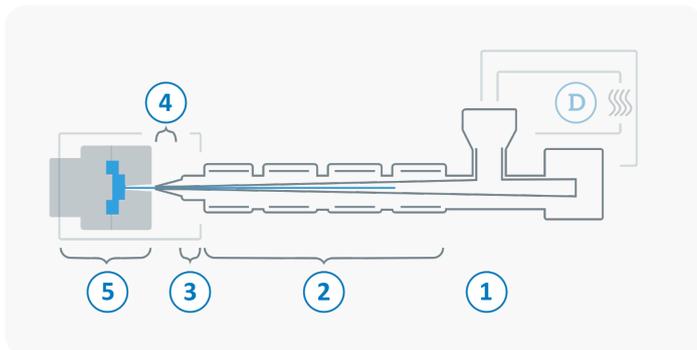
Density ISO 1183	23°C	1,34 g/cm³
Molding shrinkage ISO 294-4	flow transverse	0,3 - 0,4 % 0,6 - 0,7 %

Rheological Properties

MVR ISO 1133	250°C/2,16kg	4 cm³/10 min
------------------------	--------------	--------------------------------

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 °C
	Processing moisture	0,02 - 0,04 %
1	Feed section	60 - 80 °C
2	Temperature Zone 1 - Zone 4	250 - 275 °C
3	Nozzle temperature	250 - 280 °C
4	Melt temperature	260 - 275 °C
5	Mold temperature	80 - 100 °C
→	Holding pressure, spec.	300 - 800 bar
←	Back pressure, spec.	30 - 100 bar
	Injection speed	medium to high
	Screw speed	8 - 15 m/min