

PRECITE® PRELIMINARY

V GF 20 2 natural (7737)

PBT-ASA- GF 20

PRECITE V GF 20 2 natural (7737) is a 20% 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



Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min d.a.m.	6500 MPa
Tensile stress at break ISO 527-2	5 mm/min d.a.m.	110 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.	8 kJ/m²

Flammability

Flammability UL 94	0,8 mm Wall thickness	HB Class
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General Properties

Density	23°C	1,34 g/cm³
ISO 1183		

Molding shrinkage	flow	0,3 - 0,4 %
ISO 294-4	transverse	0,6 - 0,7 %

Rheological Properties

MVR	250°C/2,16kg	7,0 cm³/10 min
ISO 1133		

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