

TECACOMP PBT GF30 natural 1014807 - Compounds

Chemical Designation

PBT (Polybutylene terephthalate)

Colour

natural

Density

1.51 g/cm³

<i>Mechanical properties</i>	<i>parameter</i>	<i>value</i>	<i>unit</i>	<i>norm</i>	<i>comment</i>
Tensile strength		140	MPa	DIN EN ISO 527-1	
Modulus of elasticity (tensile test)		9200	MPa	DIN EN ISO 527-1	
Elongation at break (tensile test)		3,5	%	DIN EN ISO 527-1	
Impact strength (Charpy)		65	kJ/m ²	DIN EN ISO 179-1eU	
<i>Thermal properties</i>	<i>parameter</i>	<i>value</i>	<i>unit</i>	<i>norm</i>	<i>comment</i>
Glass transition temperature		60	°C	-	
Melting temperature		225	°C	-	
Service temperature	long term	110	°C	-	
Service temperature	short term	170	°C	-	
<i>Other properties</i>	<i>parameter</i>	<i>value</i>	<i>unit</i>	<i>norm</i>	<i>comment</i>
Molding shrinkage	longitudinal	0,7	%	DIN EN ISO 294-4	
Molding shrinkage	transverse	1,7	%	DIN EN ISO 294-4	
<i>Processing parameter</i>	<i>parameter</i>	<i>value</i>	<i>unit</i>	<i>norm</i>	<i>comment</i>
Cylinder/processing temperature		240 - 275	°C	-	
Mould temperature		60 - 130	°C	-	
Material temperature		260 - 280	°C	-	

→ This material can be processed as a thermoplastic taking the normal technical provisions into account. The above mentioned information refers exclusively to the injection moulding process.

→ Processing should be carried out as gently as possible, in order to maintain the maximum fibre length in the component. Back pressure and injection rate should be adjusted to the component geometry accordingly. The optimum processing temperature depends upon the respective geometry of the moulded part and can be different from machine to machine.

<i>Predrying</i>	<i>parameter</i>	<i>value</i>	<i>unit</i>	<i>norm</i>	<i>comment</i>
Permissible residual moisture content		< 0,02	%	-	
Drying temperature		< 120	°C	-	
Drying time		3 - 6	h	-	

→ To achieve optimum mechanical properties, it is recommended to pre-dry the material with the above mentioned parameters.

→ Information on storage and shelf life: The granules must be stored in dry, normally tempered rooms and in closed containers. For moisture-sensitive materials, the granules must be sealed airtight. Protection against direct sunlight must be guaranteed. The granules are usually subject to the requirements of no shelf life limitation. Shelf Life may be limited by some additives.

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