

Arnite® TZ6 280 BLK (NCP-4718/B)

Polybutylene Terephthalate

DSM Engineering Plastics

Message:

Arnite® TZ6 280 BLK (NCP-4718/B) is a Polybutylene Terephthalate (PBT) material filled with 20% glass bead and 20% glass fiber. It is available in North America.

General Information			
Filler / Reinforcement	Glass Bead,20% Filler by Weight		
	Glass Fiber,20% Filler by Weight		
Physical	Nominal Value	Unit	Test Method
Density	1.63	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow	1.0	%	
Flow	0.40	%	
Water Absorption			ISO 62
Saturation, 23°C	0.25	%	
Equilibrium, 23°C, 50% RH	0.15	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	9100	MPa	ISO 527-2
Tensile Stress (Break)	100	MPa	ISO 527-2
Tensile Strain (Break)	2.5	%	ISO 527-2
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	5.5	kJ/m ²	
23°C	7.0	kJ/m ²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	30	kJ/m ²	
23°C	35	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	210	°C	ISO 75-2/B
1.8 MPa, Unannealed	205	°C	ISO 75-2/A
Melting Temperature ¹	225	°C	ISO 11357-3
CLTE			ISO 11359-2
Flow	3.0E-5	cm/cm/°C	
Transverse	1.3E-4	cm/cm/°C	
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	> 1.0E+15	ohms · cm	IEC 60093

Injection	Nominal Value	Unit
Drying Temperature	100 to 120	°C
Drying Time	3.0 to 12	hr
Rear Temperature	230 to 240	°C
Middle Temperature	230 to 250	°C
Front Temperature	240 to 260	°C
Nozzle Temperature	240 to 260	°C
Processing (Melt) Temp	240 to 270	°C
Mold Temperature	60.0 to 100	°C
Injection Rate	Moderate-Fast	
Back Pressure	3.00 to 10.0	MPa
Screw Compression Ratio	2.5:1.0	
NOTE		

1. 10°C/min

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