Beetle® PBTB130F

Polybutylene Terephthalate + PET

Teknor Apex Company (Chem Polymer)

Message:

PBTB130F is a 30% glass fibre reinforced PBT injection moulding grade. It features a modified formulation that offers good mechanical performance combined with higher surface gloss and excellent mould release.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Features	Highlight Thermal stability, good Good demoulding performance Excellent appearance		
Forms	Particle		
Processing Method	Injection molding		
Resin ID (ISO 1043)	PBT+PET-GF30		
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	1.55	g/cm³	ISO 1183
Molding Shrinkage [1]	0.60 - 1.2	%	Internal method
Water Absorption (Equilibrium, 23°C, 50% RH)	0.060	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	10000	MPa	ISO 527-2
Tensile Stress (Yield)	140	MPa	ISO 527-2
Tensile Strain (Break)	2.5	%	ISO 527-2
Flexural Modulus	9300	MPa	ISO 178
Flexural Stress	200	MPa	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength	11	kJ/m²	ISO 179
Charpy Unnotched Impact Strength	45	kJ/m²	ISO 179
Notched Izod Impact	7.0	kJ/m²	ISO 180
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature			
0.45 MPa, not annealed	> 200	°C	ISO 75-2/B
1.8 MPa, not annealed	200	°C	ISO 75-2/Af
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	1.0E+16	ohms	IEC 60093
Volume Resistivity	1.0E+14	ohms·cm	IEC 60093
Dielectric Strength (3.00 mm)	16	kV/mm	IEC 60243-1
Relative Permittivity	3.30		IEC 60250

Comparative Tracking Index	300	V	IEC 60112
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (1.50 mm, Teknor Apex test result)	HB		UL 94
Oxygen Index	20	%	ISO 4589-2
Injection	**Nominal Value**	**Unit**	
Drying Temperature	120	°C	
Drying Time	4.0	hr	
Rear Temperature	240 - 270	°C	
Middle Temperature	245 - 270	°C	
Front Temperature	250 - 270	°C	
Processing (Melt) Temp	260 - 275	°C	
Mold Temperature	80.0 - 110	°C	
Injection Rate	Fast		
Screw Speed	50 - 200	rpm	

Injection instructions

Back Pressure: LowInjection Pressure: HighPolyester grades are very sensitive to moisture content during processing. Suitable pre-drying is essential. Excess moisture causes rapid hydrolytic degradation of the melt and severe impairment of mechanical properties. Low melt viscosity & brittle product are often the key indicators. Vacuum or dehumidified air driers must be used.

NOTE

1. Mould shrinkage is significantly influenced by many factors including wall thickness, gating, moulding shape and processing conditions. The range values given are determined from specimen bar mouldings of 1.5mm to 4mm wall thickness. They are provided as a guide for comparison purposes only and no guarantee should be inferred from their inclusion. (Specimens measured in the dry state, 24 hours after moulding).

Recommended distributors for this material

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