

TechnoDur PBT 4 GF10 black (9991)

Polybutylene Terephthalate

TechnoCompound GmbH

Message:

PBT, injection moulding, 10% glass fibre, heat stabilized, excellent flow ability and strength, for outdoorapplications

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 10% filler by weight		
Additive	heat stabilizer		
Features	High strength		
	High liquidity		
	Thermal Stability		
Uses	Outdoor application		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.38	g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR) (250°C/2.16 kg)	18.0	cm³/10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	4600	MPa	ISO 527-2/1
Tensile Stress (Break)	90.0	MPa	ISO 527-2/5
Tensile Strain (Break)	4.0	%	ISO 527-2/5
Flammability	Nominal Value	Test Method	
Flame Rating (0.800 mm)	HB	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	120 - 140	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	250 - 265	°C	
Middle Temperature	250 - 265	°C	
Front Temperature	250 - 265	°C	
Nozzle Temperature	260 - 270	°C	
Processing (Melt) Temp	260 - 270	°C	
Mold Temperature	75.0 - 100	°C	
Injection Pressure	60.0 - 100	MPa	
Injection Rate	Fast		
Holding Pressure	40.0 - 80.0	MPa	

Back Pressure	1.00 - 3.00	MPa
Screw Speed	80	rpm
Injection instructions		

Residence Time: 5 to 10 min

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

