

DURANEX® 313RA

Polybutylene Terephthalate

Polyplastics Co., Ltd.

Message:

Resin Adhesion Improved for Multiple Injection Molding, GF15% reinforced, Standard

General Information			
UL YellowCard	E213445-228903		
Filler / Reinforcement	Glass fiber reinforced material, 15% filler by weight		
Features	Good adhesion		
UL File Number	E213445		
Forms	Particle		
Processing Method	Multiple injection molding		
	Injection molding		
Part Marking Code (ISO 11469)	>PBT-GF15		
Physical	Nominal Value	Unit	Test Method
Density	1.41	g/cm³	ISO 1183
Water Absorption (23°C, 24 hr)	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress	110	MPa	ISO 527-2
Tensile Strain (Break)	3.0	%	ISO 527-2
Flexural Modulus	5330	MPa	ISO 178
Flexural Stress	160	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	6.0	kJ/m²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	197	°C	ISO 75-2/A
Linear thermal expansion coefficient			Internal method
Flow: 23 to 55°C	4.0E-5	cm/cm/°C	Internal method
Lateral: 23 to 55°C	1.0E-4	cm/cm/°C	Internal method
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	2.0E+16	ohms · cm	IEC 60093
Dielectric Strength (3.00 mm)	24	kV/mm	IEC 60243-1
Comparative Tracking Index	350	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		UL 94
Additional Information	Nominal Value		
Color Number	EF2001/ED3002		

Injection	Nominal Value	Unit
Drying Temperature	120 - 140	°C
Drying Time	3.0 - 5.0	hr
Processing (Melt) Temp	250 - 270	°C
Mold Temperature	40.0 - 80.0	°C
Holding Pressure	60.0 - 100	MPa
Screw Speed	100 - 150	rpm

Injection instructions

Cooling Time: Plasticization time + alpha or time without sticking in mold

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