

Romiloy® 5230 GF 20

Polybutylene Terephthalate + ASA

ROMIRA GmbH

Message:

Romiloy® 5230 GF 20 is a polybutylene terephthalate + ASA (PBT + ASA) material, and the filler is 20% glass fiber reinforced material. This product is available in Europe, and the processing method is injection molding.

Romiloy® The main characteristics of 5230 GF 20 are:

flame retardant/rated flame

Good dimensional stability

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Features	Good dimensional stability		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.41	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	40	g/10 min	ISO 1133
Molding Shrinkage (23°C)	0.30 - 0.60	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	6450	MPa	ISO 527-2/1
Tensile Stress (Yield, 23°C)	98.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	6.0	%	ISO 527-2/5
Flexural Modulus ¹ (23°C)	5700	MPa	ISO 178
Flexural Stress ² (23°C)	150	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	5.0	kJ/m²	ISO 179/1eA
23°C	6.0	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	35	kJ/m²	ISO 179/1eU
23°C	45	kJ/m²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	210	°C	ISO 306/B50
Flammability	Nominal Value		Test Method
Flame Rating (1.60 mm)	HB		UL 94
Additional Information			
The value listed as Molding Shrinkage ISO 294-4, was tested in accordance with DIN 16901.			
Injection	Nominal Value	Unit	
Drying Temperature	90.0 - 100	°C	
Drying Time	2.0 - 4.0	hr	

Suggested Max Moisture	0.040	%
Suggested Max Re grind	5	%
Rear Temperature	240 - 260	°C
Middle Temperature	240 - 260	°C
Front Temperature	240 - 260	°C
Processing (Melt) Temp	< 260	°C
Mold Temperature	75.0 - 100	°C
Injection Rate	Moderate	
Back Pressure	< 1.00	MPa
Screw Speed	12 - 18	rpm

Injection instructions

Holding Pressure: moderate to high

NOTE

1. 2.0 mm/min
2. 2.0 mm/min

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