

Pocan B1503 000000

PBT, non-reinforced, injection molding, extrusion

ISO Shortname: ISO 20028-PBT,,GHMR,11-030

Property	Test Condition	Unit	Standard	guide value
Rheological properties				
C Melt volume-flow rate	260 °C; 2.16 kg	cm ³ /(10 min)	ISO 1133-1	18
Molding shrinkage, parallel	150x105x3; 260 °C / MT 80 °C; 600 bar	%	acc. ISO 2577	1.9
Molding shrinkage, transverse	150x105x3; 260 °C / MT 80 °C; 600 bar	%	acc. ISO 2577	1.9
Post- shrinkage, parallel	150x105x3; 150 °C; 1 h	%	acc. ISO 2577	0.5
Post- shrinkage, transverse	150x105x3; 150 °C; 1 h	%	acc. ISO 2577	0.5
Mechanical properties (23 °C/50 % r. h.)				
C Tensile modulus	1 mm/min	MPa	ISO 527-1,-2	2600
C Yield stress	50 mm/min	MPa	ISO 527-1,-2	55
C Yield strain	50 mm/min	%	ISO 527-1,-2	8.0
C Nominal strain at break	50 mm/min	%	ISO 527-1,-2	>20
C Charpy impact strength	23 °C	kJ/m ²	ISO 179-1eU	N
C Charpy impact strength	-30 °C	kJ/m ²	ISO 179-1eU	180
C Charpy notched impact strength	23 °C	kJ/m ²	ISO 179-1eA	< 10
C Charpy notched impact strength	-30 °C	kJ/m ²	ISO 179-1eA	< 10
Izod impact strength	23 °C	kJ/m ²	ISO 180-1U	N
Izod impact strength	-30 °C	kJ/m ²	ISO 180-1U	150
Izod notched impact strength	23 °C	kJ/m ²	ISO 180-1A	< 10
Izod notched impact strength	-30 °C	kJ/m ²	ISO 180-1A	< 10
Izod notched impact strength	-40 °C	kJ/m ²	ISO 180-1A	< 10
Flexural modulus	2 mm/min	MPa	ISO 178-A	2650
Flexural strength	2 mm/min	MPa	ISO 178-A	90
Flexural strain at flexural strength	2 mm/min	%	ISO 178-A	6.0
Flexural stress at 3.5 % strain	2 mm/min	MPa	ISO 178-A	80
Thermal properties				
C Melting temperature	10 °C/min	°C	ISO 11357-1,-3	225
C Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2	60
C Temperature of deflection under load	0.45 MPa	°C	ISO 75-1,-2	160
C Coefficient of linear thermal expansion, parallel	23 to 55 °C	10 ⁻⁴ /K	ISO 11359-1,-2	1.2
C Coefficient of linear thermal expansion, transverse	23 to 55 °C	10 ⁻⁴ /K	ISO 11359-1,-2	1.2
Burning behavior US-FMVSS302			ISO 3795	passed
C Vicat softening temperature	50 N; 50 °C/h	°C	ISO 306	180
Other properties (23 °C)				
C Water absorption (Saturation value)	Water at 23 °C	%	ISO 62	0.5
C Water absorption (Equilibrium value)	23 °C; 50 % RH	%	ISO 62	0.2
C Density		kg/m ³	ISO 1183	1300



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Property	Test Condition	Unit	Standard	guide value
Bulk density		kg/m ³	ISO 60	800
Processing conditions for test specimens				
C Injection molding-Melt temperature		°C	ISO 294	260
C Injection molding-Mold temperature		°C	ISO 294	80
Processing recommendations				
Drying temperature circulating air dryer		°C	-	120
Drying time circulating air dryer		h	-	4-8
Residual moisture content		%	Acc. to Karl Fischer	0-0.02
Melt temperature (Tmin - Tmax)		°C	-	250-270
Mold temperature		°C	-	80-100

C These property characteristics are taken from the CAMPUS plastics data bank and are based on the international catalogue of basic data for plastics according to ISO 10350.



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Disclaimer

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Test values

Unless specified to the contrary, the values given have been established on standardized test specimens at room temperature. The figures should be regarded as guide values only and not as binding minimum values. Kindly note that, under certain conditions, the properties can be affected to a considerable extent by the design of the mould/die, the processing conditions and the coloring.

Processing note

Under the recommended processing conditions small quantities of decomposition product may be given off during processing. To preclude any risk to the health and well-being of the machine operatives, tolerance limits for the work environment must be ensured by the provision of efficient exhaust ventilation and fresh air at the workplace in accordance with the Safety Data Sheet. In order to prevent the partial decomposition of the polymer and the generation of volatile decomposition products, the prescribed processing temperatures should not be substantially exceeded. Since excessively high temperatures are generally the result of operator error or defects in the heating system, special care and controls are essential in these areas.

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