

## Technical Data Sheet

**Schuladur 1031849CT PC E-12672B C3 BLKBLK**

Polybutylene Terephthalate

**Product Description**

PBT

**Processing Method**      Injection Molding

<b>Typical Properties</b>	<b>Nominal Value</b>	<b>Units</b>	<b>Test Method</b>
<b>Physical</b>			
Melt Flow Rate, (260 °C/2.16 kg, Procedure A)	10	g/10 min	ASTM D1238
Density - Specific Gravity	1.19	g/cm <sup>3</sup>	ASTM D792
<b>Mechanical</b>			
Tensile Strength at Yield, (50 mm/min)	52.0	MPa	ASTM D638
Tensile Strength at Break, (50 mm/min)	0.827	MPa	ASTM D638
Flexural Modulus, (1.3 mm/min)	2130	MPa	ASTM D790
Tensile Modulus, (50 mm/min)	1960	MPa	ASTM D638
<b>Impact</b>			
Notched Izod Impact	660	J/m	ASTM D256
<b>Thermal</b>			
Vicat Softening Temperature	145	°C	ASTM D1525
Deflection Temperature Under Load Unannealed (66 psi)	130	°C	ASTM D648

<b>Injection Parameters</b>	<b>Value</b>	<b>Units</b>
Drying Time	2.0 to 4.0	hr
Drying Temperature, (Desiccant Dryer)	120 to 140	°C
Nozzle Temperature	235 to 255	°C
Processing (Melt) Temp	220 to 270	°C
Front Temperature	225 to 240	°C
Middle Temperature	225 to 240	°C
Rear Temperature	220 to 235	°C
Mold Temperature	<80	°C