Technical Data Sheet

Schuladur A2 GF1 5LS K1882 BLK968001

Polybutylene Terephthalate + ASA

Product Description

15% glass fibre reinforced PBT/ASA-blend with high surface and reduced warpage

Processing Method	Injection Molding
Filler/Reinforcement	Glass Fiber, 15%
Resin ID	(PBT+ASA)-GF15

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Volume Flow Rate			
(250 °C/5.0 kg)	30	cm³/10 min	ISO 1133
(250 °C/2.16 kg)	5.0	cm³/10 min	ISO 1133
Density, (Method A)	1.31	g/cm³	ISO 1183
Mechanical			
Tensile Strain at Break, (Type 1A, 5 mm/min)	3.2	%	ISO 527-2
Flexural Modulus, (23 °C)	4100	MPa	ISO 178
Tensile Stress at Break, (Type 1A, 5 mm/min)	60.0	MPa	ISO 527-2
Tensile Modulus, (1 mm/min, Type 1A)	4650	MPa	ISO 527-1
Flexural Stress, (23 °C)	94.0	MPa	ISO 178
Impact			
Charpy Impact Strength - Notched, (23 °C, Type 1, Edgewise, Notch A)	6.0	kJ/m²	ISO 179
Charpy Impact Strength - Unnotched, (23 °C, Type 1, Edgewise)	40	kJ/m²	ISO 179
Thermal			
Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise)	200	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	130	°C	ISO 75-2/A
Electrical			
Comparative Tracking Index (CTI)	250	V	IEC 60112
Flammable			
Burning Rate			
(2.00 mm)	<100	mm/min	ISO 3795
(2.00 mm)	<100	mm/min	FMVSS 302

Injection Parameters	Nominal Value	Units
Drying Time	2.0 to 4.0	hr
Drying Temperature	100	°C
Suggested Max Moisture	0.05	%
Nozzle Temperature	260	°C
Screw Speed	300	mm/sec
Processing (Melt) Temp	250 to 260	°C
Front Temperature	260	°C
Holding Pressure	40.0 to 70.0	MPa
Hopper Temperature	70	°C
Middle Temperature	245	°C
Vent Depth	0.02	mm
Rear Temperature	230	°C
Back Pressure	5.00 to 10.0	MPa
Mold Temperature	60 to 90	°C
Injection Pressure	80.0 to 120	MPa