Technical Data Sheet

Schuladur PCR GF 15 K1947

Polybutylene Terephthalate + PET
LyondellBasell Industries
Engineering Plastics

Product Description

15% glass fibre reinforced PBT/PET blend.
According to ISO 14021:2016 Schuladur PCR GF15 K1947 is a compound containing at least 40% (R40) of recycled material that is fully based on Post-Consumer Waste (PCW).

General

Filler / Reinforcement	• Glass Fiber, 15% Filler by Weight
Recycled Content	• Yes
Processing Method	• Injection Molding

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.43 g/cm³	1.43 g/cm³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (260°c/2.16 Kg)	18 cm³/10min	18 cm³/10min	ISO 1133
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Modulus	972000 psi	6700 MPa	ISO 527-1/1A/1
Tensile Stress (Break)	16200 psi	112 MPa	ISO 527-2/1A/5
Tensile Strain (Break)	2.4 %	2.4 %	ISO 527-2/1A/5
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Charpy Notched Impact Strength			ISO 179/1eA
-22°f (-30°c)	1.9 ft·lb/in²	4.0 kJ/m²	
73°f (23°c)	2.4 ft·lb/in²	5.0 kJ/m²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°f (-30°c)	8.6 ft·lb/in²	18 kJ/m²	
73°f (23°c)	12 ft·lb/in²	25 kJ/m²	
Thermal	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Deflection Temperature Under Load			
66 Psi (0.45 Mpa), Unannealed	415 °F	213 °C	ISO 75-2/Bf
264 Psi (1.8 Mpa), Unannealed	367 °F	186 °C	ISO 75-2/Af
Vicat Softening Temperature			
--	381 °F	194 °C	ISO 306/B50
--	419 °F	215 °C	ISO 306/A120
Electrical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Surface Resistivity	> 1.0E+15 ohms	> 1.0E+15 ohms	IEC 60093
Volume Resistivity	> 1.0E+13 ohms·m	> 1.0E+13 ohms·m	IEC 62631-3-1

Additional Information

1.) Not for use in food contact applications
2.) Not for use in medical or pharmaceutical applications

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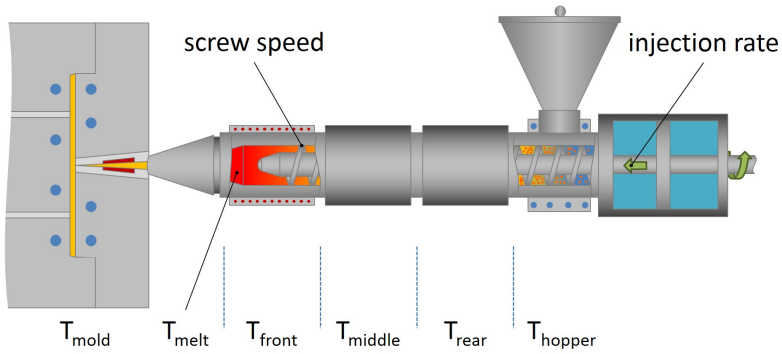

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	248 °F	120 °C
Drying Time	4.0 to 6.0 hr	4.0 to 6.0 hr
Suggested Max Moisture	0.02 %	0.02 %
Processing (Melt) Temp	500 to 536 °F	260 to 280 °C
Mold Temperature	176 to 230 °F	80 to 110 °C

Notes

These are typical property values not to be construed as specification limits.