Technical Data Sheet

SCHULADUR® PCR GF 15 K2027

Polybutylene Terephthalate + PET
Engineering Plastics

Product Description
PBT/PET blend, 15% glass fibre reinforced

General	
Filler / Reinforcement	• Glass Fiber, 15% Filler by Weight
Processing Method	• Injection Molding
Resin ID (ISO 1043)	• PBT+PET

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.51 g/cm³	1.51 g/cm³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (260°C/2.16 kg)	25 cm³/10min	25 cm³/10min	ISO 1133
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Modulus	870000 psi	6000 MPa	ISO 527-2/1A/1
Tensile Stress (Break)	12300 psi	85.0 MPa	ISO 527-2/1A/5
Tensile Strain (Break)	2.0 %	2.0 %	ISO 527-2/1A/5
Flexural Modulus [1]	1.09E+6 psi	7500 MPa	ISO 178
Flexural Stress [1] (2.0% Strain)	18900 psi	130 MPa	ISO 178
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Charpy Notched Impact Strength			ISO 179/1eA
-22°F (-30°C)	0.71 ft·lb/in²	1.5 kJ/m²	
73°F (23°C)	0.95 ft·lb/in²	2.0 kJ/m²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°F (-30°C)	12 ft·lb/in²	26 kJ/m²	
73°F (23°C)	10 ft·lb/in²	22 kJ/m²	
Hardness	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Shore Hardness (Shore D, 3 sec)	80	80	ISO 868
Ball Indentation Hardness (H 961/30)	28900 psi	199 MPa	ISO 2039-1
Thermal	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Heat Deflection Temperature			
66 psi (0.45 MPa), Unannealed	405 °F	207 °C	ISO 75-2/Bf
264 psi (1.8 MPa), Unannealed	331 °F	166 °C	ISO 75-2/Af
Vicat Softening Temperature			
--	410 °F	210 °C	ISO 306/A120
--	379 °F	193 °C	ISO 306/B50
Flammability	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Burning Rate			
0.0787 in (2.00 mm)	1.2 in/min	30 mm/min	ISO 3795
0.0787 in (2.00 mm)	1.2 in/min	30 mm/min	FMVSS 302

Additional Information

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

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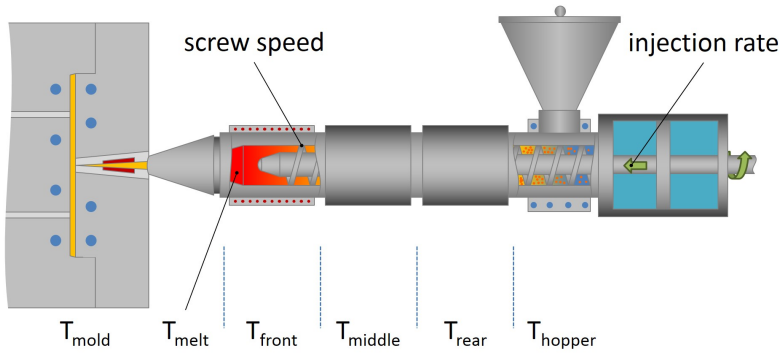

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	248 °F	120 °C
Drying Time	4.0 to 6.0 hr	4.0 to 6.0 hr
Suggested Max Moisture	0.02 %	0.02 %
Suggested Max Regrind	20 %	20 %
Processing (Melt) Temp	500 to 536 °F	260 to 280 °C
Mold Temperature	176 to 230 °F	80 to 110 °C

Notes

[1] 0.079 in/min (2.0 mm/min)

Notes

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