Technical Data Sheet

SCHULADUR® PCR GF 20 K2068

Polybutylene Terephthalate + PET
Engineering Plastics

Product Description	
20% glass fibre reinforced PBT/PET blend	

General	
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight
Recycled Content	• Yes
Processing Method	• Injection Molding
Resin ID (ISO 1043)	• PBT+PET+GF

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.47 g/cm³	1.47 g/cm³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (260°C/2.16 kg)	27 cm³/10min	27 cm³/10min	ISO 1133
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Modulus	1.17E+6 psi	8100 MPa	ISO 527-2/1A/1
Tensile Stress (Break)	16700 psi	115 MPa	ISO 527-2/1A/5
Tensile Strain (Break)	2.3 %	2.3 %	ISO 527-2/1A/5
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Charpy Notched Impact Strength (73°F (23°C))	2.9 ft·lb/in²	6.0 kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
73°F (23°C)	14 ft·lb/in²	30 kJ/m²	
Thermal	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Heat Deflection Temperature			
66 psi (0.45 MPa), Unannealed	437 °F	225 °C	ISO 75-2/Bf
264 psi (1.8 MPa), Unannealed	392 °F	200 °C	ISO 75-2/Af
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
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
Flammability Classification			IEC 60695-11-10, -20
0.030 in (0.75 mm)	HB	HB	
0.06 in (1.5 mm)	HB	HB	
Glow Wire Flammability Index			IEC 60695-2-12
0.08 in (2.0 mm)	1200 °F	650 °C	

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

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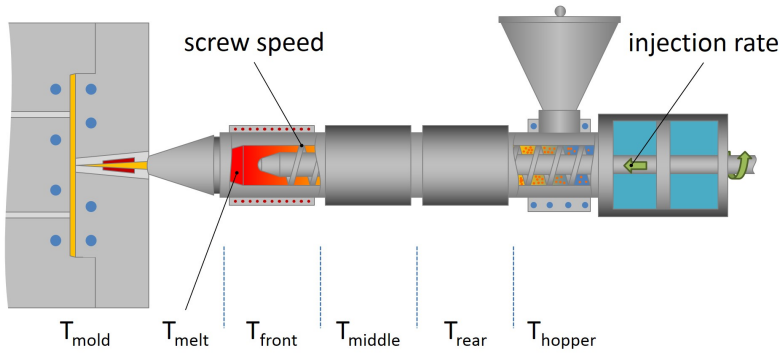

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	248 °F	120 °C
Drying Time	4.0 to 6.0 hr	4.0 to 6.0 hr
Suggested Max Moisture	0.02 %	0.02 %
Suggested Max Regrind	20 %	20 %
Processing (Melt) Temp	500 to 536 °F	260 to 280 °C
Mold Temperature	176 to 230 °F	80 to 110 °C

Notes

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