

PIBIFOR® 30S5301NA - PBT

| Physical properties | Value | Unit | Test Standard |
|-----------------------|-------|------------------------|---------------|
| Melt volume rate, MVR | 20 | cm ³ /10min | ISO 1133 |
| MVR temperature | 250 | °C | ISO 1133 |
| MVR load | 2.16 | kg | ISO 1133 |

| Mechanical properties | Value | Unit | Test Standard |
|--------------------------------------|-------|-------------------|---------------|
| Flexural modulus, 23°C | 8300 | MPa | ISO 178 |
| Charpy notched impact strength, 23°C | 9.5 | kJ/m ² | ISO 179/1eA |

| Thermal properties | Value | Unit | Test Standard |
|----------------------------------|-------|-------|---------------|
| Flammability @1.6mm nom. thickn. | HB | class | UL 94 |

Typical injection moulding processing conditions

| Pre Drying | Value | Unit | Test Standard |
|---|-----------|------|---------------|
| Necessary low maximum residual moisture content | 0.02 | % | - |
| Drying time | 2 - 4 | h | - |
| Drying temperature | 120 - 140 | °C | - |

| Temperature | Value | Unit | Test Standard |
|--------------------------|-----------|------|---------------|
| Hopper temperature | 20 - 50 | °C | - |
| Feeding zone temperature | 190 - 200 | °C | - |
| Zone1 temperature | 250 - 260 | °C | - |
| Zone2 temperature | 250 - 260 | °C | - |
| Zone3 temperature | 255 - 265 | °C | - |
| Zone4 temperature | 255 - 265 | °C | - |
| Nozzle temperature | 260 - 270 | °C | - |
| Melt temperature | 260 - 270 | °C | - |
| Mold temperature | 75 - 100 | °C | - |
| Hot runner temperature | 260 - 270 | °C | - |

| Speed | Value | Unit | Test Standard |
|-----------------|-------|------|---------------|
| Injection speed | fast | - | - |

| Screw Speed | Value | Unit | Test Standard |
|----------------------------|-------|------|---------------|
| Screw speed diameter, 25mm | 90 | RPM | - |
| Screw speed diameter, 40mm | 75 | RPM | - |
| Screw speed diameter, 55mm | 60 | RPM | - |

Characteristics

| Product Categories | Regional Availability |
|--------------------|-----------------------|
| Glass reinforced | Europe |

Processing

Injection molding