

PIBIFOR® 34S5301NN - PBT

Description

PBT GF10, Flame Retardant grade, preliminary data sheet

Physical properties	Value	Unit	Test Standard
Density	1500	kg/m ³	ISO 1183
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
Tensile modulus	4850	MPa	ISO 527-2/1A
Tensile stress at break, 5mm/min	75	MPa	ISO 527-2/1A
Tensile strain at break, 5mm/min	2	%	ISO 527-2/1A
Flexural modulus, 23°C	4200	MPa	ISO 178
Charpy notched impact strength, 23°C	2	kJ/m ²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
Melting temperature, 10°C/min	225	°C	ISO 11357-1/-3
Flammability @1.6mm nom. thickn.	V-0	class	UL 94
thickness tested (1.6)	1.6	mm	UL 94
UL recognition (1.6)	UL	-	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

Special Characteristics

Flame retardant

Processing

Injection molding