

PIBITER® NRV15S1 NAT001 - PBT
Description

PBT, 15% glass fiber reinforced

| Physical properties | Value | Unit | Test Standard |
|---------------------|-------|-------------------|---------------|
| Density | 1340 | kg/m ³ | ISO 1183 |
| Melt flow rate, MFR | 15 | g/10min | ISO 1133 |
| MFR temperature | 250 | °C | ISO 1133 |
| MFR load | 2.16 | kg | ISO 1133 |

| Mechanical properties | Value | Unit | Test Standard |
|--------------------------------------|-------|-------------------|---------------|
| Tensile modulus | 5500 | MPa | ISO 527-2/1A |
| Tensile stress at break, 5mm/min | 93 | MPa | ISO 527-2/1A |
| Tensile strain at break, 5mm/min | 3.3 | % | ISO 527-2/1A |
| Flexural modulus, 23°C | 4700 | MPa | ISO 178 |
| Charpy impact strength, 23°C | 60 | kJ/m ² | ISO 179/1eU |
| Charpy notched impact strength, 23°C | 6.8 | 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 |
|--------------------|-----------|------|---------------|
| Drying time | 3 - 4 | h | - |
| Drying temperature | 100 - 120 | °C | - |
| Temperature | Value | Unit | Test Standard |
| Zone1 temperature | 230 - 250 | °C | - |
| Zone2 temperature | 240 - 260 | °C | - |
| Zone3 temperature | 245 - 265 | °C | - |
| Zone4 temperature | 250 - 270 | °C | - |
| Mold temperature | 60 - 90 | °C | - |