

PIBITER NRV15S1

PIBITER®

Product information

Resin Identification	(PBT+SAN)-GF15	ISO 1043
Part Marking Code	>(PBT+SAN)-GF15<	ISO 11469

Rheological properties

Melt mass-flow rate	15 g/10min	ISO 1133
Melt mass-flow rate, Temperature	250 °C	
Melt mass-flow rate, Load	2.16 kg	
Moulding shrinkage range, parallel	0.6 - 0.7 %	ISO 294-4, 2577
Moulding shrinkage range, normal	0.8 - 0.9 %	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	5500 MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	93 MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	3.3 %	ISO 527-1/-2
Flexural modulus	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
Poisson's ratio	0.35 ^[C]	

[C]: Calculated

Thermal properties

Temperature of deflection under load, 1.8 MPa	190 °C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	218 °C	ISO 75-1/-2

Flammability

Burning Behav. at 1.5mm nom. thickn.	HB class	IEC 60695-11-10
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Physical/Other properties

Density	1340 kg/m ³	ISO 1183
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Injection

Drying Recommended	yes
Drying Temperature	120 °C
Drying Time, Dehumidified Dryer	4 h
Processing Moisture Content	≤0.04 %
Melt Temperature Optimum	250 °C
Min. melt temperature	240 °C
Max. melt temperature	260 °C
Screw tangential speed	0.1 - 0.3 m/s
Mold Temperature Optimum	80 °C
Min. mould temperature	60 °C
Max. mould temperature	130 °C

Characteristics

Processing	Injection Moulding
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