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Technical Data Sheet

Schuladur 1031850CT PC E-12672G C3 GRYGRY



Polybutylene Terephthalate

Product Description

PBT

Processing Method Injection Molding

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Flow Rate, (260 °C/2.16 kg, Procedure A)	10	g/10 min	ASTM D1238
Density - Specific Gravity	1.19	g/cm³	ASTM D792
Mechanical			
Tensile Strength at Yield, (50 mm/min)	52.0	MPa	ASTM D638
Tensile Strength at Break, (50 mm/min)	0.827	MPa	ASTM D638
Flexural Modulus, (1.3 mm/min)	2130	MPa	ASTM D790
Tensile Modulus, (50 mm/min)	1960	MPa	ASTM D638
Impact			
Notched Izod Impact	660	J/m	ASTM D256
Thermal			
Vicat Softening Temperature	145	°C	ASTM D1525
Deflection Temperature Under Load Unannealed (66 psi)	130	°C	ASTM D648

Injection Parameters	Value	Units
Drying Time	2.0 to 4.0	hr
Drying Temperature, (Desiccant Dryer)	120 to 140	°C
Nozzle Temperature	235 to 255	°C
Processing (Melt) Temp	220 to 270	°C
Front Temperature	225 to 240	°C
Middle Temperature	225 to 240	°C
Rear Temperature	220 to 235	°C
Mold Temperature	<80	°C