

Technical Data Sheet

Schuladur PCR GF20 K206 8BLK968001



Polybutylene Terephthalate + PET

Product Description

20% glass fibre reinforced PBT/PET compound based on mechanical recycled sourcing. Standard color is black, color matching for dark colors possible. Automotive structural applications are possible. According to ISO 14021:2016 Schuladur PCR GF20 is a compound containing 35% of recycled material. Recycled content according to DIN SPEC 91446:2021-12: R35 Data Quality Level according to DIN SPEC 91446:2021-12: DQL4 Data Quality Level according to VDA 284: DQL Automotive

Processing Method	Injection Molding
Filler/Reinforcement	Glass Fiber, 20%
Resin ID	(PBT+PET)-GF20

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Volume Flow Rate, (260 °C/2.16 kg)	20	cm ³ /10 min	ISO 1133
Density, (Method A)	1.47	g/cm ³	ISO 1183
Apparent (Bulk) Density	0.60 to 0.80	g/cm ³	ISO 60
Mechanical			
Tensile Strain at Break, (Type 1A, 5 mm/min)	2.5	%	ISO 527-2
Tensile Stress at Break, (Type 1A, 5 mm/min)	120	MPa	ISO 527-2
Tensile Modulus, (1 mm/min, Type 1A)	7600	MPa	ISO 527-1
Impact			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	6.0	kJ/m ²	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	5.0	kJ/m ²	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	30	kJ/m ²	ISO 179
(-30 °C, Type 1, Edgewise)	28	kJ/m ²	ISO 179
Hardness			
Ball Pressure Test, (200 °C)	Pass		IEC 60695-10-2
Thermal			
Vicat Softening Temperature			
(B (50N), 50 °C/h)	190	°C	ISO 306
(A (10N), 50 °C/h)	215	°C	ISO 306
Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise)	215	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	190	°C	ISO 75-2/A
Electrical			

Volume Resistivity	>1.0E+13	ohm*m	IEC 62631-3-1
Surface Resistivity	>1.0E+15	ohm	IEC 60093
Flammable			
Burning Rate			
(2.00 mm)	30	mm/min	ISO 3795
(2.00 mm)	30	mm/min	FMVSS 302
Glow Wire Flammability Index, (2.0 mm)	650	°C	IEC 60695-2-12
Additional Information			
Water Absorption 23C/50RH	0.3	%	ISO 62
UL Information			
Flammability Classification			
(0.75 mm)	HB		IEC 60695-11-10, -20
(1.5 mm)	HB		IEC 60695-11-10, -20
(3.0 mm)	HB		IEC 60695-11-10, -20
		Nominal	
Injection Parameters	Value	Units	
Drying Time	4.0 to 6.0	hr	
Drying Temperature	120	°C	
Suggested Max Moisture	0.02	%	
Processing (Melt) Temp	260 to 280	°C	
Mold Temperature	80 to 110	°C	