

PIBIFOR® 33S6202LNA 0001 - PBT

Physical properties	Value	Unit	Test Standard
Density	1450	kg/m³	ISO 1183
Melt flow rate, MFR	20	g/10min	ISO 1133
MFR temperature	250	°C	ISO 1133
MFR load	2.16	kg	ISO 1133
Melt volume rate, MVR	18	cm³/10min	ISO 1133
MVR temperature	250	°C	ISO 1133
MVR load	2.16	kg	ISO 1133

Mechanical properties	Value	Unit	Test Standard
Flexural modulus, 23°C	5200	MPa	ISO 178

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
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

Product Categories	Regional Availability
Glass reinforced	Europe
Processing	
Injection molding	