Celanese
The chemistry inside innovation™

PIBITER NRV15S1

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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/m²	ISO 179/1eU
Charpy notched impact strength, 23°C	6.8	kJ/m²	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

Physical/Other properties

Density	1340	kg/m³	ISO 1183

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

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Characteristics

Processing	Injection Moulding

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