

TEKASTER™ F10G15

Polybutylene Terephthalate
Mando Advanced Materials Co., Ltd.

Message:
F10G15 is GF 15% reinforced Polybutylene terephthalate(PBT).

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 15% filler by weight		
Uses	Connector		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.41	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.40 - 1.1	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break)	93.2	MPa	ASTM D638
Tensile Elongation ² (Break)	3.0	%	ASTM D638
Flexural Modulus ³	4900	MPa	ASTM D790
Flexural Strength ⁴	147	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	59	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	210	°C	ASTM D648
1.8 MPa, not annealed	220	°C	ASTM D648
Peak Melting Temperature	225	°C	ASTM D3418
Flammability	Nominal Value		Test Method
Flame Rating	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 100	°C	
Drying Time	3.0 - 4.0	hr	
Rear Temperature	230 - 250	°C	
Middle Temperature	230 - 250	°C	
Front Temperature	230 - 250	°C	
Nozzle Temperature	240 - 250	°C	
Processing (Melt) Temp	230 - 260	°C	
Mold Temperature	60.0 - 100	°C	
Injection instructions			
Injection Speed: 40 to 70%Injection Pressure - 1st: 20 to 50%Injection Pressure - 2nd: 20 to 50%Injection Pressure - Back Pressure: 0 to 20%			
NOTE			
1.	5.0 mm/min		
2.	5.0 mm/min		

3.	3.0 mm/min
4.	3.0 mm/min

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519
Phone: +86 13424755533
Email: sales@su-jiao.com
No. 215, Lianhe North Road, Fengxian District, Shanghai, China

