

SCHULADUR® A3 GF 30 LM

Polybutylene Terephthalate + ASA

A. Schulman Europe

Message:

30% glass fibre reinforced lasermarkable PBT/ASA-blend with high surface quality and reduced warpage

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Features	Low warpage		
	Excellent appearance		
Processing Method	Injection molding		
Resin ID (ISO 1043)	PBT+ASA GF30		
Physical	Nominal Value	Unit	Test Method
Density	1.43	g/cm ³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (250°C/5.0 kg)	20.0	cm ³ /10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	9500	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	115	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	2.0	%	ISO 527-2/1A/5
Flexural Modulus ¹	10500	MPa	ISO 178
Flexural Stress ² (2.5% strain)	205	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	7.0	kJ/m ²	ISO 179/1eA
23°C	7.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	48	kJ/m ²	ISO 179/1eU
23°C	50	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	215	°C	ISO 75-2/Bf
1.8 MPa, not annealed	175	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	210	°C	ISO 306/A50
--	140	°C	ISO 306/B50
Additional Information			
1.)			
Not for use in food contact applications2.)			
Not for use in medical or pharmaceutical applications			

Injection	Nominal Value	Unit
Drying Temperature	100	°C
Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	0.050	%
Suggested Max Regrind	10	%
Hopper Temperature	70.0	°C
Rear Temperature	230	°C
Middle Temperature	245	°C
Front Temperature	260	°C
Nozzle Temperature	260	°C
Processing (Melt) Temp	250 - 260	°C
Mold Temperature	60.0 - 90.0	°C
Injection Pressure	80.0 - 120	MPa
Injection Rate	Moderate-Fast	
Holding Pressure	40.0 - 70.0	MPa
Back Pressure	5.00 - 10.0	MPa
Cushion	2.00 - 5.00	mm
Vent Depth	0.020	mm
NOTE		
1.	2.0 mm/min	
2.	2.0 mm/min	

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