

Generic PC+PBT - Glass Fiber

Polycarbonate + PBT

Generic

Message:

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General Information			
Filler / Reinforcement	Glass fiber reinforced material		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.26 - 1.60	g/cm ³	ASTM D792
23°C	1.30 - 1.51	g/cm ³	ISO 1183
Apparent Density	0.70 - 0.80	g/cm ³	ISO 60
Molding Shrinkage			ASTM D955
Flow: 23°C	0.25 - 0.73	%	ASTM D955
Transverse flow: 23°C	0.50 - 0.75	%	ASTM D955
Water Absorption			
23°C, 24 hr	0.060 - 0.092	%	ASTM D570
Saturated, 23°C	0.10 - 0.50	%	ISO 62
Equilibrium, 23°C, 50% RH	0.076 - 0.15	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (23°C)	110 - 120		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
23°C	4400 - 12800	MPa	ASTM D638
23°C	4510 - 10200	MPa	ISO 527-2
Tensile Strength			
Yield, 23°C	83.3 - 105	MPa	ASTM D638
Fracture, 23°C	105 - 132	MPa	ASTM D638
Fracture, 23°C	73.0 - 101	MPa	ISO 527-2
Tensile Elongation			
Yield, 23°C	1.0 - 3.5	%	ASTM D638
Fracture, 23°C	2.8 - 6.2	%	ASTM D638
Fracture, 23°C	1.0 - 6.2	%	ISO 527-2
Flexural Modulus			
23°C	2860 - 8280	MPa	ASTM D790
23°C	3980 - 8920	MPa	ISO 178
Flexural Strength			
23°C	77.2 - 187	MPa	ASTM D790

23°C	100 - 189	MPa	ISO 178
Yield, 23°C	130 - 196	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	9.8 - 21	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength (23°C)	35 - 45	kJ/m ²	ISO 179
Notched Izod Impact			
23°C	71 - 97	J/m	ASTM D256
23°C	7.9 - 10	kJ/m ²	ISO 180
Unnotched Izod Impact			
23°C	590 - 640	J/m	ASTM D256
23°C	30 - 36	kJ/m ²	ISO 180
Instrumented Dart Impact (23°C)	6.50 - 8.30	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	139 - 216	°C	ASTM D648
0.45 MPa, not annealed	133 - 212	°C	ISO 75-2/B
1.8 MPa, not annealed	107 - 210	°C	ASTM D648
1.8 MPa, not annealed	95.0 - 192	°C	ISO 75-2/A
Vicat Softening Temperature			
--	121 - 192	°C	ASTM D1525
--	129 - 212	°C	ISO 306
Linear thermal expansion coefficient			
Flow	1.6E-5 - 2.4E-5	cm/cm/°C	ASTM E831
Flow	2.0E-5 - 8.0E-5	cm/cm/°C	ISO 11359-2
Lateral	4.9E-5 - 1.1E-4	cm/cm/°C	ISO 11359-2
RTI Elec	75.0 - 140	°C	UL 746
RTI Imp	75.0 - 130	°C	UL 746
RTI	75.0 - 140	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity (23°C)	1.0 - 1.0E+17	ohms · cm	ASTM D257
Dielectric Strength			
23°C	19 - 29	kV/mm	ASTM D149
23°C	15 - 34	kV/mm	IEC 60243-1
Dielectric Constant			
23°C	3.48 - 4.00		ASTM D150
23°C	3.49		IEC 60250
Dissipation Factor (23°C)	1.4E-3 - 0.020		ASTM D150
Injection	Nominal Value	Unit	
Drying Temperature	110 - 121	°C	
Drying Time	3.0 - 6.1	hr	
Drying Time, Maximum	10	hr	
Suggested Shot Size	60 - 65	%	

Rear Temperature	242 - 261	°C
Middle Temperature	244 - 266	°C
Front Temperature	250 - 271	°C
Nozzle Temperature	250 - 266	°C
Processing (Melt) Temp	250 - 272	°C
Mold Temperature	60.0 - 90.0	°C
Back Pressure	0.448 - 0.517	MPa
Screw Speed	53 - 65	rpm
Vent Depth	0.017 - 0.032	mm

Injection instructions

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