

LNP™ STAT-KON™ WX06322 compound

Polybutylene Terephthalate

SABIC Innovative Plastics Asia Pacific

Message:

CF filled low warpage PBT Grade

General Information			
Filler / Reinforcement	Carbon Fiber		
Features	Low Warpage		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.55	g/cm ³	ASTM D792
Molding Shrinkage ¹			Internal Method
Flow	0.17	%	
Across Flow	0.55	%	
Mechanical	Nominal Value	Unit	Test Method
Flexural Modulus (6.40 mm)	11500	MPa	ASTM D790
Flexural Strength (Yield, 6.40 mm)	202	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	78	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	204	°C	ASTM D648
CLTE			ISO 11359-2
Flow : 23 to 60°C	1.3E-5	cm/cm/°C	
Transverse : 23 to 60°C	8.3E-5	cm/cm/°C	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.3E+6	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (2.00 mm)	V-0		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	3.0 to 4.0	hr	
Drying Time, Maximum	12	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 to 80	%	
Rear Temperature	238 to 254	°C	
Middle Temperature	243 to 260	°C	
Front Temperature	249 to 266	°C	
Nozzle Temperature	243 to 260	°C	

Processing (Melt) Temp	249 to 266	°C
Mold Temperature	65.6 to 87.8	°C
Back Pressure	0.345 to 0.689	MPa
Screw Speed	50 to 80	rpm
Vent Depth	0.025 to 0.038	mm

NOTE

1. 1.5 to 3.2 mm

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