

Sindustris PBT SV1121M

Polybutylene Terephthalate

Sincerity Australia Pty Ltd.

Message:

Sindustris PBT SV1121M is a Polybutylene Terephthalate (PBT) material. It is available in Asia Pacific for injection molding. Primary attribute of Sindustris PBT SV1121M: High Viscosity.
Typical applications include:
Film
Hose/Tubing
Optics/Lenses
Sheet

General Information			
Features	General Purpose		
	High Viscosity		
Uses	Film		
	Optical Applications		
	Sheet		
	Tubing		
UL File Number	E306922		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.31	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	1.2 to 2.1	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.080	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹			ASTM D638
Yield, 3.20 mm	53.9	MPa	
Break, 3.20 mm	47.1	MPa	
Tensile Elongation ² (Break, 3.20 mm)	> 200	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2450	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	83.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	39	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 6.40 mm	57.0	°C	
1.8 MPa, Unannealed, 6.40 mm	154	°C	

Peak Melting Temperature	225	°C	ASTM D3418
Injection	Nominal Value	Unit	
Drying Temperature	100 to 120	°C	
Drying Time	3.0 to 5.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	230 to 240	°C	
Middle Temperature	240 to 250	°C	
Front Temperature	245 to 255	°C	
Nozzle Temperature	245 to 255	°C	
Processing (Melt) Temp	225	°C	
Mold Temperature	40.0 to 80.0	°C	
Extrusion	Nominal Value	Unit	
Drying Temperature	100 to 120	°C	
Drying Time	3.0 to 5.0	hr	
Suggested Max Moisture	0.020	%	
Cylinder Zone 1 Temp.	225 to 245	°C	
Cylinder Zone 2 Temp.	230 to 250	°C	
Cylinder Zone 3 Temp.	240 to 260	°C	
Cylinder Zone 4 Temp.	240 to 260	°C	
Adapter Temperature	240 to 260	°C	
Melt Temperature	225	°C	
Die Temperature	230 to 260	°C	
NOTE			
1.	50 mm/min		
2.	50 mm/min		
3.	2.8 mm/min		
4.	2.8 mm/min		

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