

ColorFast® PBT100

Polybutylene Terephthalate

LTL Color Compounders, Inc.

Message:

General purpose injection molding grade unfilled PBT with lube

General Information			
Additive	Lubricant		
Features	General Purpose		
	Lubricated		
Uses	General Purpose		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.31	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	1.5 to 2.3	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	117		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	51.7	MPa	ASTM D638
Tensile Elongation ² (Break)	200	%	ASTM D638
Flexural Modulus ³	2340	MPa	ASTM D790
Flexural Strength ⁴	82.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	53	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.35 mm)	54.4	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	3.0 to 4.0	hr	
Drying Time, Maximum	12	hr	
Suggested Shot Size	40 to 60	%	
Rear Temperature	232 to 249	°C	
Middle Temperature	238 to 254	°C	
Front Temperature	243 to 260	°C	
Nozzle Temperature	238 to 254	°C	
Processing (Melt) Temp	243 to 260	°C	
Mold Temperature	48.9 to 76.7	°C	

Back Pressure	0.345 to 0.689	MPa
Screw Speed	40 to 70	rpm
Vent Depth	0.013 to 0.025	mm

NOTE		
1.	51 mm/min	
2.	51 mm/min	
3.	51 mm/min	
4.	51 mm/min	

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