

Later 4

Polybutylene Terephthalate
LATI S.p.A.

Message:
Polybutylene Terephthalate (PBT).

General Information			
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.32	g/cm ³	ISO 1183
Molding Shrinkage ¹			ISO 294-4
Across Flow : 2.00 mm	1.7 to 2.0	%	
Flow : 2.00 mm	1.7 to 2.0	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			ISO 527-2/1
23°C	2100	MPa	
60°C	650	MPa	
90°C	400	MPa	
120°C	350	MPa	
Tensile Stress (Yield, 23°C)	50.0	MPa	ISO 527-2/5
Tensile Strain (Yield, 23°C)	4.0	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	3.5	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	35	kJ/m ²	ISO 179/1eU
Notched Izod Impact (23°C, 3.20 mm)	40	J/m	ASTM D256A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	190	°C	ISO 75-2/B
1.8 MPa, Unannealed	65.0	°C	ISO 75-2/A
Continuous Use Temperature ²	120	°C	
Vicat Softening Temperature	195	°C	ISO 306/B50
CLTE - Flow (30 to 100°C)	1.1E-4	cm/cm/°C	ASTM D696
Injection	Nominal Value	Unit	
Drying Temperature	110 to 130	°C	
Drying Time	3.0	hr	
Processing (Melt) Temp	230 to 245	°C	
Mold Temperature	70.0 to 90.0	°C	
Injection Rate	Moderate		
NOTE			
1.	at 60 MPa of cavity pressure		

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