

TechnoDur PBT 4 black (9996)

Polybutylene Terephthalate

TechnoCompound GmbH

Message:

PBT, injection moulding, unfilled, medium viscosity, easy mould realise, for outdoor applications

General Information			
Features	Good demoulding performance		
	Medium viscosity		
Uses	Outdoor application		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.30	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (250°C/2.16 kg)	38.0	cm ³ /10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2600	MPa	ISO 527-2/1
Tensile Stress (Yield)	60.0	MPa	ISO 527-2/50
Tensile Strain			ISO 527-2/50
Yield	> 4.0	%	ISO 527-2/50
Fracture	> 10	%	ISO 527-2/50
Flammability	Nominal Value		Test Method
Flame Rating (0.800 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	120 - 140	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	240 - 260	°C	
Middle Temperature	240 - 260	°C	
Front Temperature	240 - 260	°C	
Nozzle Temperature	250 - 260	°C	
Processing (Melt) Temp	250 - 260	°C	
Mold Temperature	75.0 - 85.0	°C	
Injection Pressure	60.0 - 100	MPa	
Injection Rate	Fast		
Holding Pressure	40.0 - 80.0	MPa	
Back Pressure	1.00 - 3.00	MPa	

Screw Speed	80	rpm
Injection instructions		

Residence Time: 5 to 10 min

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