

ColorFast® FRPBT130

Polybutylene Terephthalate

LTL Color Compounders, Inc.

Message:

30% glass-filled V-0 rated PBT - UL listed

General Information			
UL YellowCard	E178307-226554		
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Additive	Flame Retardant		
Features	Flame Retardant		
UL File Number	E178307		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.14	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.50 to 0.80	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	119		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹			ASTM D638
Yield	117	MPa	
Break	186	MPa	
Flexural Modulus ²	7580	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	69	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.35 mm)	204	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating (0.830 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 Shot Size	40 to 60	%	
Rear Temperature	243 to 266	°C	
Middle Temperature	249 to 271	°C	
Front Temperature	254 to 277	°C	
Nozzle Temperature	249 to 271	°C	

Processing (Melt) Temp	254 to 277	°C
Mold Temperature	65.6 to 87.8	°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	

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