

Novalloy-B B1300, B1300F

Acrylonitrile Butadiene Styrene + PBT

Daicel Polymer Ltd.

Message:

Novalloy-B B1300, B1300F is an Acrylonitrile Butadiene Styrene + PBT (ABS+PBT) material. It is available in Asia Pacific.

General Information			
Physical	Nominal Value	Unit	Test Method
Density	1.12	g/cm ³	ISO 1183
Molding Shrinkage - Flow	0.50 to 0.80	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.15	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	38.0	MPa	ISO 527-2
Flexural Modulus	1800	MPa	ISO 178
Flexural Stress	57.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	10	kJ/m ²	ISO 179/1eA
Notched Izod Impact (23°C, 6.40 mm)	60	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 6.40 mm	100	°C	ASTM D648
0.45 MPa, Unannealed	100	°C	ISO 75-2/B
1.8 MPa, Unannealed, 6.40 mm	90.0	°C	ASTM D648
1.8 MPa, Unannealed	80.0	°C	ISO 75-2/A
CLTE - Flow	1.0E-4	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 120	°C	
Drying Time	3.0 to 5.0	hr	
Rear Temperature	190 to 230	°C	
Middle Temperature	220 to 240	°C	
Front Temperature	240 to 250	°C	
Nozzle Temperature	230 to 250	°C	
Mold Temperature	60.0 to 80.0	°C	
Back Pressure	5.00 to 20.0	MPa	
Screw Speed	50 to 90	rpm	

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