

TEKASTER™ F300

Polybutylene Terephthalate
Mando Advanced Materials Co., Ltd.

Message:
F300 is unreinforced Polybutylene terephthalate(PBT). F300 has high viscosity.

General Information			
Features	Viscosity, High		
Uses	Films		
	Pipe fittings		
	Sheet		

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.31	g/cm ³	ASTM D792
Molding Shrinkage - Flow	1.7 - 2.3	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.80	%	ASTM D570

Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break)	54.9	MPa	ASTM D638
Tensile Elongation ² (Break)	250	%	ASTM D638
Flexural Modulus ³	2550	MPa	ASTM D790
Flexural Strength ⁴	95.1	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	49	J/m	ASTM D256

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	155	°C	ASTM D648
1.8 MPa, not annealed	75.0	°C	ASTM D648
Peak Melting Temperature	221	°C	ASTM D3418

Flammability	Nominal Value	Test Method
Flame Rating	HB	UL 94

Injection	Nominal Value	Unit
Drying Temperature	80.0 - 120	°C
Drying Time	3.0 - 4.0	hr
Rear Temperature	230 - 250	°C
Middle Temperature	230 - 250	°C
Front Temperature	230 - 250	°C
Nozzle Temperature	240 - 260	°C
Processing (Melt) Temp	230 - 260	°C
Mold Temperature	60.0 - 80.0	°C

Injection instructions

Injection Speed: 30 to 70%Injection Pressure - 1st: 20 to 50%Injection Pressure - 2nd: 20 to 50%Injection Pressure - Back Pressure: 0 to 20%

NOTE

1.	50 mm/min
2.	50 mm/min
3.	3.0 mm/min
4.	3.0 mm/min

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