

Generic ABS+PBT - Glass Fiber

Acrylonitrile Butadiene Styrene + PBT

Generic

Message:

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This information is provided for comparative purposes only.

General Information			
Filler / Reinforcement	Glass fiber reinforced material		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.23 - 1.55	g/cm ³	ASTM D792
23°C	1.28 - 1.61	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/5.0 kg)	14 - 40	g/10 min	ASTM D1238
Molding Shrinkage - Flow (23°C)	0.20 - 0.67	%	ASTM D955
Water Absorption			
23°C, 24 hr	0.12 - 0.15	%	ASTM D570
23°C, 24 hr	0.15	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (23°C)	114 - 120		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
Yield, 23°C	67.1 - 123	MPa	ASTM D638
Yield, 23°C	78.8 - 120	MPa	ISO 527-2
Fracture, 23°C	77.5 - 112	MPa	ASTM D638
23°C	77.7 - 105	MPa	ASTM D638
Tensile Elongation			
Fracture, 23°C	1.5 - 4.4	%	ASTM D638
Fracture, 23°C	2.5 - 3.5	%	ISO 527-2
Flexural Modulus			
23°C	3180 - 10300	MPa	ASTM D790
23°C	3800 - 9770	MPa	ISO 178
Flexural Strength			
23°C	86.1 - 190	MPa	ASTM D790
23°C	114 - 171	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	5.9 - 8.2	kJ/m ²	ISO 179
Notched Izod Impact (23°C)	56 - 83	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			

0.45 MPa, not annealed	198 - 211	°C	ASTM D648
0.45 MPa, not annealed	196 - 220	°C	ISO 75-2/B
1.8 MPa, not annealed	104 - 202	°C	ASTM D648
1.8 MPa, not annealed	104 - 191	°C	ISO 75-2/A
Vicat Softening Temperature	100 - 218	°C	ISO 306
Linear thermal expansion coefficient			
Flow	2.8E-5 - 6.6E-5	cm/cm/°C	ASTM D696
Flow	2.0E-5 - 4.0E-5	cm/cm/°C	ISO 11359-2
Lateral	7.9E-5 - 1.0E-4	cm/cm/°C	ISO 11359-2
RTI Elec	59.0 - 140	°C	UL 746
RTI Imp	58.8 - 100	°C	UL 746
RTI	60.0 - 130	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity			
23°C	1.0E+15 - 1.0E+17	ohms·cm	ASTM D257
23°C	1.0E+15 - 2.5E+17	ohms·cm	IEC 60093
Dielectric Strength (23°C)	18 - 35	kV/mm	ASTM D149
Arc Resistance	69.0 - 85.5	sec	ASTM D495
Comparative Tracking Index	210 - 600	V	IEC 60112
High Amp Arc Ignition (HAI)	19.0 - 113		UL 746
High Voltage Arc Tracking Rate (HVTR)	1.20 - 188	mm/min	UL 746
Hot-wire Ignition (HWI)	13 - 51	sec	UL 746
Injection	Nominal Value	Unit	
Drying Temperature	85.0 - 111	°C	
Drying Time	4.0 - 5.0	hr	
Rear Temperature	210 - 255	°C	
Middle Temperature	230 - 255	°C	
Front Temperature	245 - 255	°C	
Nozzle Temperature	240 - 265	°C	
Processing (Melt) Temp	250 - 260	°C	
Mold Temperature	69.0 - 70.0	°C	
Injection Pressure	70.0 - 88.4	MPa	
Back Pressure	0.150 - 12.5	MPa	
Screw Speed	54 - 125	rpm	
Injection instructions			

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