

# Pocan<sup>®</sup> B1204

## PBT

Injection Molding, Unreinforced, Excellent Surface Properties

| PROPERTIES                                   | TYPICAL DATA | UNIT                   | TEST METHOD    |
|----------------------------------------------|--------------|------------------------|----------------|
| <b>RHEOLOGICAL PROPERTIES</b>                |              | VALUE                  |                |
| Melt volume–flow rate                        | 60           | cm <sup>3</sup> /10min | ISO 1133       |
| Temperature                                  | 260          | °C                     | ISO 1133       |
| Load                                         | 2.16         | kg                     | ISO 1133       |
| Molding shrinkage (normal)                   | 2            | %                      | ISO 294–4      |
| Molding shrinkage (parallel)                 | 2            | %                      | ISO 294–4      |
| <b>MECHANICAL PROPERTIES</b>                 |              | VALUE                  |                |
| Tensile modulus                              | 2600         | MPa                    | ISO 527–1/–2   |
| Yield stress                                 | 60           | MPa                    | ISO 527–1/–2   |
| Yield strain                                 | 9            | %                      | ISO 527–1/–2   |
| Flexural modulus                             | 2700         | MPa                    | ISO 178        |
| Flexural strength                            | 90           | MPa                    | ISO 178        |
| Flexural strain at flexural strength         | 6            | %                      | ISO 178–A      |
| Charpy impact strength (+23°C)               | 180          | kJ/m <sup>2</sup>      | ISO 179/1eU    |
| Charpy notched impact strength (+23°C)       | 3            | kJ/m <sup>2</sup>      | ISO 179/1eA    |
| Izod impact strength (+23°C)                 | 125          | kJ/m <sup>2</sup>      | ISO 180/1U     |
| <b>THERMAL PROPERTIES</b>                    |              | VALUE                  |                |
| Melting temperature (10°C/min)               | 225          | °C                     | ISO 11357–1/–3 |
| Temp. of deflection under load (1.80 MPa)    | 70           | °C                     | ISO 75–1/–2    |
| Temp. of deflection under load (0.45 MPa)    | 160          | °C                     | ISO 75–1/–2    |
| Coeff. of linear therm. expansion (parallel) | 1.11         | E–4/°C                 | ISO 11359–1/–2 |
| Coeff. of linear therm. expansion (normal)   | 1.07         | E–4/°C                 | ISO 11359–1/–2 |



Property Data

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| PROPERTIES                             | TYPICAL DATA | UNIT  | TEST METHOD     |
|----------------------------------------|--------------|-------|-----------------|
| Burning Behav. at 0.75 mm nom. thickn. | HB           | class | IEC 60695-11-10 |
| Thickness tested                       | 0.75         | mm    | IEC 60695-11-10 |
| Burning Behav. at 1.5 mm nom. thickn.  | HB           | class | IEC 60695-11-10 |
| Thickness tested                       | 1.5          | mm    | IEC 60695-11-10 |
| Burning Behav. at 3.0 mm nom. thickn.  | HB           | class | IEC 60695-11-10 |
| Thickness tested                       | 3            | mm    | IEC 60695-11-10 |

| OTHER PROPERTIES | VALUE |       |          |
|------------------|-------|-------|----------|
| Density          | 1310  | kg/m³ | ISO 1183 |

| PROCESSING RECOMMENDATIONS               | VALUE     |    |                      |
|------------------------------------------|-----------|----|----------------------|
| Drying temperature circulating air dryer | 120       | °C |                      |
| Drying time circulating air dryer        | 4-8       | h  |                      |
| Residual moisture content                | 0.00-0.02 | %  | acc. to Karl Fischer |
| Melt temperature (Tmin – Tmax)           | 250-270   | °C |                      |
| Mold temperature                         | 80-100    | °C |                      |

