

SPESIN[®] KP211DC

PBT, Unreinforced, Injection molding

Application

Auto(Head lamp bezel), E&E

Properties	Measurement condition	Test Method	Unit	Typical value
Physical				
Density		ASTM D792	—	1.31
Shrinkage		ASTM D955	%	1.4~2.0
Water Absorption	23℃, H ₂ O, 24hr	ASTM D570	%	0.07
Mechanical				
Tensile Strength at Break (3.2mm)	50 mm/min	ASTM D638	MPa	60
Elongation at Break (3.2mm)	50 mm/min	ASTM D638	%	20
Flexural Strength (3.2mm)	5 mm/min	ASTM D790	MPa	98
Flexural Modulus (3.2mm)	5 mm/min	ASTM D790	MPa	2,750
Izod Impact Strength (6.4mm)		ASTM D256		
(Notched)	23 ℃		J/m	50
	-30 ℃		J/m	—
Thermal				
Melting Point	20 ℃/min	ASTM D1525	℃	224
Heat Deflection Temperature	0.45 MPa	ASTM D648	℃	180
	1.82 MPa	ASTM D648	℃	60
Flammability (0.8mm)		UL94	Class	HB



Processing Guide (Injection Molding)

Drying Temperature(℃)	100~120	(Dehumidifying Dryer)			
Drying Time(hr)	3~5				
Processing Moisture Contents(%)	≤ 0.04				
Cylinder Temperature(℃)	Nozzle	Front	Middle	Rear	
	235~250	235~255	230~245	220~235	
Mold Temperature(℃)	30~70				

