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NOVADURAN -PBT-

				GF Reinforced Flame Retardant type-1
Properties	Test Method	Terms	Units	5010GN6-15M8AM
				Low Outgas
				GF
				15
Physical properties				
Density	ISO 1183	-	g/cm³	1.55
Water absorption	-	23degC, Underwater	%	0.07
Demensional properties				
Moulding shrinkage (100×100×2mmt)	-	MD	%	0.7
		TD		1.6
Mechanical properties				
Tensile modulus	ISO 527-1 , 527-2	-	MPa	6700
Yield stress				-
Yield strain			%	-
Nominal strain at break				-
Stress at 50% strain			MPa	-
Stress at break				110
Strain at break			%	3
Flexural strength	ISO 178	-	MPa	160
Flexural modulus				2250
Charpy impact strength	ISO 179-1 , 179-2	23 degC	kJ/m²	30
Charpy notched impact strength		23 degC	kJ/m²	7
Thermal properties				
Melting temperature	ISO 11357-3		degC	224
Temperature of deflection under load	ISO 75-1 , 75-2	1.80MPa	degC	198
		0.45MPa		218
Coefficient of Linear thermal expansion	ISO 11359-2	MD : -30～120degC	1/degC*10^-5	3
		MD : -30～50degC		3
		MD : 50～120degC		3
		TD : -30～120degC		12
		TD : -30～50degC		9
		TD : 50～120degC		16
Flammability	UL94	-	-	V-0 (0.75mmt)
Electrical properties				
Relative permittivity	IEC 60250	1MHz	-	3.7
Dissipation factor	IEC 60250	1MHz	-	0.017
Volume resistivity	IEC 60093	-	ohm-m	3E+14
Surface resistivity	IEC 60093	-	ohm	4E+16
Electric strength	IEC 60243-1	1mmt	MV/m	23
		2mmt		-
		3mmt		-

Comparative tracking index	UL746A	-	-	PLC 2
Note				
Molding conditions -Examples of recommended molding conditions are shown below.-				
Drying of feedstock resin				Hot air drying at 120℃ ---5 to 8 hours at 140℃ ---about 4 hours
Cylinder temp (rear)			℃	235
Cylinder temp (center)			℃	240
Cylinder temp (front)			℃	255
Nozzle temp			℃	250
Mold temp			℃	80-100
Injection pressure			MPa	20-150
Screw rotation			rpm	80-120

