

PRECITE®

V GF 30 2 black (7724)

PBT+ASA GF30

PRECITE® V GF 30 2 black (7724) is a 30% glass fibre reinforced, UV-stabilised PBT/ASA blend with low warpage and good surface quality. Compared to neat PBT, this grade has a lower density and is suitable for precision parts in the automotive, E&E and household goods industries.

Features

UV-stabilised low warpage reduced density

Properties

Modulus

9.500 MPa

Strength

130 MPa

Impact

60 kJ/m²

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

9500 MPa

Tensile stress at break

ISO 527-2

5 mm/min | d.a.m.

130 MPa

Tensile strain at break

ISO 527-2

5 mm/min | d.a.m.

2,2 %

Charpy impact strength

ISO 179-1/1eU

23°C | d.a.m.

60 kJ/m²

-40°C | d.a.m.

42 kJ/m²

Charpy notched impact strength

ISO 179-1/1eA

23°C | d.a.m.

9 kJ/m²

-40°C | d.a.m.

8 kJ/m²

Thermal Properties

Melting temperature

ISO 11357-3

DSC, 10K/min

225 °C

Flammability

Flammability

UL 94

0,8 mm Wall thickness

HB Class

General Properties

Density

ISO 1183

23°C

1,43 g/cm³

Humidity absorption

ISO 1110

70°C, 62% r.H.

0,1 - 0,3 %

Molding shrinkage

ISO 294-4

flow

0,2 - 0,4 %

transverse

0,5 - 0,7 %

Rheological Properties

MVR

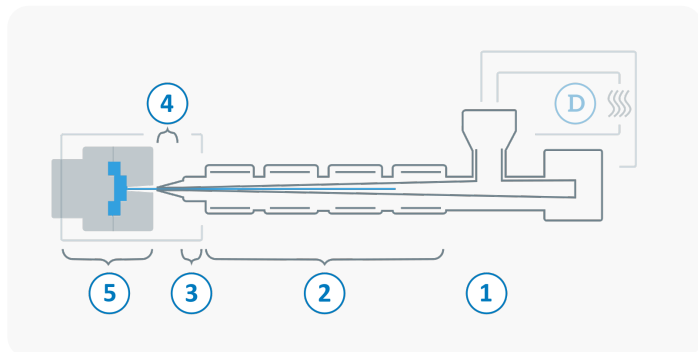
ISO 1133

250°C/2,16kg

5 cm³/10 min

Processing

The values mentioned are recommendations. We only recommend desiccant / dry air dryers or vacuum dryers. Too long a drying time and the resulting residual moisture content below the lower limit can lead to filling problems and surface defects. The specified drying time refers to closed and undamaged bagged material. When processing from previously opened bags or from octabins with polyolefin inliners, a longer drying time may be necessary. It is recommended to check the residual moisture content after the drying process.



D	Drying time	3 - 4 h
	Drying temperature ($\tau \leq -30^{\circ}\text{C}$)	100 - 120 $^{\circ}\text{C}$
	Processing moisture	0,02 - 0,04 %
1	Feed section	60 - 80 $^{\circ}\text{C}$
2	Temperature Zone 1 - Zone 4	250 - 275 $^{\circ}\text{C}$
3	Nozzle temperature	250 - 280 $^{\circ}\text{C}$
4	Melt temperature	260 - 275 $^{\circ}\text{C}$
5	Mold temperature	80 - 100 $^{\circ}\text{C}$
→	Holding pressure, spec.	300 - 800 bar
←	Back pressure, spec.	30 - 100 bar
	Injection speed	medium to high
	Screw speed	8 - 15 m/min

Diagrams

