

Compound No.: 8270

66 kJ/m<sup>2</sup>

11 kJ/m<sup>2</sup>

# PRECITE® PRELIMINARY K GF 50 ECO black (8270)

PBT-PET- GF 50

PRECITE® K GF 50 ECO black (8270) is a 50% glass fibre reinforced PBT/PET blend with high strength and improved surface finish. Due to its low moisture absorption, this material is particularly suitable for precision parts in the automotive, E&E or appliances industries. The formulations of the sustainable ECO products are partly based on regenerated post-consumer feedstock and thus contribute to reducing the consumption of valuable raw materials.

#### **Features** surface modified recycled content E&E Sports & leisure **Properties** Modulus Strength **Impact 17.000** MPa **180** MPa 66 kJ/m<sup>2</sup>

23°C | d.a.m.

23°C | d.a.m.

#### **Sustainability**

Recycled content		20 %
Mechanical Properties		
Tensile modulus ISO 527-2	1 mm/min   d.a.m.	17000 MPa
Tensile stress at break ISO 527-2	5 mm/min   d.a.m.	180 MPa
Tensile strain at break ISO 527-2	5 mm/min   d.a.m.	1,8 %
Charpy impact strength	23°C   d a m	66 kl/m²

ISO 179-1/1eU

ISO 179-1/1eA

Charpy notched impact strength



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### **Thermal Properties**

Temperature of deflection under load HDT/A ISO 75	1,8 MPa	210 °C
Melting temperature ISO 11357-3	DSC, 10K/min	245 °C

## **Flammability**

Flammability UL 94	0,8 mm Wall thickness	HB Class

### **General Properties**

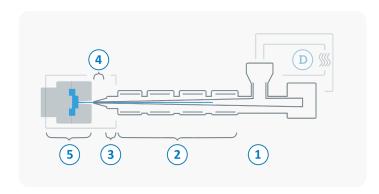
Density ISO 1183	23°C	1,74 g/cm³
Humidity absorption ISO 1110	70°C, 62% r.H.	0,1 - 0,3 %
Molding shrinkage	flow	0,2 - 0,4 %
ISO 294-4	transverse	0,7 - 0,9 %





#### **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 (τ <= -30°C)	120 - 140 °C
	Processing moisture	d0,02 %
1	Feed section	60 - 80 °C
2	Temperature Zone 1 - Zone 4	260 - 280 °C
3	Nozzle temperature	260 - 290 °C
4	Melt temperature	270 - 280 °C
5	Mold temperature	80 - 100 °C
$\bigcirc$	Holding pressure, spec.	300 - 800 bar
	Back pressure, spec.	30 - 100 bar
	Injection speed	medium to high
	Screw speed	8 - 15 m/min



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### **Diagrams**

