

PRECITE® PRELIMINARY

K GF 30 natural (7437)

PBT-PET- GF 30

PRECITE® K GF 30 natural (7437) is a 30% glass fibre reinforced PBT/PET blend with high strength and improved surface finish.

Properties

Modulus

10.800 MPa

Strength

170 MPa

Impact

60 kJ/m²

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

10800 MPa

Tensile stress at break

ISO 527-2

5 mm/min | d.a.m.

170 MPa

Tensile strain at break

ISO 527-2

5 mm/min | d.a.m.

2,5 %

Charpy impact strength

ISO 179-1/1eU

23°C | d.a.m.

60 kJ/m²

Charpy notched impact strength

ISO 179-1/1eA

23°C | d.a.m.

11 kJ/m²

Flammability

Flammability

UL 94

0,8 mm Wall thickness

HB Class

General Properties

Density

ISO 1183

23°C

1,56 g/cm³

Molding shrinkage

ISO 294-4

flow

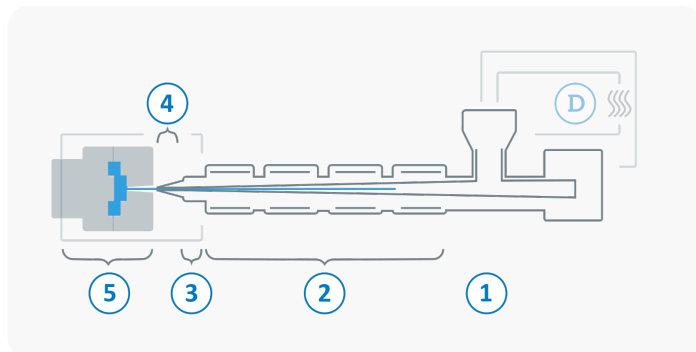
0,2 - 0,4 %

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 ($\tau \leq -30^{\circ}\text{C}$)	120 - 140 °C
Processing moisture	0,02 %
(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
(→) Holding pressure, spec.	300 - 800 bar
(←) Back pressure, spec.	30 - 100 bar
Injection speed	medium to high
Screw speed	8 - 15 m/min

Diagrams

