+135-3858-6433 (GuangDong)
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AKRO COMPOUNDS

Compound No.: **7435**

PRECITE® PRELIMINARY
K GF 50 natural (7435)

PBT-PET- GF 50

PRECITE® K GF 50 natural (7435) is a 50% glass fibre reinforced PBT/PET blend with very 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.

Features

surface modified | reduced moisture | E&E | Sports & leisure

Properties

Modulus	Strength	Impact
20.000 MPa	**175** MPa	**60** kJ/m²

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min | d.a.m.	**20000 MPa**
Tensile stress at break ISO 527-2	5 mm/min | d.a.m.	**175 MPa**
Tensile strain at break ISO 527-2	5 mm/min | d.a.m.	**1,3 %**
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.	**18 kJ/m²**

Thermal Properties

Melting temperature ISO 11357-3	DSC, 10K/min	**250 °C**

General Properties

Density ISO 1183	23°C	**1,75 g/cm³**

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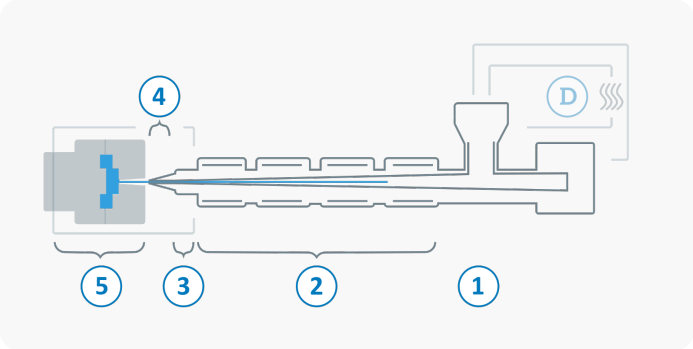
Processing

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	≤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

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Diagrams