

Pocan® B3215XF 000000

PBT-GF10

Envalior

Injection Molding, 10% Glass Reinforced, Improved flow, Improved Impact

ISO 1043 PBT-GF10

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	32	cm³/10min	ISO 1133
Temperature	260	°C	-
Load	2.16	kg	-
Molding shrinkage, parallel	0.9	%	ISO 294-4, 2577
Molding shrinkage, normal	1.1	%	ISO 294-4, 2577

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	4350	MPa	ISO 527
Stress at Break	80	MPa	ISO 527
Strain at Break	4	%	ISO 527
Impact Strength (Charpy), +23°C	40	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	30	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	10	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	10	kJ/m²	ISO 179/1eA

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	225	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	185	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	215	°C	ISO 75-1/-2
Coeff. of Linear Therm. Expansion, parallel	60	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	140	E-6/K	ISO 11359-1/-2

Electrical Properties	Value	Unit	Test Standard
ISO Data			
Comparative tracking index	350	-	IEC 60112

Other Properties	Value	Unit	Test Standard
ISO Data			
Density	1350	kg/m³	ISO 1183

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	260	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294

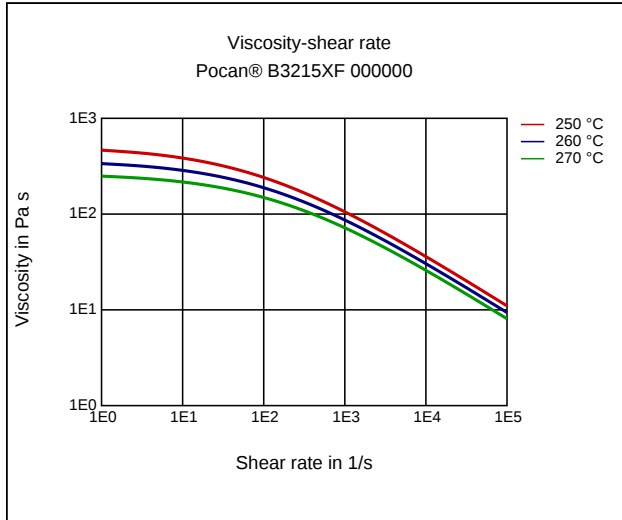
Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	120	°C	-
Pre-drying - Time	4 - 8	h	-
Processing humidity	≤0.02	%	-
Melt temperature	250 - 270	°C	-
Mold temperature	80 - 100	°C	-

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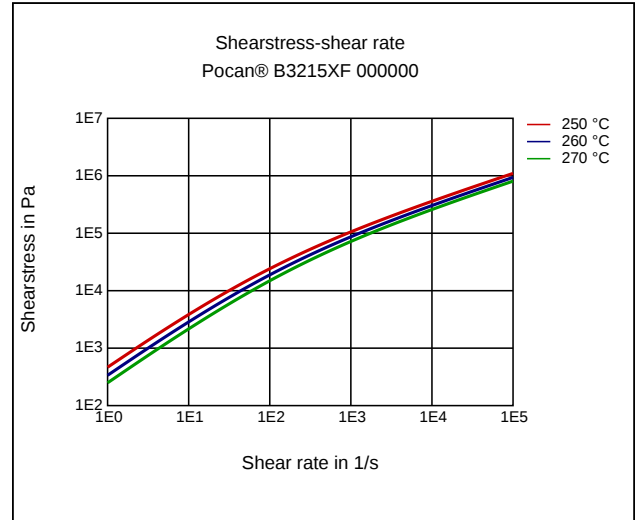
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Diagrams

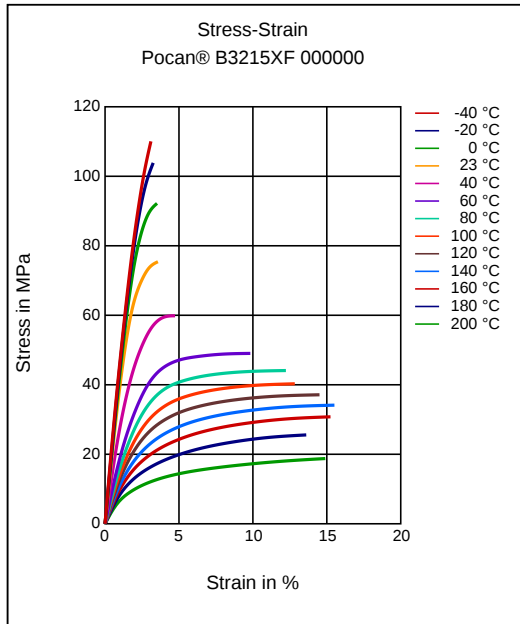
Viscosity-shear rate



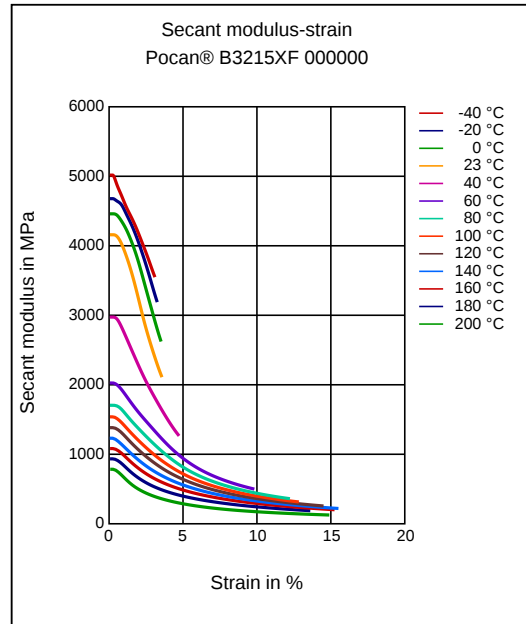
Shearstress-shear rate



Stress-strain



Secant modulus-strain

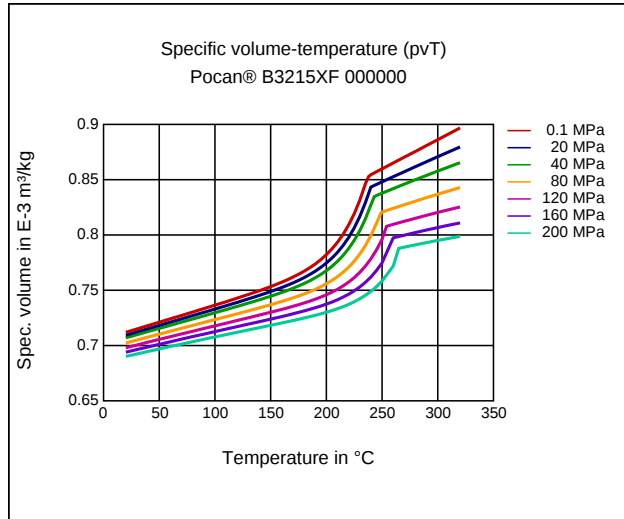


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Specific volume-temperature (pvT)



Characteristics

Processing

Injection Molding

Delivery form

Pellets

Special Characteristics

Impact modified, Heat aging stabilized

Injection Molding

PREPROCESSING

Residual moisture content: 0.00 - 0.02 %

Drying temperature circulating air dryer: 120 °C

Drying time circulating air dryer: 4 - 8 h

PROCESSING

Melt temperature (Tmin - Tmax): 250 - 270 °C

Mold temperature: 80 - 100 °C