

Pocan® B1204 000000
PBT

Envalior

Injection Molding, Unreinforced, Excellent Surface Properties

ISO 1043 PBT

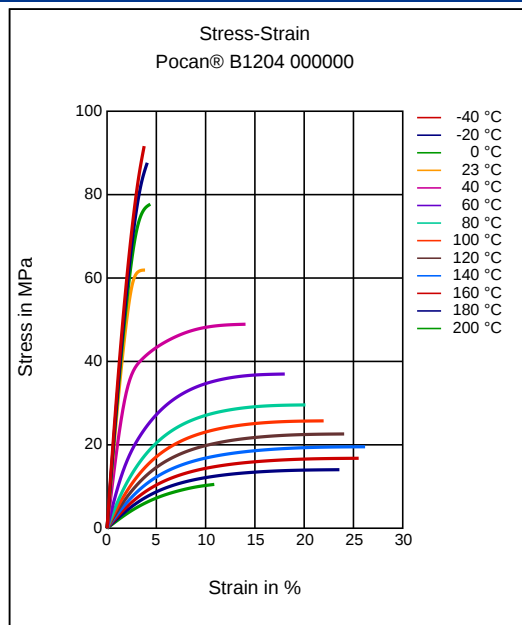
Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	60	cm ³ /10min	ISO 1133
Temperature	260	°C	-
Load	2.16	kg	-
Molding shrinkage, parallel	2.0	%	ISO 294-4, 2577
Molding shrinkage, normal	2.0	%	ISO 294-4, 2577
Mechanical Properties			
ISO Data			
Tensile Modulus	2600	MPa	ISO 527
Yield stress	60	MPa	ISO 527
Yield strain	9	%	ISO 527
Impact Strength (Charpy), +23°C	180	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	10	kJ/m ²	ISO 179/1eA
Thermal Properties			
ISO Data			
Melting Temperature (10°C/min)	225	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	70	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	160	°C	ISO 75-1/-2
Coeff. of Linear Therm. Expansion, parallel	111	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	107	E-6/K	ISO 11359-1/-2
Other Properties			
ISO Data			
Density	1310	kg/m ³	ISO 1183
Test specimen production			
ISO Data			
Injection Molding, melt temperature	250	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294
Processing Recommendation Injection Molding			
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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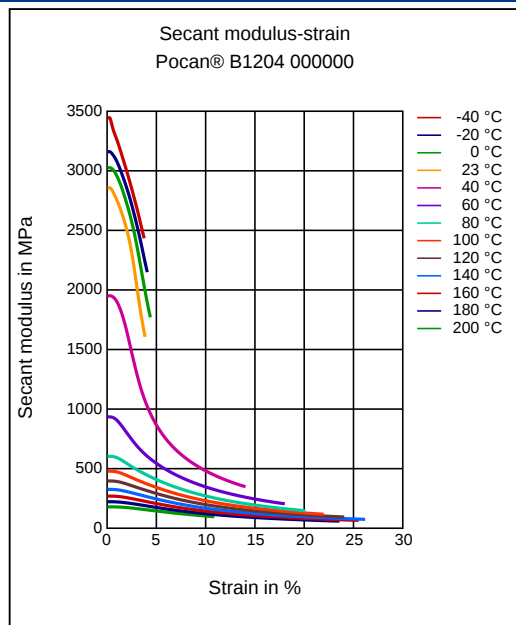
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Diagrams

Stress-strain



Secant modulus-strain



Characteristics

Processing

Injection Molding

Delivery form

Pellets

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