

Pocan® KL1-7033 000000
PBT-I-GF30

Envalior

Injection Molding, 30% Glass Reinforced, Improved Impact

ISO 1043 PBT-I-GF30

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	13	cm ³ /10min	ISO 1133
Temperature	260	°C	-
Load	5	kg	-
Molding shrinkage, parallel	0.4	%	ISO 294-4, 2577
Molding shrinkage, normal	0.9	%	ISO 294-4, 2577

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	8000	MPa	ISO 527
Stress at Break	95	MPa	ISO 527
Strain at Break	4	%	ISO 527
Impact Strength (Charpy), +23°C	65	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy), -30°C	65	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	12	kJ/m ²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	10	kJ/m ²	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)	195	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	220	°C	ISO 75-1/-2
Coeff. of Linear Therm. Expansion, parallel	30	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	100	E-6/K	ISO 11359-1/-2
Burning Behav. at 1.5 mm Nom. Thickn.	HB	class	UL 94
Thickness tested	1.5	mm	-
Oxygen index	21	%	ISO 4589-1/-2

Electrical Properties	Value	Unit	Test Standard
ISO Data			
Relative permittivity, 100Hz	4.6	-	IEC 62631-2-1
Relative permittivity, 1MHz	3.9	-	IEC 62631-2-1
Dissipation Factor, 100Hz	60	E-4	IEC 62631-2-1
Dissipation Factor, 1MHz	260	E-4	IEC 62631-2-1
Surface Resistivity	>1E15	Ohm	IEC 62631-3-2
Electric Strength	28	kV/mm	IEC 60243-1
Comparative tracking index	600	-	IEC 60112

Other Properties	Value	Unit	Test Standard
ISO Data			
Water Absorption	0.4	%	Sim. to ISO 62
Humidity absorption	0.2	%	Sim. to ISO 62
Density	1460	kg/m ³	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	-

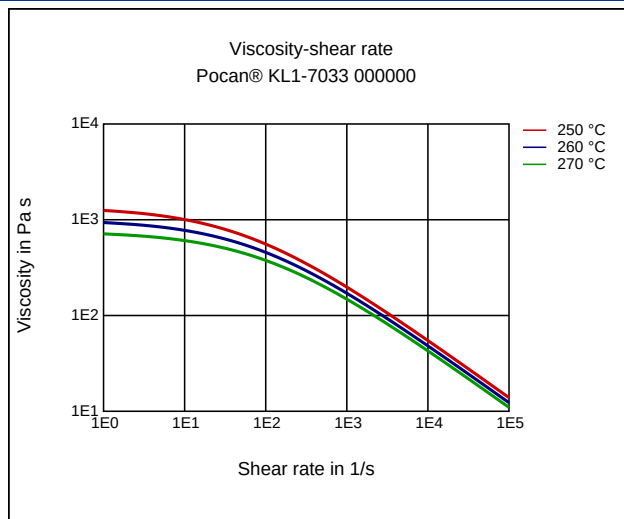
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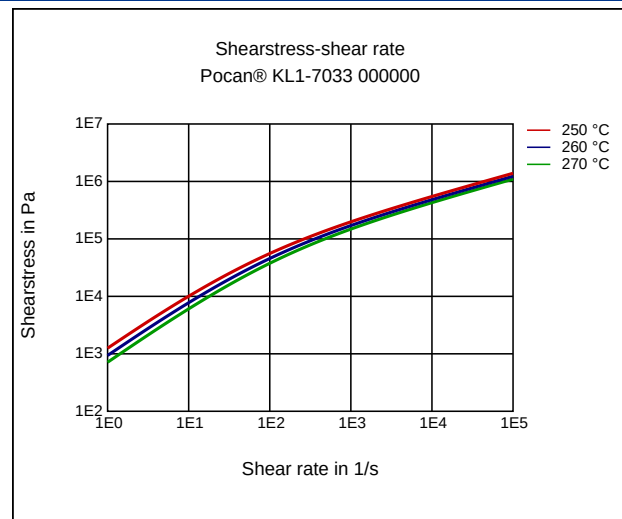
Envalior

Diagrams

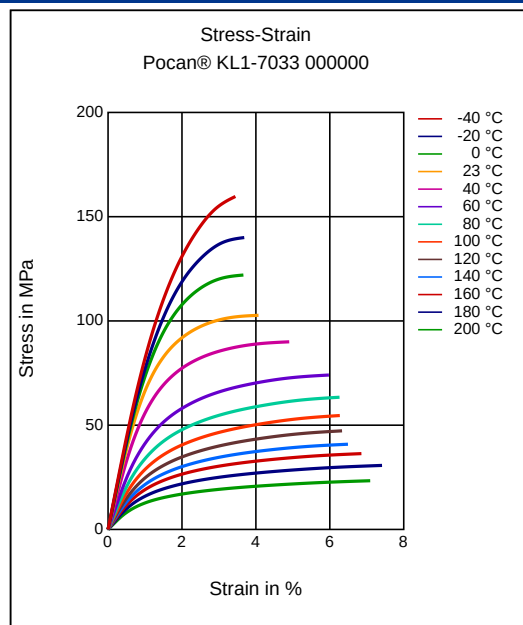
Viscosity-shear rate



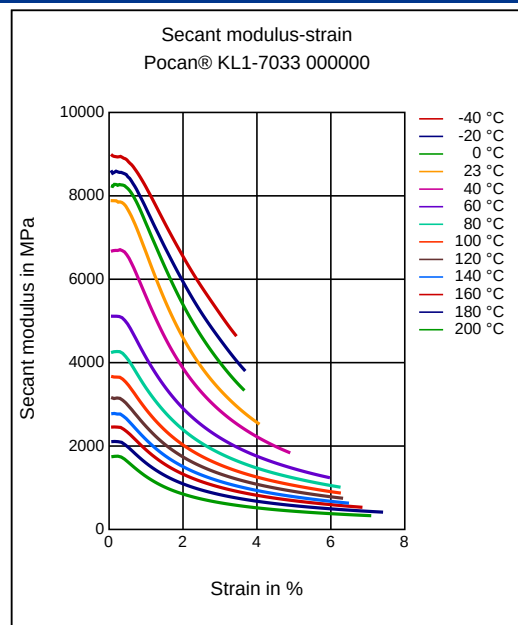
Shearstress-shear rate



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

Special Characteristics

Impact modified, Heat aging stabilized