

**Plaslube® PBT-1850/TF/20 Natl**

Techmer Polymer Modifiers - *Polybutylene Terephthalate*

**General**

Material Status	<ul style="list-style-type: none"> <li>Commercial: Active</li> </ul>
Availability	<ul style="list-style-type: none"> <li>North America</li> </ul>
Additive	<ul style="list-style-type: none"> <li>Lubricant</li> </ul>
Features	<ul style="list-style-type: none"> <li>Lubricated</li> </ul>
Appearance	<ul style="list-style-type: none"> <li>Natural Color</li> </ul>
Processing Method	<ul style="list-style-type: none"> <li>Injection Molding</li> </ul>

**Properties <sup>1</sup>**

<b>Physical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Density / Specific Gravity	1.41		ASTM D792
Molding Shrinkage - Flow (0.125 in)	7.0E-3 to 9.0E-3	in/in	ASTM D955
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Modulus	362000	psi	ISO 527-1
Tensile Stress (Yield)	6100	psi	ISO 527-2
Tensile Stress (Break)	6000	psi	ISO 527-2
Tensile Strain (Break)	7.0	%	ISO 527-2
Flexural Modulus	334000	psi	ISO 178
Flexural Stress	10300	psi	ISO 178
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact (0.125 in)	0.30	ft·lb/in	ISO 180/1A

**Processing Information**

<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	410 to 450	°F
Middle Temperature	420 to 460	°F
Front Temperature	430 to 470	°F
Nozzle Temperature	440 to 480	°F
Processing (Melt) Temp	420 to 480	°F
Mold Temperature	100 to 175	°F
Injection Rate	Moderate-Fast	
Back Pressure	50.0 to 100	psi
Screw Speed	Moderate-Fast	

