

Plaslube® PBT GF/B25 TL5 LE

Techmer Polymer Modifiers - *Polybutylene Terephthalate*

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Bead\Glass Fiber, 25% Filler by Weight
Additive	• Lubricant
Features	• Lubricated
Appearance	• Natural Color
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.57		ASTM D792
Molding Shrinkage - Flow (0.125 in)	8.0E-3 to 0.011	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	810000	psi	ASTM D638
Tensile Strength (Yield)	9500	psi	ASTM D638
Tensile Strength (Break)	9500	psi	ASTM D638
Tensile Elongation (Break)	3.5	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.70	ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	450 to 480	°F
Middle Temperature	460 to 490	°F
Front Temperature	470 to 500	°F
Nozzle Temperature	480 to 510	°F
Processing (Melt) Temp	465 to 515	°F
Mold Temperature	125 to 200	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow	

