

Plaslube® PBT-1850/TF/20 NatI

 Techmer Polymer Modifiers - *Polybutylene Terephthalate*
General Information
General

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

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.41		ASTM D792
Molding Shrinkage - Flow (0.125 in)	7.0E-3 to 9.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
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
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.30	ft·lb/in	ISO 180/1A

Processing Information

Injection	Nominal Value	Unit
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	

