

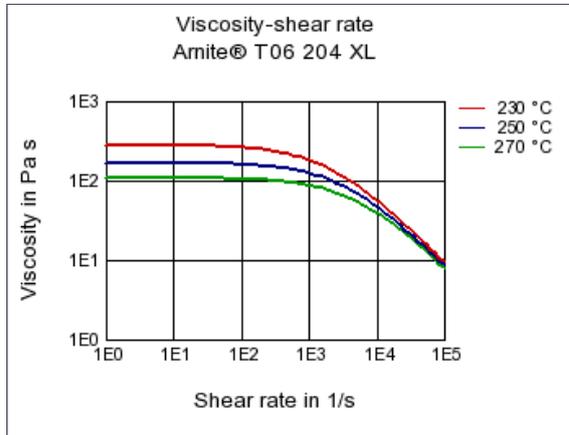


<b>Arnite® T06 204 XL</b>			
<b>PBT</b>		DSM Engineering Plastics	
<b>Product Texts</b>			
Low Viscosity, Injection Molding, Low Outgassing			
ISO 1043 PBT			
<b>Rheological properties</b>			
	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Melt volume-flow rate, MVR	50	cm <sup>3</sup> /10min	ISO 1133
Temperature	250	°C	ISO 1133
Load	2.16	kg	ISO 1133
<b>Mechanical properties</b>			
	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Tensile Modulus	2700	MPa	ISO 527-1/-2
Yield stress	62	MPa	ISO 527-1/-2
Yield strain	8.5	%	ISO 527-1/-2
Nominal strain at break	12	%	ISO 527-1/-2
Charpy impact strength (+23°C)	N	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength (+23°C)	3.5	kJ/m <sup>2</sup>	ISO 179/1eA
<b>Thermal properties</b>			
	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Melting temperature (10°C/min)	225	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	60	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	170	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	90	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	90	E-6/K	ISO 11359-1/-2
Burning behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.5	mm	IEC 60695-11-10
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	0.8	mm	IEC 60695-11-10
<b>Electrical properties</b>			
	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Relative permittivity, 100Hz	3.5	-	IEC 60250
Relative permittivity, 1MHz	3.2	-	IEC 60250
Dissipation factor, 100Hz	20	E-4	IEC 60250
Dissipation factor, 1MHz	200	E-4	IEC 60250
Volume resistivity	>1E13	Ohm*m	IEC 60093
Electric strength	27	kV/mm	IEC 60243-1
Comparative tracking index	600	-	IEC 60112
<b>Other properties</b>			
	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Water absorption	0.45	%	Sim. to ISO 62
Humidity absorption	0.18	%	Sim. to ISO 62
Density	1300	kg/m <sup>3</sup>	ISO 1183
<b>Rheological calculation properties</b>			
	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Density of melt	1040	kg/m <sup>3</sup>	-
Thermal conductivity of melt	0.109	W/(m K)	-

Spec. heat capacity of melt	2260	J/(kg K)	-
Eff. thermal diffusivity	4.65E-8	m²/s	-

Diagrams

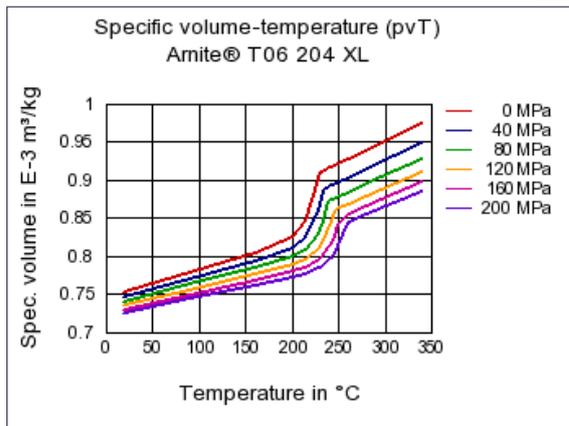
Viscosity-shear rate



Shearstress-shear rate



Specific volume-temperature (pvT)



Characteristics

Processing

Injection Molding

Additives

Release agent

Delivery form

Pellets

Other text information

Injection Molding

[Injection Molding Recommendations](#)