

# Technical information

## TEREZ<sup>®</sup> PBT 6750/2 T GK 20

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PBT standard type with medium viscosity with 20% glass beads filled impact modified.



## TECHNICAL DATA SHEET

### Product text

For all kind of injection molding parts with increased dimensional stability and tendency to warpage.

Properties	Value	Unit	Test method
Density	1,3800	g/cm <sup>3</sup>	ISO 1183
Impact strength Charpy (Notched 23°C), dry	8	kJ/m <sup>2</sup>	ISO 179
Elongation at yield, dry	2,30	%	ISO 527
Tensile-modulus, dry	2700	MPa	ISO 527
Tensile stress at break, dry	41	MPa	ISO 527
Elongation at break, dry	12,00	%	ISO 527
Tensile strength, dry	43	MPa	ISO 527
HDT 0,45 MPa	155	°C	ISO 75
HDT 1,80 MPa	65	°C	ISO 75
Burning Behav. at thickness h	HB	class	UL 94
Thickness tested	1,6	mm	UL 94
UL recognition	-		UL 94
Water absorption	0,40	%	ISO 62
Moisture absorption	0,20	%	ISO 62

## PROCESSING DATA SHEET

### Processing guidelines for injection molding of TEREZ PBT 6750/2 T GK 20

The processing data sheet provides guidelines about processing as well as pre-drying.

#### MATERIAL PREPARATION

##### Storage

Store in a dry place protected from direct sunlight. Avoid all sources of ignition like extreme heat, sparks, or open flame.

##### Drying

For the manufacturing of mechanically and optically optimal injection molding parts, we recommend following pre-drying conditions according to the table below. If the container is open (wet granules), the drying time can be extended accordingly.

##### Dry air dryer

Temperature	120°C
Time	3 - 6 hours
Due point	-40°C

##### Residual moisture

<= 0.03% (recommended)

#### MACHINE REQUIREMENTS

#### PROCESSING

##### Basic settings

The following basic settings are generally to be selected:

##### Temperatures

##### Processing temperatures

Hopper	60 - 80°C
Center	250 - 265°C
Nozzle	265 - 280°C

##### Mold temperature

Temp.	60 - 100°C
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##### Residence time

You should try to keep the residence time short, especially at high temperatures to avoid material degradation.

##### Instructions for cleaning

The unit can be cleaned with standard cleaning granules.