



2079 Center Square Road  
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**TECHNICAL DATA AND PROCESS SHEET**

**20% GLASS FIBER REINFORCED PBT**

**INSTRUC PBTGF20**

**TYPICAL PROPERTIES**

<b>PROPERTY</b>	<b>ASTM METHOD</b>	<b>English</b>	<b>UNITS</b>	<b>Metric SI</b>	<b>UNITS</b>
<b>GENERAL</b>					
SPECIFIC GRAVITY	D792	1.45		1.45	
SPECIFIC VOLUME		19.10	in <sup>3</sup> /lb	0.690	cm <sup>3</sup> /gm
WATER ABSORPTION (24 Hrs)	D570	0.08	%	0.08	%
MOLD SHRINKAGE	D955	0.2-0.6	%	0.2-0.6	%
<b>MECHANICAL</b>					
TENSILE STRENGTH	D638	15,500	psi	107	MPa
ELONGATION, YIELD	D638	3-5	%	3-5	%
FLEXURAL STRENGTH	D790	23,500	psi	162	MPa
FLEXURAL MODULUS	D790	820,000	psi	5,654	MPa
SHEAR STRENGTH	D732				
IZOD IMPACT STRENGTH	D256				
NOTCHED 1/8"		1.5	ft.lb./in.	80	J/m
UNNOTCHED 1/8"		12	ft.lb./in.	640	J/m
ROCKWELL HARDNESS		M82	M Scale	M82	M Scale
<b>THERMAL</b>					
HDTUL @ 264 PSI	D648	400	°F	204	°C
COEFFICIENT OF LINEAR THERMAL EXPANSION	D696	1.4	in./in. F x10 <sup>-5</sup>	2.52	mm/mm C 10 <sup>-6</sup>
FLAMMABILITY <sup>1</sup>	U.L.Subj 94	HB@1/16	in	HB@ 1.5	mm
<b>ELECTRICAL</b>					
SURFACE RESISTIVITY		10e <sup>16</sup>	ohms/sq	10e <sup>16</sup>	ohms/sq
<b>PROCESSING</b>					
DRYING TEMPERATURE		230	°F	110	°C
DRYING TIME		4	hrs	4	hrs
MELT TEMPERATURE		430-500	°F	220- 260	°C
MOLD TEMPERATURE		225	°F	107	°C
BACK PRESSURE		50-100	psi	0.3 - 0.7	MPa
SCREW SPEED		40-70	rpm	40-70	rpm
VENT DEPTH		0.0015-0.003	in	0.038 - 0.075	mm

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