

Properties**B1300, B1300F**

PBT/ABS resin

Standard

Properties	Test methods	Test conditions	Units	
Mold shrinkage	ASTM D955	-	%	0.5-0.8
Tensile strength	ISO 527	-	MPa	38
Flexural strength	ISO 178	-	MPa	57
Flexural modulus	ISO 178	-	MPa	1800
Notched Charpy impact strength	ISO 179/1eA	23 deg C	kJ/m2	10
Notched Izod impact strength	ASTM D256	23 deg C/6.4mm	J/m	60
Deflection temperature under load	ISO 75	1.80MPa	deg C	80
Deflection temperature under load	ASTM D648	1.82MPa/6.4mm	deg C	90
Deflection temperature under load	ISO 75	0.45MPa	deg C	100
Deflection temperature under load	ASTM D648	0.46MPa/6.4mm	deg C	100
Coefficient of linear thermal expansion	ISO 11359	MD	X1E-5/deg C	10
Coefficient of linear thermal expansion	ISO 11359	TD	X1E-5/deg C	-
Water absorption	ISO 62	-	%	0.15
Density	ISO 1183	-	g/cm3	1.12

Note

•Values are typical, not quality assured.

Typical settings for processing

Preliminary drying	Barrel temperature(deg C)				Screw rotation (rpm)	Back pressure (MPa)	Mold temperature (deg C)
	Nozzle	Front	Middle	Back			
3-5hrs 80-120deg C	230-250	240-250	220-240	190-230	50-90	5-20	60-80