

Properties

B27B3(Type M)

Glass fiber-reinforced PBT/ABS resin (GF15%, UL94 HB)

Good surface appearance

Properties	Test methods	Test conditions	Units	
Mold shrinkage	ASTM D955	-	%	0.4-0.6
Tensile strength	ISO 527	-	MPa	80
Flexural strength	ISO 178	-	MPa	115
Flexural modulus	ISO 178	-	MPa	5000
Notched Charpy impact strength	ISO 179/1eA	23 deg C	kJ/m2	6
Notched Izod impact strength	ASTM D256	23 deg C/6.4mm	J/m	60
Deflection temperature under load	ISO 75	1.80MPa	deg C	155
Deflection temperature under load	ASTM D648	1.82MPa/6.4mm	deg C	180
Deflection temperature under load	ISO 75	0.45MPa	deg C	200
Deflection temperature under load	ASTM D648	0.46MPa/6.4mm	deg C	200
Coefficient of linear thermal expansion	ISO 11359	MD	X1E-5/deg C	3
Coefficient of linear thermal expansion	ISO 11359	TD	X1E-5/deg C	10
Flammability	UL94	-	-	HB
Water absorption	ISO 62	-	%	0.15
Density	ISO 1183	-	g/cm3	1.33

Note

- Values are typical, not quality assured.
- UL recognition File No. of Daicel Polymer is E47773.

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	240-260	250-270	230-250	200-220	50-100	5-20	80-100