

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/m ²	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/cm ³	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