



## Grade: PBTGF30

Molding Grade 30% Glass Filled PBT

### Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.52	D792
<b>Mechanical</b>		
Tensile Strength @ Yield	18,500 psi	D638
Flexural Modulus	1,200,000 psi	D790
Flexural Strength @ Yield	27,500 psi	D790
<b>Impact</b>		
Notched Izod Impact (73°F, 0.125 in)	1.30 ft-lb/in	D256
<b>Thermal</b>		
DTUL @ 264 psi-unannealed (0.250 in)	385°F	D648
<b>Mold Shrinkage</b>		
Linear Flow	.004 - .006 in/in	D955

### Recommended Processing Guidelines

	Nominal Values
Drying Time and Temperature	4.0 hrs, 230°F - 250°F
Suggested Max Moisture	0.020%
Rear Temperature	450°F - 480°F
Middle Temperature	475°F - 500°F
Front Temperature	475°F - 510°F
Nozzle Temperature	475°F - 510°F
Processing (Melt) Temperature	485°F - 525°F
Mold Temperature	150°F - 210°F
Back Pressure	50 - 100 psi
Screw Speed	40 - 75 RPM