



**TechnoCompound**

*Creativity & Innovation in Plastics*

## Technical Datasheet

### TechnoDur PBT GF 15 BAGF 20 black (67450)

PBT, injection moulding grade with 15 % glass-fiber and filler material, for sound absorbing

Property	Test cond.	Unit	Standard	Value
Density	23°C	g / cm <sup>3</sup>	ISO 1183	2,00
MVR - Melt volume rate	250 °C / 2,16 kg	cm <sup>3</sup> / 10min	ISO 1133	10
Tensile modulus	1 mm / min	MPa	ISO 527	10200
Tensile stress at yield	50 mm / min	MPa	ISO 527	105
Tensile strain at yield	50 mm / min	%	ISO 527	1,6
Felxural modulus	1,75 mm / min	MPa	ISO 178	10400

## Processing recommendations

### Predrying

In order to avoid the degradation of the polymer, residual moisture during processing may not exceed 0,02 percent. Therefore predrying is strictly recommended. Dry-air dryer are preferred on this. Drying is recommended 2 to 4 hours at 120 - 140°C.

### Injection moulding

Temperatures	Cylinder	°C	250 - 270
	Dye	°C	265 - 275
	Mass	°C	265 - 275
	Tool	°C	90 - 120
Dwell time		min	5 - 10
Pressures	Injection	bar	600 - 1000
	Dwell pressure	bar	400 - 800
	Back pressure	bar	10 - 30
Screw speed		Upm	80
Speed of injection			high
Dye			open