

Technical Datasheet

TechnoDur PBT GF 30 BAGF 18 black (71121)

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 ³	ISO 1183	1,80
MVR – Melt volume rate	250 °C / 2,16 kg	cm ³ / 10min	ISO 1133	22
Tensile modulus	1 mm / min	MPa	ISO 527	11900
Tensile stress at yield	50 mm / min	MPa	ISO 527	118
Tensile strain at yield	50 mm / min	%	ISO 527	1,5
Flexural modulus	1,75 mm / min	MPa	ISO 178	12200

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		U/min	80
Speed of injection			high
Dye			open