

Technical Datasheet

TechnoDur PBT/PET GF 30 2 black UV (55986)

PBT/PET - Blend, injection moulding grade with 30% glass-fiber, very good surface, high stiffness and stability, for outdoor applications

Property	Test cond.	Unit	Standard	Value
Density	23 °C	g / cm ³	ISO 1183	1,55
MVR – Melt volume rate	265 °C / 2,16 kg	cm ³ / 10min	ISO 1133	10
Tensile modulus	1 mm / min	MPa	ISO 527	10500
Tensile stress at break	50 mm / min	MPa	ISO 527	150
Elongation at break	50 mm / min	%	ISO 527	2,5
Burning behavior UL 94	0,8 mm	Class	UL 94	HB

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	
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