

## Technical Datasheet

### TechnoDur PBT/PET GF 30 2 grey UV (73736)

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 <sup>3</sup>	ISO 1183	1,55
MVR – Melt volume rate	265 °C / 2,16 kg	cm <sup>3</sup> / 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			5 -10
Pressures	Injection	bar	600 - 1000
	Dwell pressure	bar	400 - 800
	Back pressure	bar	10 - 30
Screw speed			80
Speed of injection			high
Dye			open