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PBT/PET Compound PBT-PET- GF 50

PRECITE® K GF 50 natural (7435)

Tensile modulus	Stress at break	Charpy impact strength
20000 MPa	**175 MPa**	**60 kJ/m²**
1 mm/min	**5 mm/min**	**23°C**
ISO 527-2	ISO 527-2	ISO 179-1/1eU

PRECITE K GF 50 natural (7435) is a 50% glass fibre reinforced PBT/PET blend with high strength and improved surface finish.

Typical applications

Technical, precision and surface parts in automobile, industrial, E/E and appliances industry

Mechanical Properties

Tensile modulus (1 mm/min | ISO 527-2)	d.a.m.	20000 MPa
Stress at break (5 mm/min | ISO 527-2)	d.a.m.	175 MPa
Strain at break (5 mm/min | ISO 527-2)	d.a.m.	1,3 %
Charpy impact strength (23°C | ISO 179-1/1eU)	d.a.m.	60 kJ/m²
Charpy notched impact strength (23°C | ISO 179-1/1eA)	d.a.m.	18 kJ/m²

Thermal Properties

Melting temperature (DSC, 10K/min | DIN EN 11357-1)	223 °C

General properties

Density (23°C | ISO 1183)	1,75 g/cm³

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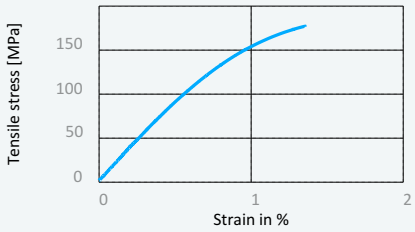
Stress strain chart at 23°C



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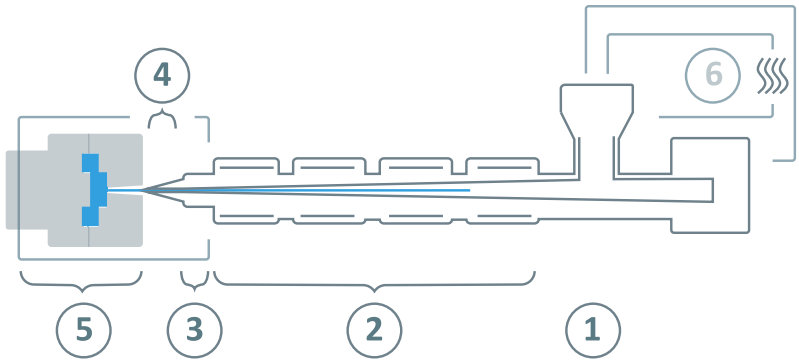
Processing information

The listed values are recommendations. Higher values should be used for higher glass loadings. We recommend only de-humidifying or vacuum dryers. Extensive drying can cause filling problems and surface defects.



6	Drying time	3 - 4 h
	Drying temperature (τ ≤ -30°C)	120 - 140°C
	Processing moisture	≤ 0,02%
1	Feed section	60 - 80°C
2	Temperature zone 1 - Zone 4	260 - 280°C
3	Nozzle temperature	260 - 290°C
4	Melt temperature	270 - 280°C
5	Mold temperature	80 - 100°C
→	Holding pressure, spec.	300 - 800 bar
←	Back pressure, spec.	30 - 100 bar
	Injection speed	medium to high
	Screw speed	8 - 15 m/min

Warning

Due to hydrolysis sensitivity of polyesters, a careful drying of the material before processing is very important. High residual moisture contents causes, in addition to surface defects, a decomposition of the molecular chains and thus reduced mechanical properties. If there are longer interruptions of the process, the cylinder temperature should be lowered. Furthermore, we recommend a thorough cleaning of the screw cylinder with extended dwell time or a material change. Glass-fiber-reinforced polyolefins (PE, PP) have established a particularly good cleaning effect.