

PBT black standrad lubricifed to gain improvements in injection and moulding.

TECHNICAL DATA SHEET

	STANDARD	UNIT	DRY	CONDITIONED
GENERALS	Density	ISO 1183	gr/cm ³	1,30
	Melt Flow Index	ISO 1133	gr/10 min.	-
	Humidity Pelets	ISO 1110	%	0,2
	Hardness	SHORE D	Points	77
	Mold Shrinkage	-	%	~1,6

	STANDARD	UNIT	DRY	CONDITIONED
MECHANICAL	Tensile Strenght	ISO 527	N/mm ²	55
	Elogantion at break	ISO 527	%	>20
	Tensile Modulus	ISO 527	N/mm ²	2500
	Charpy Impact	23 °C ISO 179	Kj/m ²	NB
		-40 °C ISO 179	Kj/m ²	-
	Charpy Impact	23 °C ISO 179	Kj/m ²	5,5
-40 °C ISO 179		Kj/m ²	-	

	STANDARD	UNIT	DRY	CONDITIONED
ELECTRICAL	Surface Resistivity	IEC 93	Ohm	10 ¹⁴
	Dielectric strength	IEC 243	Kv/mm	27
	Tracking index (C.T.I.)	IEC 112	Kv/mm	-

	STANDARD	UNIT	DRY	CONDITIONED
THERMAL	Deflection Temp. Under Load	0,4 N ISO 75/A	°C	160
		(H.D.T.)	1,8 N ISO 75/A	°C
	VICAT Temperatura	ISO 306	°C	-

- The values provided in this data sheet correspond to our knowledge. All products must be subjected to in company test by the user before application.
- These datas do not release you from the obligation to test our products as to their suitability for the intended processes and final use.
- These data may not valid such material used in combination with any other materials or additives or in - any process.
- Triesa assumes no liability and makes no warranties of any kind, expressed or implied how to use this information data.
- UL measurements are done in our lab according to this norm.

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	STANDARD	UNIT	DRY	CONDITIONED
OTHERS	UL - Flammability	UL-94	-	HB
	Glow Wire	IEC 695	°C	-
	Fammability speed	FMV 302	mm/min.	<100
	Ashes	Triesa Test	%	-
	Water absorption (24h)	ISO 62	%	~0,1
	Lubricated			YES

RECOMMENDED VALUES

PROCESSING	Drying Material	2h - 4h 110°C
	Mold. Temperature	70°C-90°C
	Processing Temperature	230°C-245°C
	Back Temperature	230°C-235°C
	Middle Temperature	240°C-245°C
	Nozzle Temperature	245°C-250°C
	Hold Pressure	40 - 70 Mpa

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SOURCE: Triesa Quality Control; Last update: 10/05/2020