Pocan T7141 000000

PET+PBT, 40 % glass fibers/mineral, injection molding, improved flowability, high thermal dimension stability

ISO Shortname: ISO 20028-PET+PBT,(GF+MD)40,GHMR,07-120

Property	Test Condition	Unit	Standard	guide value
Rheological properties				
C Melt volume-flow rate	280 °C; 2.16 kg	cm³/(10 min)	ISO 1133-1	25
C Molding shrinkage, parallel	60x60x2; 280°C / WZ 110°C; 600 bar	%	ISO 294-4	0.2
C Molding shrinkage, transverse	60x60x2; 280°C / WZ 110°C; 600 bar	%	ISO 294-4	0.7
Post- shrinkage, parallel	60x60x2; 120 °C; 4 h	%	ISO 294-4	0.1
Post- shrinkage, transverse	60x60x2; 120 °C; 4 h	%	ISO 294-4	0.1
Mechanical properties (23 °C/50 % r. h.)				
C Tensile modulus	1 mm/min	MPa	ISO 527-1,-2	12000
C Tensile Stress at break	5 mm/min	MPa	ISO 527-1,-2	125
C Tensile Strain at break	5 mm/min	%	ISO 527-1,-2	1.6
C Charpy notched impact strength	23 °C	kJ/m²	ISO 179-1eA	<10
C Charpy notched impact strength	-30 °C	kJ/m²	ISO 179-1eA	<10
Izod impact strength	23 °C	kJ/m²	ISO 180-1U	35
Izod notched impact strength	23 °C	kJ/m²	ISO 180-1A	<10
Izod notched impact strength	-30 °C	kJ/m²	ISO 180-1A	<10
Flexural modulus	2 mm/min	MPa	ISO 178-A	11000
Flexural strength	2 mm/min	MPa	ISO 178-A	175
Flexural strain at flexural strength	2 mm/min	%	ISO 178-A	2.0
Thermal properties				
C Melting temperature	10 °C/min	°C	ISO 11357-1,-3	260
C Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2	205
C Temperature of deflection under load	0.45 MPa	°C	ISO 75-1,-2	250
Vicat softening temperature	50 N; 120 °C/h	°C	ISO 306	220
C Coefficient of linear thermal expansion, parallel	23 to 55 °C	10^{-4}/K	ISO 11359-1,-2	0.2
C Coefficient of linear thermal expansion, transverse	23 to 55 °C	10^{-4}/K	ISO 11359-1,-2	0.5
Glow wire test (GWFI)	0.8 mm	°C	IEC 60695-2-12	750
Glow wire test (GWFI)	1.5 mm	°C	IEC 60695-2-12	750
Glow wire test (GWFI)	3.0 mm	°C	IEC 60695-2-12	750
Glow wire test (GWIT)	0.8 mm	°C	IEC 60695-2-13	775
Glow wire test (GWIT)	1.5 mm	°C	IEC 60695-2-13	775
Glow wire test (GWIT)	3.0 mm	°C	IEC 60695-2-13	775
Electrical properties (23 °C/50 % r. h.)				
C Comparative tracking index CTI	Solution A	Rating	IEC 60112	225
Other properties (23 °C)				
C Density		kg/m³	ISO 1183	1700
Bulk density		kg/m³	ISO 60	900
Processing conditions for test specimens				
C Injection molding-Melt temperature		°C	ISO 294	280
C Injection molding-Mold temperature		°C	ISO 294	110

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Property	Test Condition	Unit	Standard	guide value
Processing recommendations				
Drying temperature circulating air dryer		°C	-	120
Drying time circulating air dryer		h	-	4-8
Residual moisture content		%	Acc. to Karl Fischer	0.00-0.02
Melt temperature (Tmin - Tmax)		°C	-	270-290
Mold temperature		°C	-	100-130

C These property characteristics are taken from the CAMPUS plastics data bank and are based on the international catalogue of basic data for plastics according to ISO 10350.

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Disclaimer

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Test values

Unless specified to the contrary, the values given have been established on standardized test specimens at room temperature. The figures should be regarded as guide values only and not as binding minimum values. Kindly note that, under certain conditions, the properties can be affected to a considerable extent by the design of the mould/die, the processing conditions and the coloring.

Processing note

Under the recommended processing conditions small quantities of decomposition product may be given off during processing. To preclude any risk to the health and well-being of the machine operatives, tolerance limits for the work environment must be ensured by the provision of efficient exhaust ventilation and fresh air at the workplace in accordance with the Safety Data Sheet. In order to prevent the partial decomposition of the polymer and the generation of volatile decomposition products, the prescribed processing temperatures should not be substantially exceeded. Since excessively high temperatures are generally the result of operator error or defects in the heating system, special care and controls are essential in these areas.

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