

Pocan[®] B1204

PBT

Injection Molding, Unreinforced, Excellent Surface Properties

Print Date: 2024-09-17

PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
RHEOLOGICAL PROPERTIES			
	VALUE		
Melt volume-flow rate	60	cm ³ /10min	ISO 1133
Temperature	260	°C	ISO 1133
Load	2.16	kg	ISO 1133
Molding shrinkage (normal)	2	%	ISO 294-4
Molding shrinkage (parallel)	2	%	ISO 294-4
MECHANICAL PROPERTIES			
	VALUE		
Tensile modulus	2600	MPa	ISO 527-1/-2
Yield stress	60	MPa	ISO 527-1/-2
Yield strain	9	%	ISO 527-1/-2
Flexural modulus	2700	MPa	ISO 178
Flexural strength	90	MPa	ISO 178
Flexural strain at flexural strength	6	%	ISO 178-A
Charpy impact strength (+23°C)	180	kJ/m ²	ISO 179/1eU
Charpy notched impact strength (+23°C)	<10	kJ/m ²	ISO 179/1eA
Izod impact strength (+23°C)	125	kJ/m ²	ISO 180/1U
THERMAL PROPERTIES			
	VALUE		
Melting temperature (10°C/min)	225	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	70	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	160	°C	ISO 75-1/-2
Coeff. of linear therm. expansion (parallel)	1.11	E-4/°C	ISO 11359-1/-2
Coeff. of linear therm. expansion (normal)	1.07	E-4/°C	ISO 11359-1/-2

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Property Data

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<i>PROPERTIES</i>	<i>TYPICAL DATA</i>	<i>UNIT</i>	<i>TEST METHOD</i>
Burning Behav. at 0.75 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	0.75	mm	IEC 60695-11-10
Burning Behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.5	mm	IEC 60695-11-10
Burning Behav. at 3.0 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	3	mm	IEC 60695-11-10

<i>OTHER PROPERTIES</i>	<i>VALUE</i>		
Density	1310	kg/m ³	ISO 1183

<i>PROCESSING RECOMMENDATIONS</i>	<i>VALUE</i>		
Drying temperature circulating air dryer	120	°C	
Drying time circulating air dryer	4-8	h	
Residual moisture content	0.00-0.02	%	acc. to Karl Fischer
Melt temperature (Tmin – Tmax)	250-270	°C	
Mold temperature	80-100	°C	

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