

# Pocan<sup>®</sup> B3225XF

## PBT-GF20

Injection Molding, 20% Glass Fiber Reinforced, High Flow, Impact Modified

Print Date: 2025-11-26

PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
<b>RHEOLOGICAL PROPERTIES</b>			
	VALUE		
Melt volume-flow rate	35	cm <sup>3</sup> /10min	ISO 1133
Temperature	260	°C	ISO 1133
Load	2.16	kg	ISO 1133
Molding shrinkage (normal)	1.1	%	ISO 294-4
Molding shrinkage (parallel)	0.5	%	ISO 294-4
<b>MECHANICAL PROPERTIES</b>			
	VALUE		
Tensile modulus	6500	MPa	ISO 527-1/-2
Stress at break	105	MPa	ISO 527-1/-2
Strain at break	3.5	%	ISO 527-1/-2
Flexural modulus	6100	MPa	ISO 178
Flexural strength	165	MPa	ISO 178
Flexural strain at flexural strength	3.7	%	ISO 178-A
Charpy impact strength (+23°C)	60	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength (-30°C)	40	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength (+23°C)	8.3	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength (-30°C)	7.2	kJ/m <sup>2</sup>	ISO 179/1eA
Izod impact strength (+23°C)	50	kJ/m <sup>2</sup>	ISO 180/1U
Izod impact strength (-30°C)	40	kJ/m <sup>2</sup>	ISO 180-1U
<b>THERMAL PROPERTIES</b>			
	VALUE		
Melting temperature (10°C/min)	225	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	200	°C	ISO 75-1/-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>
Temp. of deflection under load (0.45 MPa)	220	°C	ISO 75-1/-2
Coeff. of linear therm. expansion (parallel)	0.2	E-4/°C	ISO 11359-1/-2
Coeff. of linear therm. expansion (normal)	1.3	E-4/°C	ISO 11359-1/-2
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
Glow Wire Flammability Index GWFI	750	°C	IEC 60695-2-12
GWFI (Thickness (1) tested)	2	mm	IEC 60695-2-12
Glow Wire Ignition Temperature GWIT	775	°C	IEC 60695-2-13
GWIT (Thickness (1) tested)	2	mm	IEC 60695-2-13

### *ELECTRICAL PROPERTIES*

#### *VALUE*

Comparative tracking index	400	V	IEC 60112
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### *OTHER PROPERTIES*

#### *VALUE*

Water absorption	0.4	%	Sim. to ISO 62
Humidity absorption	0.1	%	Sim. to ISO 62
Density	1400	kg/m <sup>3</sup>	ISO 1183

### *PROCESSING RECOMMENDATIONS*

#### *VALUE*

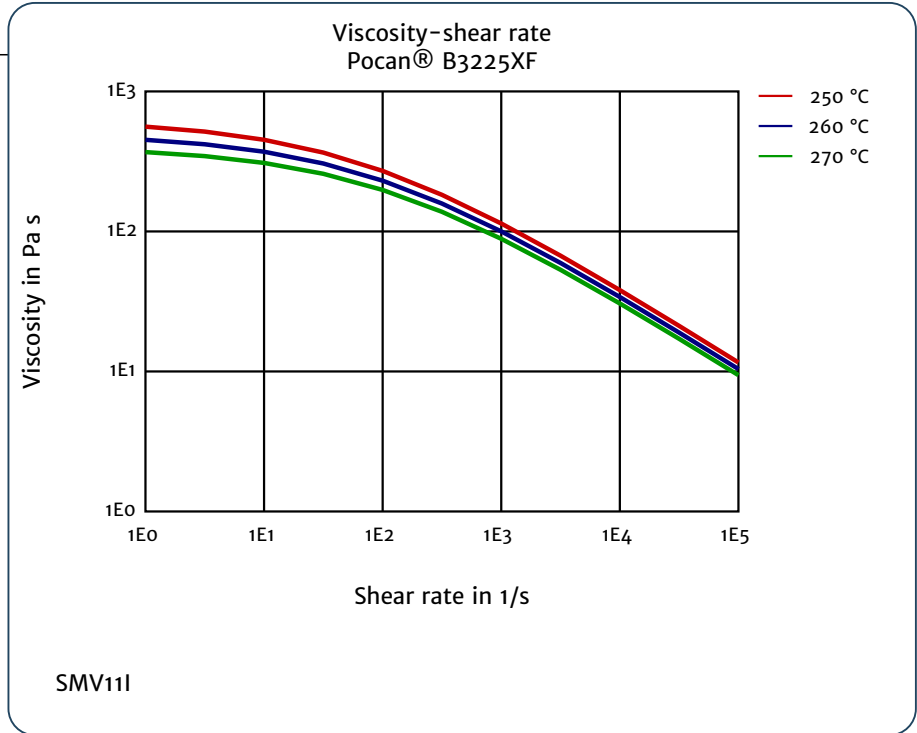
Drying temperature circulating air dryer	120	°C	
Drying time circulating air dryer	4-8	h	
Residual moisture content	0.00-0.02	%	acc. to Karl Fischer
Melt temperature (Tmin – Tmax)	250-270	°C	
Mold temperature	80-100	°C	

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## Viscosity-shear rate



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