

Properties

B14M0

PBT/ABS resin

Impact resistance

Properties	Test methods	Test conditions	Units	
Mold shrinkage	Daicel method	-	%	0.6-0.9
Tensile strength	ISO 527	-	MPa	40
Flexural strength	ISO 178	-	MPa	60
Flexural modulus	ISO 178	-	MPa	1900
Notched Charpy impact strength	ISO 179/1eA	23 deg C	kJ/m2	50
Deflection temperature under load	ISO 75	1.80MPa	deg C	80
Coefficient of linear thermal expansion	ISO 11359	MD	X1E-5/deg C	10
Coefficient of linear thermal expansion	ISO 11359	TD	X1E-5/deg C	-
Water absorption	ISO 62	-	%	0.15
Density	ISO 1183	-	g/cm3	1.13

Note

- Test methods such as ISO standards are fully or almost compliant with the standards.
- Values are typical, not quality assured.

Typical settings for processing

Preliminary drying	Barrel temperature(deg C)				Screw rotation (rpm)	Back pressure (MPa)	Mold temperature (deg C)
	Nozzle	Front	Middle	Back			
3-5hrs 80-120deg C	230-250	240-250	220-240	190-230	50-90	5-20	60-80