

Properties

B2504

Glass fiber-reinforced PBT/ABS resin (GF20%)

Standard

Properties	Test methods	Test conditions	Units	
Mold shrinkage	Daicel method	-	%	0.3-0.5
Tensile strength	ISO 527	-	MPa	86
Flexural strength	ISO 178	-	MPa	140
Flexural modulus	ISO 178	-	MPa	6000
Notched Charpy impact strength	ISO 179/1eA	23 deg C	kJ/m ²	8
Notched Izod impact strength	ASTM D256	23 deg C/6.4mm	J/m	80
Deflection temperature under load	ISO 75	1.80MPa	deg C	130
Deflection temperature under load	ASTM D648	1.82MPa/6.4mm	deg C	125
Deflection temperature under load	ISO 75	0.45MPa	deg C	200
Deflection temperature under load	ASTM D648	0.46MPa/6.4mm	deg C	200
Coefficient of linear thermal expansion	ISO 11359	MD	X1E-5/deg C	3
Coefficient of linear thermal expansion	ISO 11359	TD	X1E-5/deg C	10
Water absorption	ISO 62	-	%	0.15
Density	ISO 1183	-	g/cm ³	1.31

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