

EnCounter 120MF

PBT



Product Description			
20% Mineral Filled PBT			
General Properties			
Appearance	Black, Natural or Colors		
Processing Methods	Injection Molding		
Applications	Automotive, Electronics\Electrical, Business Equipment, Structural		
Mechanical Properties	Test Method	English Units	S.I. Units
Tensile Strength @ Yield	ASTM D638	8,000 psi	55 MPa
Tensile Elongation at Break	ASTM D638	2 %	2 %
Flexural Modulus	ASTM D790	600,000 psi	4,138 MPa
Flexural Strength	ASTM D790	13,500 psi	93 MPa
Notched Izod Impact (73°F)	ASTM D256	0.5 ft-lb/in	27 J/m
Physical Properties	Test Method	English Units	S.I. Units
Specific Gravity	ASTM D792	1.49 sp gr	1.49 sp gr
Mold Shrink - Flow: 0.126 in (3.20 mm)	ASTM D955	0,008 - 0,012 in/in	0,008 - 0,012 mm/mm
Filler Content		20.0 %	20.0 %
Thermal Properties	Test Method	English Units	S.I. Units
Heat Deflection Temperature @ 66 psi	ASTM D648	390 °F	199 °C
Heat Deflection Temperature @ 264 psi	ASTM D648	175 °F	79 °C
Injection Molding	Value		
Drying Temperature	250 °F		
Drying Time	3.0 - 4.0 hrs		
Maximum Drying Time	8 hrs		
Suggested Maximum Moisture	0.02 %		
Rear Barrel Temperatures	450 - 480 °F		
Middle Barrel Temperatures	460 - 490 °F		
Front Barrel Temperatures	470 - 500 °F		
Nozzle Temperature	460 - 490 °F		
Melt (processing) Temperatures	470 - 500 °F		
Mold Temperatures	120 - 180 °F		
Back Pressure	50 - 100 psi		
Screw speed	50 - 100 rpm		
Vent Depth	0.0005 - 0.001 in		

These Data Sheet Values are Typical Values and are not intended for specification purposes. These values should only be used as a guide and no assurances by EnCom, Inc. can be granted that all molded articles will exhibit duplicate properties as those listed above. Each material user should perform their own testing for suitability.