

# EnCounter 15615

PBT



Product Description					
Low temperature impact PBT					
General Properties					
Appearance	Black, Natural or Colors				
Processing Methods	Profile Extrusion, Injection Molding				
Applications	Automotive, Material Handling, Industrial				
Mechanical Properties	Test Method	English Units		S.I. Units	
Tensile Strength @ Yield	ASTM D638	5,850	psi	40	MPa
Tensile Elongation at Break	ASTM D638	7	%	7	%
Flexural Modulus	ASTM D790	259,500	psi	1,790	MPa
Flexural Strength	ASTM D790	8,200	psi	57	MPa
Notched Izod Impact (73°F)	ASTM D256	17.0	ft-lb/in	908	J/m
Notched Izod Impact (-22°F)	ASTM D256	16.0	ft-lb/in	854	J/m
Un-notched Izod (73°F)	ASTM D256	65.0			
Un-notched Izod (-22°F)	ASTM D256	65.0	ft-lb/in	3471	J/m
Physical Properties	Test Method	English Units		S.I. Units	
Specific Gravity	ASTM D792	1.21	sp gr	1.21	sp gr
Melt Flow 250°C/5.0 kg	ASTM D1238	14.0	g/10min	14.0	g/10min
Mold Shrink - Flow: 0.126 in (3.20 mm)	ASTM D955	2.500	in/in	0.025 - 0.381	mm/mm
Thermal Properties	Test Method	English Units		S.I. Units	
Heat Deflection Temperature @ 66 psi	ASTM D648	210	°F	99	°C
Heat Deflection Temperature @ 264 psi	ASTM D648	120	°F	49	°C
Injection Molding		Value			
Drying Temperature		250	°F		
Drying Time		12.00	hrs		
Suggested Maximum Moisture		0.02	%		
Suggested Shot Size		40 - 80	%		
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 - 170	°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.

EnCom Polymers, Inc.

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