

## GRADE: PBTGF30

Molding Grade 30% Glass Filled PBT

### Typical Material Properties

| Physical                             | Nominal Values    | ASTM Test |
|--------------------------------------|-------------------|-----------|
| Specific Gravity                     | 1.52              | D792      |
| <b>Mechanical</b>                    |                   |           |
| Tensile Strength @ Yield             | 18,500 psi        | D638      |
| Flexural Modulus                     | 1,200,000 psi     | D790      |
| Flexural Strength @ Yield            | 27,500 psi        | D790      |
| <b>Impact</b>                        |                   |           |
| Notched Izod Impact (73°F, 0.125 in) | 1.30 ft-lb/in     | D256      |
| <b>Thermal</b>                       |                   |           |
| DTUL @ 264 psi-unannealed (0.250 in) | 385°F             | D648      |
| <b>Mold Shrinkage</b>                |                   |           |
| Linear Flow                          | .004 - .006 in/in | D955      |

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### Recommended Processing Guidelines

|                               | Nominal Values         |
|-------------------------------|------------------------|
| Drying Time and Temperature   | 4.0 hrs, 230°F - 250°F |
| Suggested Max Moisture        | 0.020%                 |
| Rear Temperature              | 450°F – 480°F          |
| Middle Temperature            | 475°F – 500°F          |
| Front Temperature             | 475°F – 510°F          |
| Nozzle Temperature            | 475°F – 510°F          |
| Processing (Melt) Temperature | 485°F – 525°F          |
| Mold Temperature              | 150°F – 210°F          |
| Back Pressure                 | 50 – 100 psi           |
| Screw Speed                   | 40 – 75 RPM            |

The conditions listed above are only guidelines. You may want to adjust conditions to meet your requirements.