

Star Plastics PC/PBT7804 Molding Grade PC/PBT

Category : Polymer , Thermoplastic , Polycarbonate (PC) , Polycarbonate/Polybutylene Terephthalate (PBT) Blend, Unreinforced , Polyester, TP , Polybutylene Terephthalate (PBT)

Material Notes:

Information provided by Star Plastics, Inc.

Order this product through the following link:

http://www.lookpolymers.com/polymer_Star-Plastics-PCPBT7804-Molding-Grade-PCPBT.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.20 g/cc	1.20 g/cc	ASTM D792
Maximum Moisture Content	0.020	0.020	
Linear Mold Shrinkage	0.0080 - 0.011 cm/cm	0.0080 - 0.011 in/in	ASTM D955
Melt Flow	4.0 g/10 min @Load 3.80 kg, Temperature 230 Â°C	4.0 g/10 min @Load 8.38 lb, Temperature 446 Â°F	ASTM D1238

Mechanical Properties	Metric	English	Comments
Tensile Strength, Yield	48.3 MPa	7000 psi	ASTM D638
Tensile Modulus	1.86 GPa	270 ksi	ASTM D638
Flexural Yield Strength	72.4 MPa	10500 psi	ASTM D790
Flexural Modulus	1.97 GPa	285 ksi	ASTM D790
Izod Impact, Notched	6.67 J/cm	12.5 ft-lb/in	73Â°F, 0.125 in.; ASTM D256

Thermal Properties	Metric	English	Comments
Deflection Temperature at 1.8 MPa (264 psi)	93.3 Â°C	200 Â°F	unannealed, .125in; ASTM D648

Processing Properties	Metric	English	Comments
Rear Barrel Temperature	232 - 249 Â°C	450 - 480 Â°F	
Middle Barrel Temperature	246 - 260 Â°C	475 - 500 Â°F	
Front Barrel Temperature	246 - 266 Â°C	475 - 510 Â°F	
Nozzle Temperature	252 - 266 Â°C	485 - 510 Â°F	
Melt Temperature	252 - 274 Â°C	485 - 525 Â°F	
Mold Temperature	48.9 - 87.8 Â°C	120 - 190 Â°F	

Processing Properties	Metric	English	Comments
Drying Temperature	121°C	250°F	
Dry Time	4 hour	4 hour	
Back Pressure	0.345 - 0.689 MPa	50.0 - 100 psi	
Screw Speed	40 - 75 rpm	40 - 75 rpm	

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