

Data sheet

Pocan BF4215 000000

PBT, 12 % glass fibers, injection molding, flame retardant

ISO Shortname: ISO 20028-PBT,GF12,GFHMR,09-060; ISO 1043-4 FR(17)

Property	Test Condition	Unit	Standard	guide value
Rheological properties				
C Melt volume-flow rate	260 °C; 2.16 kg	cm ³ /(10 min)	ISO 1133-1	21
C Molding shrinkage, parallel	60x60x2; 250 °C / WZ 80° C; 600 bar %		ISO 294-4	0.8
C Molding shrinkage, transverse	60x60x2; 250 °C / WZ 80° C; 600 bar %		ISO 294-4	1.1
Post- shrinkage, parallel	60x60x2; 120 °C; 4 h	%	ISO 294-4	0.1
Post- shrinkage, transverse	60x60x2; 120 °C; 4 h	%	ISO 294-4	0.1
Mechanical properties (23 °C/50 % r. h.)				
C Tensile modulus	1 mm/min	MPa	ISO 527-1,-2	6000
C Tensile Stress at break	5 mm/min	MPa	ISO 527-1,-2	100
C Tensile Strain at break	5 mm/min	%	ISO 527-1,-2	2.5
C Tensile creep modulus	1 h	MPa	ISO 899-1	5500
C Tensile creep modulus	1000 h	MPa	ISO 899-1	5000
C Charpy impact strength	23 °C	kJ/m ²	ISO 179-1eU	25
C Charpy impact strength	-30 °C	kJ/m ²	ISO 179-1eU	25
C Charpy notched impact strength	23 °C	kJ/m ²	ISO 179-1eA	<10
C Charpy notched impact strength	-30 °C	kJ/m ²	ISO 179-1eA	<10
Izod impact strength	23 °C	kJ/m ²	ISO 180-1U	20
Izod impact strength	-30 °C	kJ/m ²	ISO 180-1U	20
Izod notched impact strength	23 °C	kJ/m ²	ISO 180-1A	<10
Izod notched impact strength	-30 °C	kJ/m ²	ISO 180-1A	<10
Izod notched impact strength	-40 °C	kJ/m ²	ISO 180-1A	<10
Flexural modulus	2 mm/min	MPa	ISO 178-A	5700
Flexural strength	2 mm/min	MPa	ISO 178-A	155
Flexural strain at flexural strength	2 mm/min	%	ISO 178-A	3.2
Ball indentation hardness		N/mm ²	ISO 2039-1	180
Thermal properties				
C Melting temperature	10 °C/min	°C	ISO 11357-1,-3	225
C Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2	185
C Temperature of deflection under load	0.45 MPa	°C	ISO 75-1,-2	210
Vicat softening temperature	50 N; 120 °C/h	°C	ISO 306	205
C Coefficient of linear thermal expansion, parallel	23 to 55 °C	10-4/K	ISO 11359-1,-2	0.4
C Coefficient of linear thermal expansion, transverse	23 to 55 °C	10-4/K	ISO 11359-1,-2	1.0
C Burning behavior UL 94	1.5 mm	Class	UL 94	V-0
C Burning behavior UL 94	0.4 mm	Class	UL 94	V-0
C Oxygen index	Method A	%	ISO 4589-2	32
Thermal conductivity	23 °C	W/(m·K)	ISO 8302	0.2
Resistance to heat (ball pressure test)		°C	IEC 60695-10-2	210
Temperature index (Tensile strength)	20000 h	°C	IEC 60216-1	140
Halving interval (Tensile strength)		°C	IEC 60216-1	11.7
Relative temperature index (Tensile strength)		°C	UL 746B	140
Temperature index (Tensile impact strength)	20000 h	°C	IEC 60216-1	135
Halving interval (Tensile impact strength)		°C	IEC 60216-1	9.2
Relative temperature index (Tensile impact strength)		°C	UL 746B	130
Temperature index (Electric strength)	20000 h	°C	IEC 60216-1	145
Halving interval (Electric strength)		°C	IEC 60216-1	12.4
Relative temperature index (Electric strength)		°C	UL 746B	130
Glow wire test (GWFI)	0.75 mm	°C	IEC 60695-2-12	960
Glow wire test (GWFI)	1.5 mm	°C	IEC 60695-2-12	960
Glow wire test (GWFI)	3.0 mm	°C	IEC 60695-2-12	960
Glow wire test (GWIT)	0.75 mm	°C	IEC 60695-2-13	700
Glow wire test (GWIT)	1.5 mm	°C	IEC 60695-2-13	700
Glow wire test (GWIT)	3.0 mm	°C	IEC 60695-2-13	700
Electrical properties (23 °C/50 % r. h.)				
C Relative permittivity	100 Hz	-	IEC 60250	3.6

C Relative permittivity	1 MHz	-	IEC 60250	3.4
C Dissipation factor	100 Hz	10-4	IEC 60250	40
C Dissipation factor	1 MHz	10-4	IEC 60250	190
C Volume resistivity		Ohm·m	IEC 60093	>1E11
C Surface resistivity		Ohm	IEC 60093	>1E15
C Electric strength	1 mm	kV/mm	IEC 60243-1	29
C Comparative tracking index CTI	Solution A	Rating	IEC 60112	200
Comparative tracking index CTI	Solution A	PLC	UL 746A	2

Other properties (23 °C)

C Water absorption (Saturation value)	Water at 23 °C	%	ISO 62	0.3
C Water absorption (Equilibrium value)	23 °C; 50 % RH	%	ISO 62	0.1
C Density		kg/m³	ISO 1183	1530
Bulk density		kg/m³	ISO 60	800

Processing conditions for test specimens

C Injection molding-Melt temperature		°C	ISO 294	250
C Injection molding-Mold temperature		°C	ISO 294	80

Processing recommendations

Drying temperature circulating air dryer		°C	-	120
Drying time circulating air dryer		h	-	4-8
Residual moisture content		%	Acc. to Karl Fischer	0.00-0.02
Melt temperature (Tmin - Tmax)		°C	-	240-260
Mold temperature		°C	-	80-100

C These property characteristics are taken from the CAMPUS plastics data bank and are based on the international catalogue of basic data for plastics according to ISO 10350.

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Test values

Unless specified to the contrary, the values given have been established on standardized test specimens at room temperature. The figures should be regarded as guide values only and not as binding minimum values. Kindly note that, under certain conditions, the properties can be affected to a considerable extent by the design of the mould/die, the processing conditions and the coloring.

Processing note

Under the recommended processing conditions small quantities of decomposition product may be given off during processing. To preclude any risk to the health and well-being of the machine operatives, tolerance limits for the work environment must be ensured by the provision of efficient exhaust ventilation and fresh air at the workplace in accordance with the Safety Data Sheet. In order to prevent the partial decomposition of the polymer and the generation of volatile decomposition products, the prescribed processing temperatures should not be substantially exceeded. Since excessively high temperatures are generally the result of operator error or defects in the heating system, special care and controls are essential in these areas.

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