

CHANG CHUN PLASTICS CO., LTD.

NO. 301, SONGKIANG ROAD, 7TH FL., TAIPEI, 10477 TAIWAN
TEL : 886-2-2503-8131 (REF) FAX : 886-2- 2501-8018

PBT 4830-BK Technical Data

Engineering Plastics Polybutylene Terephthalate

CCP PBT 4830-BK

PBT 4830-BK is a 30% glass fiber reinforced injection molding grade.

Characteristics

- 1) excellent electrical property
- 2) excellent temperature resistance, high heat distortion temperature.
- 3) excellent mechanic and chemical property
- 4) excellent weatherability
- 5) excellent moldability
- 6) High resistance to fuels, oil, fats and many solvents

Injection Molding Condition

Cylinder temperatures	: 235-270°C
Nozzle temperature	: 250-270°C
Mould temperature	: 40-120°C , suitable temperature 60-80°C
Injection rate	: middle - fast
Screw speed	: 60-120 rpm, to be chosen in such a way that plasticizing time is just within cooling time.
Pressure	Injection pressure : 500-1200 kg/cm ²
	Holding pressure : 300-800 kg/cm ²
	Back pressure : 0-3 kg/cm ²
Mould shrinkage	Mould shrinkage 1.6 mm thickness horizon is 0.2-0.5% and vertical is 0.8-1.4% under the test method ISO 294.

Packaging

25 kg/ paper bag, 850 kg/ PP super sack

Material handing

Moisture pick-up from ambient air should be avoided. Keep hopper properly closed.

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Property	Value	Unit	Test method
Glass fiber content	30	%	
Density	1.58	g/cm ³	ISO 1183
Melting point	225	°C	DSC
Heat deflection temperature under load			
--- 1.80 Mpa	200	°C	ISO 75
--- 0.45 Mpa	210	°C	ISO 75
Flammability acc. to UL 94, thickness 3.0mm	V-0		UL 94
Tensile stress	120	MPa	ISO 527
Tensile strain	3.0	%	ISO 527
Flexural stress	180	MPa	ISO 178
Flexural modulus	8000	MPa	ISO 178
Charpy impact strength – notched, 23°C	8.0	KJ/m ²	ISO 179
Dielectric strength, 2 mm thickness	22	KV/mm	IEC 243
Volume resistivity	10 ¹⁴	Ω-cm	IEC 60093
Surface resistivity	10 ¹³	Ω	IEC 60093
Arc resistance	100	sec	UL 746A

* All data are the typical values of the material and not the minimum values of the material specifications.