

Orion™ Resins

Grade: PBTGF20

Molding Grade 20% Glass Filled PBT



TYPICAL MATERIAL PROPERTIES

Physical	Nominal Values	ASTM Test
Specific Gravity	1.45	D792
Mechanical		
Tensile Strength @ Yield	17,000 psi	D638
Flexural Modulus	950,000 psi	D790
Flexural Strength @ Yield	25,000 psi	D790
Impact		
Notched Izod Impact (73°F, 0.125 in)	1.20 ft-lb/in	D256
Thermal		
DTUL @ 264 psi-unannealed (0.250 in)	375 °F	D648
Mold Shrinkage		
Linear Flow	.004 - .006 in/in	D955

The information provided above is based upon typical values, and are intended only as guides. Star Plastics/SDR Inc. assumes no obligation or liability for any advice furnished or for any results obtained with respect to this information. *No guarantees or warranties are expressed or implied.*

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RECOMMENDED PROCESSING GUIDELINES

	Nominal Values
Drying Time and Temperature	4.0 hrs, 230 - 250°F
Suggested Max Moisture	0.020%
Rear Temperature	450 – 480°F
Middle Temperature	475 – 500°F
Front Temperature	475 – 510°F
Nozzle Temperature	475 – 510°F
Processing (Melt) Temperature	485 – 525°F
Mold Temperature	150 – 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.

Rev0

Technical Data Sheet
StarPlastics.com

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Navigating Custom Compounds