

Orion™ Resins

Grade: PBTGF30

Molding Grade 30% Glass Filled PBT



TYPICAL MATERIAL PROPERTIES

| Physical | Nominal Values | ASTM Test |
|--------------------------------------|-------------------|-----------|
| Specific Gravity | 1.52 | D792 |
| Mechanical | | |
| Tensile Strength @ Break | 18,500 psi | D638 |
| Flexural Modulus | 1,200,000 psi | D790 |
| Flexural Strength @ Yield | 27,500 psi | D790 |
| Impact | | |
| Notched Izod Impact (73°F, 0.125 in) | 1.30 ft-lb/in | D256 |
| Thermal | | |
| DTUL @ 264 psi-unannealed (0.250 in) | 385 °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.*

*Orion™ is a registered trademark of Star Plastics; SDR Plastics Inc, its subsidiaries or affiliates.

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

Access: 12/6/17

Navigating Custom Compounds