

## GRADE: PBT820AFRGF30

FR Molding Grade PBT w/ Glass

### Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.58	D792
Melt Flow (250°C/2.16 kg)	2.0 g/10 min	D1238
<b>Mechanical</b>		
Tensile Strength @ Yield	16,500 psi	D638
Flexural Modulus	1,100,000 psi	D790
Flexural Strength @ Yield	26,000 psi	D790
<b>Impact</b>		
Notched Izod Impact (73°F, 0.125 in)	1.2 ft-lb/in	D256
<b>Thermal</b>		
DTUL @ 264 psi-unannealed (0.250 in)	395 °F	D648
DTUL @ 66 psi-unannealed (.250 in)	420 °F	
<b>Mold Shrinkage</b>		
Linear Flow	.003 - .005 in/in	D955
<b>UL Rating</b>	V0 (1.5mm)	UL 94

The information provided above is based upon typical values, and is intended only as a guide. Star Plastics, LLC 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, LLC, its subsidiaries or affiliates.

### Recommended Processing Guidelines

	Nominal Values
Drying Time and Temperature	4.0 hrs, 240°F - 250°F
Suggested Max Moisture	0.020%
Rear Temperature	465°F – 500°F
Middle Temperature	475°F – 510°F
Front Temperature	475°F – 520°F
Nozzle Temperature	475°F – 520°F
Processing (Melt) Temperature	485°F – 525°F
Mold Temperature	140°F – 190°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.