

# CHANG CHUN PLASTICS CO., LTD.

NO. 301, SONGKIANG ROAD, 7<sup>TH</sup> FL., TAIPEI, 10477 TAIWAN

TEL : 886-2-2503-8131 (REF) FAX : 886-2- 2501-8018

## Engineering Plastics Polybutylene Terephthalate

### PBT 4115-104F Technical Data

#### CCP PBT 4115-104F

PBT 4115-104F is a glass fiber 15% reinforced injection moulding grade.

PBT 4115-104F 為 15%玻璃纖維強化聚丁烯對苯二甲酸酯複合材料

#### Characteristics 品質特性

- 1)excellent electrical property 優越的電氣性質
- 2)excellent mechanic and chemical property 優越的機械與耐化學特性
- 3)excellent weatherability 耐候性佳
- 4)excellent wear property 耐磨耗性佳
- 5)excellent moldability 優越的成型性
- 6)High resistance to fuels, oil, fats and many solvents 高抗燃料、油料、溶劑特性

#### Injection Moulding Condition

Cylinder temperatures : 235-265°C

料管溫度

Nozzle temperature : 250-270°C

射嘴溫度

Mould temperature : 40-120°C, suitable temperature 60-80°C

模溫

Injection rate : middle – fast

射速

Screw speed : 60-120 rpm, to be chosen in such a way that plasticizing time is just within cooling time.

螺桿轉速

Pressure Injection pressure : 500-1200 kg/cm<sup>2</sup>

壓力

射壓

Holding pressure : 300-800 kg/cm<sup>2</sup>

保壓

Back pressure : 0-3 kg/cm<sup>2</sup>

背壓

Mould shrinkage

收縮率

Mould shrinkage 1.6 mm thickness horizon is 0.3-0.6% and vertical is 1.4-2.0% under the test method ASTM D955.

1.6mm 測試試片，流動方向收縮率為 0.3-0.6%，垂直方向收縮率為 1.4-2.0%

#### Packaging 包裝

25 kg/ paper bag 紙袋包裝 25kg

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Property 品質特性	Value 測試值	Unit 單位	Test method ASTM
Ash 灰份	15	%	
Specific gravity 比重	1.51	-	D792
Melt flow Index 熔融指數	20.7	g/10min	250°C、2.16kg
Melting point 熔點	225	°C	DSC
Coef. of linear thermal expansion 膨脹係數	5.5	10 <sup>-5</sup> cm/cm°C	D696
Heat deflection temperature under load 熱變形溫度 --- 18.6 kg/cm <sup>2</sup>	195	°C	D648
--- 4.6 kg/cm <sup>2</sup>	210	°C	D648
Moisture absorption (24h) 吸水率	0.03	%	D570
Flammability acc. to UL94, 0.8 mm thickness 耐燃等級，厚度 0.8mm	V-0	-	UL94
Tensile strength 引張強度	1000	kg/cm <sup>2</sup>	D638
Tensile elongation 引張伸長率	3.7	%	
Flexural strength 撓曲強度	1500	kg/cm <sup>2</sup>	D790
Flexural modulus 撓曲彈性率	58000	kg/cm <sup>2</sup>	D790
Izod impact strength - notched 1/4" 衝擊強度	5.8	kg-cm/cm	D256
Hardness - rockwell 硬度	120	R	D785
Dielectric strength, 2 mm 絕緣破壞強度	20	KV/mm	D149
Volume resistivity 體積阻抗率	10 <sup>15</sup>	Ω-cm	D257
Surface resistivity 表面阻抗率	10 <sup>13</sup>	Ω	D257
Dielectric constant 誘電率	3.3	60Hz	D150
Dielectric dissipation factor 誘電正接	0.001	60Hz	D150
Arc resistance 耐電弧	80	Sec	D495

(1) For reference only

(2) All data in the table are the typical values of the material and not the minimum values of the material specifications.

※表中測試數據僅作參考用，非制定之規格值。