

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/ABS 7320H-104 Technical Data

Engineering Plastics Polybutylene Terephthalate

CCP PBT/ABS 7320H-104

PBT/ABS 7320H-104 is a 20% glass fiber reinforced injection moulding grade.

Applications

Fan, connector, electric and electronic parts becoming ever smaller and more complex.

Characteristics

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

Injection Moulding Condition

| | |
|-----------------------|--|
| Cylinder temperatures | : 240-270 |
| Nozzle temperature | : 250-270 |
| Mould temperature | : 40-120 , suitable temperature 60-80 |
| 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 0.1-0.4% and vertical is 0.7-1.3% under the test method ASTM D955. |

Packaging

25 kg/ paper bag .

Material handing

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

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| Property | Value | Unit | Test method ASTM |
|---|------------------|--------------------|---------------------|
| Glass Fiber Content | 20 | % | |
| Specific gravity | 1.35 | - | D792 |
| Melting point | 225 | | DSC |
| Heat deflection temperature under load | | | |
| --- 18.6 kg/cm ² | 150 | | D648 |
| --- 4.6 kg/cm ² | 190 | | D648 |
| Moisture absorption (24h) | 0.1 | % | D570 |
| Flammability acc. to UL94, 1.6 mm thickness | HB | - | UL94 |
| Tensile strength | 800 | kg/cm ² | D638 |
| Tensile elongation | 3.5 | % | |
| Flexural strength | 1200 | kg/cm ² | D790 |
| Flexural modulus | 50000 | kg/cm ² | D790 |
| Izod impact strength – notched 1/4" | 6.5 | kg.cm/cm | D256 |
| Hardness - rockwell | 80 | M | D785 |
| Dielectric strength, 2 mm thickness | 20 | KV/mm | D149 |
| Volume resistivity | 10 ¹⁵ | -cm | D257 |
| Surface resistivity | 10 ¹¹ | | D257 |
| Arc resistance | 80 | Sec | D495 |