



Phone: (517) 295-4196 Fax: (517) 295-4918

**Technical Data Sheet**  
**LCA® PBT 30GF Black**  
**PBT 30% Glass Fiber**

Typical Compound Properties	Value / Measure		Test Methods
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Physical Properties	English Units (ISO)	Metric Units	
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Density	1.52 g/cm <sup>3</sup>	1.52 g/cm <sup>3</sup>	ASTM D-792
Ash Content	30 %	30 %	ASTM D-5630
Linear Mold Shrinkage	0.004 - 0.006 in/in	mm/mm	ASTM D-955

Mechanical Properties			
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Izod Impact - Notched	1.30 ft-lb/in (kJ/m <sup>2</sup> )	70 J/m	ASTM D-256
Tensile Strength @ Yield	18,500 psi (Mpa)	128 MPa	ASTM D-638
Tensile Strength @ Break	psi (Mpa)	0 MPa	ASTM D-638
Tensile Elongation @ Yield	%	0 %	ASTM D-638
Tensile Elongation @ Break	%	0 %	ASTM D-638
Flexural Strength @ Yield	27,500 psi (Mpa)	190 MPa	ASTM D-790
Flexural Stress @ Break	psi (Mpa)	0 MPa	ASTM D-790
Flexural Stress @ 5% Strain	psi (Mpa)	0 MPa	ASTM D-790
Flexural Modulus	1,200,000 psi (Mpa)	8,280 MPa	ASTM D-790

Thermal Properties			
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DTUL @ 66 psi (455 kPa)	Deg. F	Deg. C	ASTM D-648
@ 264 psi (1820 kPa)	Deg. F	Deg. C	ASTM D-648
Vicat Softening Temperature	Deg. F	Deg. C	ASTM D-1525
Melt Point	Deg. F	Deg. C	ASTM D-789-92e1

All tests are performed on dry as molded ASTM (ISO) test bars.

General Product Type Information
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The property values listed above have been obtained using laboratory controlled test methods. They are offered without guarantee since conditions under which the product is used are beyond our control. Therefore, Uniplas, Inc. disclaims any liability for loss or damage incurred in connection with the use of this product.

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<b>Typical Processing Conditions</b>			
Process Variable	Description	Values	
<b>Temperatures</b>			
Barrel		<b>F</b>	<b>C</b>
	Rear	450 - 480	
	Center	475 - 500	
	Front	475 - 510	
	Nozzle	475 - 510	
	Mold	150 - 210	
	Process Temp	485 - 525	
<b>Drying</b>			
Type		Dehumidifier	
Temperature		230°F - 250°F	
Time		3 - 4 Hours	
Max. % Moisture		0.02%	
<b>Special Requirements</b>			

Optimum processing conditions will depend on such factors as machine size, screw design, part dimension, mold design, runner and gate design, and material residence time. These recommendations are intended only as a guide to achieve stable processing and good part quality.

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