

# POLYshine

## PBT D221 GF15 FA

**Features** Food approved, Impact modified  
**Filler** Glass fiber

Property	Value	Unit	Test method
<b>PHYSICAL PROPERTIES</b>			
Density	1,41	g/cm <sup>3</sup>	ISO 1183
Viscosity	--	Pas	--
<b>MECHANICAL PROPERTIES</b>			
Flexural modulus at +23°C	5600	MPa	ISO 178
Maximum flexural strength	150	MPa	ISO 178
Maximum tensile strength	110	MPa	ISO 527-2
Elongation at break	3	%	ISO 527-2
Elongation at yield	--	%	ISO 527-2
<b>IMPACT PROPERTIES</b>			
Impact strength	--	--	--
Notched Charpy at +23°C	7	kJ/m <sup>2</sup>	ISO 179
Notched Charpy at -20°C	--	kJ/m <sup>2</sup>	ISO 179
Unnotched Charpy at +23°C	--	kJ/m <sup>2</sup>	ISO 179
Unnotched Charpy at -20°C	--	kJ/m <sup>2</sup>	ISO 179
<b>THERMAL PROPERTIES</b>			
Heat Distortion Temperature	--	--	--
HDT 120°C/h at 455kPa (B)	210	°C	ISO 75/1
HDT 120°C/h at 1820kPa (A)	195	°C	ISO 75/1
Softening temperature	--	--	--
Vicat 50°C/h at 9,81N (A)	--	°C	ISO 306
Vicat 50°C/h at 49,05N (B)	205	°C	ISO 306
<b>FLAMMABILITY PROPERTIES</b>			
Flammability	--	--	--
GWFI at 2 mm	750	°C	IEC 60695-2-12
UL94 at 1.6 mm	HB	--	UL94
<b>ADDITIONAL INFORMATION</b>			
Filler content	15	±2%	ISO 3451
Mould shrinkage (with flow)	0,4	%	Polykemi
Mould shrinkage (across flow)	1,3	%	Polykemi
<b>PROCESS INSTRUCTIONS</b>			
Drying time	2-8	h	--
Drying temperature	120	°C	--
Maximal moisture content	<0,02	%	--
Melt temperature	250-270	°C	--
Mould temperature	80-100	°C	--
Peripheral screw speed	250-300	mm/s	--
Back pressure	60-100	bar	--

Further material information is available upon request

Stated values in this datasheet are approximate. The values originate, if nothing else is stated, from standardized test specimens in natural color. All information, recommendations and advice, written or verbal, given by an individual company within, or agent affiliated with, The Polykemi Group are according to our knowledge to the date of this edition, correct and given in good faith. It is the responsibility of the customer to test and evaluate if the material suits the application and the environment in which it is intended to be used. Companies within, or agent affiliated with, The Polykemi Group can not be held responsible or liable for any loss incurred through incorrect or faulty use of the products. When producing details in flame retardant material, corrosion protected steel is to recommend for the mould. We takes no responsibility for any printing errors.

Visiting address  
Bronsgatan 8  
SE-271 39 YSTAD

+46 (0)411 170 30  
polykemi@polykemi.se  
www.polykemi.se

THE POLYKEMI GROUP  
**polykemi**   
**rondo**  **scanfill** 