

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

Engineering Plastics Polybutylene Terephthalate

PBT/PC 6710H-104 Technical Data

CCP PBT/PC 6710H-104

PBT/PC 6710H-104 is a 8% glass fiber reinforced low warpage molding compound.
PBT/PC 6710H-104 為、8%玻纖強化低翹曲聚丁烯對苯二甲酸酯/聚碳酸酯複合材料

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
- 7)low warpage property 低翹曲特性

Injection Moulding Condition

Cylinder temperatures 料管溫度	: 230-270°C	
Nozzle temperature 射嘴溫度	: 240-270°C	
Mould temperature 模溫	: 40-120°C, suitable temperature 60-80°C	
Injection rate 射速	: middle – fast	
Screw speed 螺桿轉速	: 60-120 rpm, to be chosen in such a way that plasticizing time is just within cooling time.	
Pressure 壓力	Injection pressure 射壓	: 500-1200 kg/cm ²
	Holding pressure 保壓	: 300-800 kg/cm ²
	Back pressure 背壓	: 0-3 kg/cm ²
Mould shrinkage 收縮率	Mould shrinkage 1.6 mm thickness horizon is 0.3-0.6% and vertical is 1.0-1.6% 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 1.0-1.6%	

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	8	%	
Specific gravity 比重	1.25	-	D792
Melting point 熔點	225	°C	DSC
Heat deflection temperature under load 熱變形溫度 --- 18.6 kg/cm ²	110	°C	D648
Flammability acc. to UL94, 1.6 mm thickness 耐燃等級，厚度 1.6mm	HB	-	UL94
Tensile strength 引張強度	630	kg/cm ²	D638
Tensile elongation 引張伸長率	4.5	%	D638
Flexural strength 撓曲強度	1000	kg/cm ²	D790
Flexural modulus 撓曲彈性率	29000	kg/cm ²	D790
Izod impact strength - notched 1/4" 衝擊強度	14.0	Kg.cm/cm	D256
Hardness - rockwell 硬度	80	M	D785
Dielectric strength, 2 mm 絕緣破壞強度	20	KV/mm	D149
Volume resistivity 體積阻抗率	10 ¹⁵	Ω-cm	D257
Surface resistivity 表面阻抗率	10 ¹³	Ω	D257

* All data are the typical values of the material and not the minimum values of the material specifications.