

Technical Data Sheet

HCB9310G

PC/PBT

PRODUCT DESCRIPTION:

PC/PBTHCB9310G is a 10% glass fiber reinforced PC/PBT alloy resin, offering high heat resistance, high mechanical strength and good chemical resistance.

Properties	Standard	Condition	Unit	Typical Value
Physical				
Density	ISO 1183	23°C	g/cm ³	1.30
Mold Shrinkage	ISO 294	23°C, 48hr	%	0.5-0.7
Mechanical				
Tensile Strength at Yield	ISO 527	5mm/min	MPa	88
Flexural Strength	ISO 178	2mm/min	MPa	110
Flexural Modulus	ISO 178	2mm/min	MPa	3500
Notched Izod Impact Strength	ISO 180	5.5J, 23°C	kJ/m ²	10
Unnotched Izod Impact Strength	ISO 180	5.5J, 23°C	kJ/m ²	48
Thermal				
Heat Deflection Temperature	ISO 75	120°C/hr, 1.80MPa	°C	110
Other Properties				
Flammability	ISO 3795	355×100×3 mm	mm/min	≤80

Processing Parameters		Value	Unit
Pre-treatment			
Drying Temperature		100-120	°C
Drying Time		4-6	hour
Maximum Moisture Content		0.02	%
General Guidelines			
Barrel Temperature	Rear	230-260	°C
	Middle	240-275	°C
	Front	240-275	°C
Nozzle		245-270	°C
Melt Temperature		240-280	°C
Mold Temperature		60-90	°C

Note :

1. Values are measured at 23°C and in RH of 50% on injection molded specimens.
2. Typical values for uncolored products, not specifications, and may vary slightly with different colors.
3. Flexural strength is tested with fixed deflection.
4. HDT: specimens are unannealed.
5. The general guidelines are only for reference. Exact settings have to follow the product and machine conditions.

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