Dafneblend®

Document	ISO Datasheet
Description	PBT/PC
Grade	DAFNEBLEND PL706
Code	
Application	Injection moulding

30% glass fiber, low warpage.

Properties	Method	Unit	Value
Physical			
Density at 23°C	ISO 1183	g/cm3	1,47-1,49
Mould Shrinkage (%)	INTERNAL	%	0,5-0,9
Water absorption	ISO 62	%	0,06
Thermal			
Vicat B50	ISO 306	°C	190
Ball Pressure Test	IEC 60695-10-2	°C	125
HDT, A (1.80 MPa)	ISO 75/Af	°C	165
HDT, B (0.45 MPa)	ISO 75/Af	°C	210
Mechanical at 23 °C			
Flexural Modulus (23°C - 2 mm/min)	ISO 178	MPa	8000
Flexural strenght (23°C - 2 mm/min)	ISO 178	MPa	180
Tensile Modulus (23°C - 1 mm/min)	ISO 527-2	MPa	8600
Tensile stress at break (23°C-5 mm/min)	ISO 527-2	MPa	105
Tensile elong. at break (23°C-5 mm/min)	ISO 527-2	%	5,0
Izod notched impact strength (23°C) ISO	ISO 180/1A	KJ/m²	10
Izod notched impact strength (-30°C) ISO	ISO 180/1A	KJ/m²	9
Charpy notched impact strength (23°C)	ISO 179/1eA	KJ/m²	10
Charpy notched impact strength (-20°C)	ISO 179/1eA	KJ/m²	9
Charpy unnotched impact strength (23°C)	ISO 179/1eU	KJ/m²	55
Charpy unnotched impact strength (-30°C)	ISO 179/1eU	KJ/m²	50
Flammability			
Flammability class (1,6 mm)	UL94		HB
Flammability class (3,2 mm)	UL94		HB

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Electrical			
Comparative tracking index CTI	IEC 60112	V	175
Processing Conditions			
Melt Temperature Range	ISO 294	°C	245-265
Mold Temperature Range	ISO 294	°C	70-90
Injection Velocity	ISO 294		MEDIUM
Drying Temperature		°C	120
Drying Time		Hour	3
Regulations compliance			
RoHS compliance status:	COMPLIANT		
EN71:			
UL listed file nº:			
Water contact approvals.			
Food contact status:			

§ Moulding shrinkage is not an intrinsic property of plastics. It also depends on moulding parameters. The values reported have been calculated in the direction parallel to the flow in a 4.0 x 10.0 x 170 mm sample.

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