

STARESTER™ PBT 1230HR

PBT 1230HR is a unreinforced PBT with high viscosity, hydrolysis resistance and improved processing stability for extrusion.

PBT（聚对苯二甲酸丁二醇酯）基础树脂，高粘度，挤出级，端羧基含量低，抗水解，可用于改性工程塑料或高速挤出光纤松套管。

TYPICAL PROPERTIES 典型性能	TYPICAL VALUE 典型值	UNIT 单位	STANDARD 参考标准
PHYSICAL PROPERTIES/物理性能			
Density 密度	1.31±0.02	g/cm ³	GB/T 1033
Intrinsic Viscosity 特性粘度	1.30±0.04	dl/g	GB/T 1628-5-1986E
Melting temperature 熔点	224	°C	GB/T 2951.37
Melt Flow Rate, 250°C/2.16kg 熔体流动速率, 250°C/2.16kg	7-15	g/10min	GB/T 3682-2000
Water absorption, equilibrium in water at 23°C 饱和吸水率, 23°C	<0.05	%	GB/T 1034-1998
Shore hardness 邵氏硬度H _D	75	-	GB/T 2411
MECHANICAL PROPERTIES/机械性能			
Yield strength, 50mm/min 屈服强度, 50mm/min	55	MPa	GB/T 1040
Elongation at yield, 50mm/min 屈服伸长率, 50mm/min	5.4	%	GB/T 1040
Tensile Strain at break, 50mm/min 断裂伸长率, 50mm/min	>250	%	GB/T 1040
Tensile Modulus, 5mm/min 拉伸弹性模量, 5mm/min	2300	MPa	GB/T 1040
Flexural Strength, 2mm/min 弯曲强度, 2mm/min	75	MPa	GB/T 9341
Flexural Modulus, 2mm/min 弯曲弹性模量, 2mm/min	2250	MPa	GB/T 9341
Izod Impact, notched, 23°C 悬臂梁缺口冲击, 23°C	5	KJ/m ²	GB/T 1843
Izod Impact, notched, -40°C 悬臂梁缺口冲击, -40°C	4.5	KJ/m ²	GB/T 1843
Izod Impact, unnotched, 23°C 悬臂梁无缺口冲击, 23°C	160	KJ/m ²	GB/T 1843
THERMAL PROPERTIES/热性能			
HDT A, 1.80MPa, 4.0mm, unannealed 热变形温度, 1.80MPa, 4.0mm	55	°C	GB /T 1 634.2—2004
Coefficient of linear thermal expansion, longitudinal (23-80)°C 线性膨胀系数(23-80)°C	70	10 ⁻⁶ /K	GB/T 1036

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All figures in the table are the typical values of the material and not the minimum values of the material specifications.

以上表格中的所有数值均为典型值，非标准值。

All data shown here are not always applicable to parts used under different conditions. We do not guarantee that these data are directly applicable to the application conditions of users and we ask each user to make his own decision on the application.

以上数据可能会因为条件不同而不同，我们无法保证以上数据对应于客户所使用的条件，建议客户使用时候注意此项。

For safe handling of materials we supply, it is advised to refer to the Material Safety Data Sheet "MSDS" of the proper material.

我们所供材料的安全使用方面，请适当参阅材料安全数据表"MSDS"。

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Bluestar, Makes Life Better!

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PROCESSING PARAMETERS 工艺参数	TYPICAL VALUE 典型值	UNIT 单位
INJECTION MOLDING/ 注塑成型加工		
Drying Temperature 干燥温度	120-140	°C
Drying Time 干燥时间	3-4	hrs
Melt Temperature 熔体温度	235-250	°C
Nozzle Temperature 射嘴温度	240	°C
Mold Temperature 模具温度	60-80	°C
Injection Pressure 注射压力	40-100	MPa
Back Pressure 背压	4-15	MPa
Screw Speed 螺杆速度	<100	RPM

• NOTE: Injection Pressure, Back Pressure and Screw Speed are only mentioned as general guidelines. These may not apply or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding.

注：注射压力、背压和螺杆速度等条件及其设置与制件大小、厚度、模具有关，以上仅作参考。

COMPOUNDING EXTRUSION /改性挤出成型加工		
Drying Temperature 干燥温度	120-140	°C
Drying Time 干燥时间	3-4	H/小时
Melt Temperature 熔体温度	220-250	°C
Extruder Temperature ZONE1, close to feeder 螺杆一区温度（靠近喂料口）	210-245	°C
Extruder Temperature ZONE2 螺杆二区温度	210-245	°C
Extruder Temperature ZONE3 螺杆三区温度	210-245	°C
Extruder Temperature ZONE4 螺杆四区温度	210-245	°C
Extruder Temperature ZONE5, close to die 螺杆五区温度（靠近口模）	210-245	°C
Screw Speed 螺杆速度	≤900	RPM

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