



**PRODUCT INFORMATION**

**Material:** Polybutylene Terephthalate  
**Grade:** TP-FR IM  
**Description:** Impact Modified, Flame Retardant, Low Flow

**Effective Date:** June-03

TYPICAL PROPERTIES	VALUE	UNIT	TEST METHOD
<b>Physical*</b>			
Melt Flow Rate 250C/2.16kg	3-9	g/10 min	ASTM D1238
Specific Gravity	1.34		ASTM D792
Mold Shrinkage	10-14	E-3 in/in	ASTM D955
<b>Mechanical*</b>			
Tensile Strength, Break	6,500	psi	ASTM D638
Tensile Strength, Yield	6,500	psi	ASTM D638
Flexural Strength	11,250	psi	ASTM D790
Flexural Modulus	290	psi x 1000	ASTM D790
<b>Impact*</b>			
Notched Izod Impact Strength	10.0	ft-lb/in.	ASTM D256
Gardner Falling Dart Impact (minimum)	320	in-lbs.	ASTM D3029
<b>Thermal*</b>			
HDT @ 66 psi	270	°F	ASTM D648
HDT @ 264 psi	190	°F	ASTM D648
<b>Flammability</b>			
UL File Number, USA	E113219		
UL 94 rating	V-0 (0.125 in)		
	V-0 (0.0625 in)		

\* All physical, mechanical and thermal testing conducted on 1/8-inch thick, un-pigmented, test samples. Nylon grades are tested dry as molded(DAM) and foam grades tested with un-foamed parts.

**TYPICAL PROCESSING CONDITIONS**

<b>Processing Method: Injection Molding</b>			
Drying Temperature	240-250	°F	
Drying Time	3-4	Hours	Do not exceed 8 hours
Melt Temperature	450-500	°F	
Mold Temperature	110-180	°F	
Front Zone	480-510	°F	
Middle Zone	470-500	°F	
Rear Zone	460-490	°F	

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