Property Data

Envalior
Imagine the Future

Pocan® C1506

(PBT+PC)–I

Injection Molding, Unreinforced, Excellent Surface Properties, Low Warpage, Impact Modified

Print Date: 2025–10–04

PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
RHEOLOGICAL PROPERTIES	**VALUE**		
Melt volume–flow rate	30	cm³/10min	ISO 1133
Temperature	270	°C	ISO 1133
Load	5	kg	ISO 1133
Molding shrinkage (normal)	0.8	%	ISO 294–4
Molding shrinkage (parallel)	0.8	%	ISO 294–4
MECHANICAL PROPERTIES	**VALUE**		
Tensile modulus	2400	MPa	ISO 527–1/–2
Yield stress	60	MPa	ISO 527–1/–2
Yield strain	4.8	%	ISO 527–1/–2
Flexural modulus	2400	MPa	ISO 178
Flexural strength	90	MPa	ISO 178
Flexural strain at flexural strength	6	%	ISO 178–A
Charpy notched impact strength (+23°C)	57	kJ/m²	ISO 179/1eA
Charpy notched impact strength (–30°C)	13	kJ/m²	ISO 179/1eA
THERMAL PROPERTIES	**VALUE**		
Melting temperature (10°C/min)	220	°C	ISO 11357–1/–3
Temp. of deflection under load (1.80 MPa)	100	°C	ISO 75–1/–2
Temp. of deflection under load (0.45 MPa)	105	°C	ISO 75–1/–2
OTHER PROPERTIES	**VALUE**		
Density	1220	kg/m³	ISO 1183

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PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
PROCESSING RECOMMENDATIONS	**VALUE**		
Drying temperature circulating air dryer	120	°C	
Drying time circulating air dryer	4–8	h	
Melt temperature (Tmin – Tmax)	250–270	°C	
Mold temperature	80–100	°C	
admissible residence time at Tmax	<5	min	

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