



POLYBUTYLENE TEREPHTHALATE (PBT) THERMOPLASTIC POLYESTER

PRELIMINARY GUIDELINES†

DRYING

HYLOX® PBT Thermoplastic Polyester resins must be dried in a desiccant type dryer* to a moisture content of less than 0.02% by weight. The following typical drying parameters are recommended to achieve acceptable moisture levels prior to molding the resin:

Drying Time (hrs)	4
Drying Temp. (°F)	250

Drying time should not exceed 12 hours to avoid excessive heat history.

*Dew point of circulating air to be between -20°F and -40°F at hopper inlet. Air throughput minimum of 1 CFM/Lb. Resin/Hr.

INJECTION MOLDING

The following molding conditions are recommended starting points for HYLOX® PBT Thermoplastic Polyester. Some modifications may be required depending on the specific molding equipment and part configuration.

PARAMETER	
Rear Temp (°F)	450-470
Center Temp (°F)	460-480
Front Temp (°F)	470-490
Nozzle Temp (°F)	470-490
Melt Temp (°F)	480-500
Mold Temp (°F)	180-250
Filling Speed (%)	MED – FAST
Filling Pressure (psi)	1000-1700
Holding Pressure (psi)	500-900
Back Pressure (psi)	20-60
Screw Speed (RPM)	40-80
Shot to Cylinder Size (%)	40-80

*NOTE: Pressures given are in the hydraulic circuit.

†The data listed here fall within the normal range of product properties, but they should not be used to establish specification limits or used alone as a basis for design. This information is not intended as a warranty of any kind. Buyers must make their own representative test and assume all risks of use, whether used alone or in combination with other products. ENTEC POLYMERS, LLC assumes no obligation or liability of any advice furnished by it or results obtained with respect to these products. All warranties expressed or implied including warranties of merchantability for a particular purpose or use are excluded and disclaimed. ENTEC POLYMERS, LLC assumes no liability for use of products in infringement of any patent. The foregoing limitation of remedy and exclusion of liability is reflected in and is part of the consideration for the price at which the products are sold by ENTEC POLYMERS, LLC. All data displayed herein has been obtained via testing of injection molded specimens of natural color. Pigmentation may affect certain properties to various degrees.



ENTE C ENGINEERED RESINS

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