



Polybutylene Terephthalate (PBT) – General Purpose, Heat Stabilized

1 Scope

1.1 Material Description. This specification covers the properties of a general purpose, heat stabilized, injection molding grade polybutylene terephthalate (PBT) resin.

1.2 Symbols. The material abbreviation according to ISO 11469 is >PBT<.

1.3 Applicability. Typical applications include connector clips.

2 References

Note: Only the latest approved standards are applicable unless otherwise specified.

2.1 External Standards/Specifications.

ASTM E831	ISO 294	ISO 1183	ISO 11359-2
ISO 179/1eA	ISO 527	ISO 3795	ISO 11469
ISO 75	ISO 527-1	ISO 7792	
ISO 188	ISO 527-2	ISO 11357-3	

2.2 GM Standards/Specifications.

GMW3013	GMW3221	GMW14270	GMW16853
GMW3059	GMW3232	GMW14444	
GMW3205	GMW3235	GMW15634	

3 Requirements

3.1 Requirements on Test Specimens. Per GMW3221.

3.2 Emissions Testing of Interior Materials and Parts. For all Code E designated parts per GMW14444, reference GMW16853 for emissions testing of interior materials and parts.

3.3 Requirements on Delivery. Important physical, mechanical and thermal properties that characterize the material are summarized in charts. The color shall be specified on drawings, in material specifications and otherwise.

3.3.1 Unless otherwise specified, injection molding of test specimens shall be accomplished per ISO 294 with the conditions for injection molding from ISO 7792. Before processing, the moisture content of the sample shall not exceed 0.02%. Test specimens shall be conditioned in a controlled atmosphere of $+23\text{ }^{\circ}\text{C} \pm 2\text{ }^{\circ}\text{C}$ and $50\% \pm 6\%$ Relative Humidity (RH) for at least 24 h prior to test. All tests shall be performed on unannealed specimens in a controlled atmosphere of $+23\text{ }^{\circ}\text{C} \pm 2\text{ }^{\circ}\text{C}$ and $50\% \pm 5\%$ RH unless otherwise specified. In addition, tests specified at temperatures below or above $+23\text{ }^{\circ}\text{C} \pm 2\text{ }^{\circ}\text{C}$, shall be conducted at the specified temperature using specimens conditioned at the specified temperature for 4 h minimum. The minimum values specified in the property tables must be met by test specimens in natural, black, or in a standard sampled color if natural or black are not available.

3.3.2 Compound Properties (Natural and Black). The following are also required for full standard approval. The minimum number of lots per test required is one (1) in natural:

- Poisson's Ratio
- Coefficient of Linear Thermal Expansion (CLTE)
- Mold Shrinkage
- Stress Strain Curve at multiple temperatures. For example: -30 °C, +23 °C, +85 °C, +120 °C.

See GMW3013 for the test procedures.

3.3.3 Chemical Requirements. All parts manufactured from molding compounds shall be resistant to the media they contact, such as aliphatic and aromatic hydrocarbons, fuels, lubricants, oils, greases and alcohols, at their places of use.

3.4 Properties Requirements. See Table 1.

3.5 All materials supplied to this standard must comply with GMW3059, Restricted and Reportable Substances, including the requirement to submit a full material composition disclosure to GM via the International Material Data System (IMDS) or via a completed GMW3059 report form.

Table 1: Compound Properties (Natural and Black)

Property	Standard	Unit	Value
Density	ISO 1183	g/cm ³	Target Range 1.29 to 1.33
Melting Temperature	ISO 11357-3	°C	≥ 220
Tensile Modulus	ISO 527-1 ISO 527-2	MPa	2200 to 3100
Tensile Stress at Yield	ISO 527-1 ISO 527-2	MPa	≥ 50
Tensile Strength After Heat Aging 1000 h at +120 °C	ISO 188 ISO 527-1 ISO 527-2	% retention	≥ 100
Notched Charpy Impact after Heat Aging after 1000 h at +120 °C	ISO 188 ISO 179/1eA	% retention	≥ 75
Heat Deflection Temperature Under Load, 0.45 MPa	ISO 75	°C	≥ 140
Heat Deflection Temperature Under Load, 1.8 MPa	ISO 75	°C	≥ 50
Flammability	GMW3232 or ISO 3795 All reporting must be in accordance with GMW3232	mm/minute	Self-Extinguishing or ≤ 100