

ASTADUR™ KB4700

Polybutylene Terephthalate

Marplex Australia Pty. Ltd.

Message:

ASTADUR™ KB4700 is an UL94 V-0 rated flame retardant Polybutylene Terephthalate (PBT) based polymer alloy. Key features are high toughness, easy processing, high heat resistance and rigidity. ASTADUR™ KB4700 is designed to offer improved chemical resistance and dimensional stability in a range of environments.

Note: The letters "U" indicate UV stabilisation has been added [ie: ASTADUR™ KB4700U].

General Information			
Features	Good Chemical Resistance		
	Good Dimensional Stability		
	Good Processability		
	Good Toughness		
	High Heat Resistance		
	High Rigidity		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.28	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/3.8 kg)	16	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.00 mm)	0.70	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	110		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.20 mm)	46.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	> 100	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2400	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	74.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	400	J/m	ASTM D256
Gardner Impact (3.20 mm)	60.0	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.20 mm	110	°C	
0.45 MPa, Unannealed, 12.7 mm	125	°C	
1.8 MPa, Unannealed, 3.20 mm	77.0	°C	
1.8 MPa, Unannealed, 12.7 mm	95.0	°C	
Vicat Softening Temperature	160	°C	ASTM D1525 ⁵
CLTE - Flow	8.5E-5	cm/cm/°C	ASTM D696
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.00 mm)	V-0		UL 94

Glow Wire Ignition Temperature (3.00 mm)	960	°C	AS/NZS 60695.2.12
Injection	Nominal Value	Unit	
Drying Temperature	100 to 120	°C	
Drying Time	4.0 to 6.0	hr	
Rear Temperature	230 to 250	°C	
Middle Temperature	240 to 260	°C	
Front Temperature	250 to 270	°C	
Processing (Melt) Temp	250 to 280	°C	
Mold Temperature	60.0 to 110	°C	
Injection Pressure	40.0 to 130	MPa	
Injection Rate	Moderate		
Back Pressure	0.200 to 0.400	MPa	
Screw Speed	40 to 60	rpm	
Clamp Tonnage	4.0 to 8.0	kN/cm ²	
NOTE			
1.	5.0 mm/min		
2.	5.0 mm/min		
3.	1.3 mm/min		
4.	1.3 mm/min		
5.	Loading 1 (10 N)		

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