

TAROLOX 10 K4

Polybutylene Terephthalate

Taro Plast S.p.A.

Message:

TAROLOX 10 K4 is a Polybutylene Terephthalate (PBT) product filled with 20% glass bead. It can be processed by injection molding and is available in Europe.

Characteristics include:

- Flame Rated
- Good Stiffness
- Medium Viscosity
- Warp Resistant

General Information			
Filler / Reinforcement	Glass Bead,20% Filler by Weight		
Features	Good Flow		
	Good Stiffness		
	Low Warpage		
	Medium Viscosity		
Appearance	Colors Available		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.42	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	15	g/10 min	ISO 1133
Molding Shrinkage			Internal Method
Across Flow	0.40 to 0.70	%	
Flow	0.30 to 0.70	%	
Water Absorption			ISO 62
23°C, 24 hr	0.050	%	
Saturation, 23°C	0.28	%	
Granule Humidity ¹	< 0.050	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3500	MPa	ISO 527-2/1
Tensile Stress (Break)	60.0	MPa	ISO 527-2/50
Tensile Strain (Break)	2.5	%	ISO 527-2/50
Flexural Modulus ²	6000	MPa	ISO 178
Flexural Stress ³	100	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	4.5	kJ/m ²	ISO 179/1eA
Notched Izod Impact (23°C)	35	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method

Heat Deflection Temperature ⁴ (1.8 MPa, Unannealed)	120	°C	ISO 75-2/A
Vicat Softening Temperature	195	°C	ISO 306/B50
Melting Temperature	225	°C	ISO 11357-3
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index (Solution A)	400	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		UL 94
Glow Wire Flammability Index (2.00 mm)	650	°C	IEC 60695-2-12
Oxygen Index	20	%	ASTM D2863
Injection	Nominal Value	Unit	
Drying Temperature			
--	100	°C	
Pre-heater	120 to 130	°C	
Drying Time			
--	1.0 to 2.0	hr	
Pre-heater	3.0	hr	
Processing (Melt) Temp	250 to 270	°C	
Mold Temperature	80.0 to 110	°C	
Injection Rate	Moderate-Fast		
NOTE			
1.	TARO 002		
2.	1.0 mm/min		
3.	1.0 mm/min		
4.	120°C/hr		

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