4DUR® 9K22150

Polybutylene Terephthalate

4Plas

Message:

4DUR 9K22150 is a Standard Flow 50% Glass Fibre Reinforced PBT

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 50% filler by weight		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	1.72	g/cm³	ISO 1183
Molding Shrinkage			
Vertical flow direction	0.80	%	
Flow direction	0.20	%	
Water Absorption [1] (Equilibrium, 23°C, 50% RH)	0.10	%	ISO 62
Moisture Content	< 800	ppm	ISO 960
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus (23°C)	18000	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	150	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	1.5	%	ISO 527-2/5
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact			ISO 180/1A
-30°C	9.0	kJ/m²	ISO 180/1A
23°C	11	kJ/m²	ISO 180/1A
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature			
0.45 MPa, not annealed	220	°C	ISO 75-2/B
1.8 MPa, not annealed	210	°C	ISO 75-2/A
Vicat Softening Temperature	215	°C	ISO 306/B
Melting Temperature [2]	225	°C	ISO 11357
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	1.0E+14	ohms	IEC 60093
Volume Resistivity	1.0E+16	ohms·cm	IEC 60093
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating			UL 94
1.60 mm	HB		UL 94
3.20 mm	HB		UL 94
Injection	**Nominal Value**	**Unit**	
Drying Temperature	120	°C	

Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	0.040	%
Processing (Melt) Temp	250 - 270	°C
Mold Temperature	60.0 - 100	°C
Injection Rate	Fast	
Holding Pressure	40.0 - 80.0	MPa
Screw Speed	< 200	rpm

Injection instructions
Feed Throat Temperature: 50 - 70 °CBack Pressure: Low

NOTE	
1.	24 Hrs
2.	10 K/min

Recommended distributors for this material

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