

# 4DUR® 9K22130 AS

Polybutylene Terephthalate

4Plas

Message:

4DUR 9K22130 AS is a Standard Flow 30% Glass Fibre Reinforced Anti-Static PBT

| General Information                                       |                                                       |                   |             |
|-----------------------------------------------------------|-------------------------------------------------------|-------------------|-------------|
| Filler / Reinforcement                                    | Glass fiber reinforced material, 30% filler by weight |                   |             |
| Additive                                                  | Antistatic property                                   |                   |             |
| Features                                                  | Antistatic property                                   |                   |             |
| Processing Method                                         | Injection molding                                     |                   |             |
| Physical                                                  | Nominal Value                                         | Unit              | Test Method |
| Density                                                   | 1.53                                                  | g/cm <sup>3</sup> | ISO 1183    |
| Molding Shrinkage                                         |                                                       |                   |             |
| Vertical flow direction                                   | 1.1                                                   | %                 |             |
| Flow direction                                            | 0.30                                                  | %                 |             |
| Water Absorption <sup>1</sup> (Equilibrium, 23°C, 50% RH) | 0.10                                                  | %                 | ISO 62      |
| Mechanical                                                | Nominal Value                                         | Unit              | Test Method |
| Tensile Modulus (23°C)                                    | 9500                                                  | MPa               | ISO 527-2/5 |
| Tensile Stress (Break, 23°C)                              | 135                                                   | MPa               | ISO 527-2/5 |
| Tensile Strain (Break, 23°C)                              | 2.5                                                   | %                 | ISO 527-2/5 |
| Impact                                                    | Nominal Value                                         | Unit              | Test Method |
| Notched Izod Impact                                       |                                                       |                   | ISO 180/1A  |
| -30°C                                                     | 9.0                                                   | kJ/m <sup>2</sup> | ISO 180/1A  |
| 23°C                                                      | 11                                                    | kJ/m <sup>2</sup> | ISO 180/1A  |
| Unnotched Izod Impact Strength                            |                                                       |                   | ISO 180/1U  |
| -30°C                                                     | 55                                                    | kJ/m <sup>2</sup> | ISO 180/1U  |
| 23°C                                                      | 65                                                    | kJ/m <sup>2</sup> | ISO 180/1U  |
| 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                                     | 205                                                   | °C                | ISO 75-2/A  |
| Vicat Softening Temperature                               | 215                                                   | °C                | ISO 306/B   |
| Melting Temperature <sup>2</sup>                          | 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       |

| 0.750 mm                                               | HB            | UL 94 |
|--------------------------------------------------------|---------------|-------|
| 1.60 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 °C Back Pressure: Low |               |       |
| NOTE                                                   |               |       |
| 1.                                                     | 24 Hrs        |       |
| 2.                                                     | 10 K/min      |       |

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