

4DUR® 9K20500

Polybutylene Terephthalate

4Plas

Message:

4DUR 9K20500 is a Standard Flow Heat Stabilised PBT

General Information			
Additive	heat stabilizer		
Features	Thermal Stability		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.31	g/cm ³	ISO 1183
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	0.20	%	ISO 62
Moisture Content	< 1000	ppm	ISO 960
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2500	MPa	ISO 527-2/5
Tensile Stress			ISO 527-2/5
Yield, 23°C	55.0	MPa	ISO 527-2/5
Fracture, 23°C	55.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	30	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			
-30°C	4.0	kJ/m ²	ISO 179
23°C	5.0	kJ/m ²	ISO 179/B
Charpy Unnotched Impact Strength			ISO 179/1U
-30°C	No Break		ISO 179/1U
23°C	No Break		ISO 179/1U
Notched Izod Impact			ISO 180/1A
-30°C	5.0	kJ/m ²	ISO 180/1A
23°C	6.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength (23°C)	No Break		ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	154	°C	ISO 75-2/B
1.8 MPa, not annealed	60.0	°C	ISO 75-2/A
Vicat Softening Temperature	175	°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	240 - 260	°C	
Mold Temperature	60.0 - 100	°C	
Injection Rate	Moderate-Fast		
Holding Pressure	40.0 - 80.0	MPa	
Screw Speed	300	rpm	
Injection instructions			
Feed Throat Temperature: 50 - 70 °C Back Pressure: Low			
NOTE			
1.	24 Hrs		
2.	10 K/min		

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