

4TECH® 9KF20400

Polycarbonate + PBT
4Plas

Message:

4TECH 9KF20400 is a Standard Flow UV Stabilised PBT / Polycarbonate Blend

General Information			
Additive	UV stabilizer		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.21	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 (Break, 23°C)	65.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	75	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	No Break		ISO 179/1eU
23°C	No Break		ISO 179/1eU
Notched Izod Impact			ISO 180/1A
-30°C	9.0	kJ/m ²	ISO 180/1A
23°C	10	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	110	°C	ISO 75-2/B
1.8 MPa, not annealed	85.0	°C	ISO 75-2/A
Melting Temperature ²	120	°C	ISO 11357
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	ohms	IEC 60093
Volume Resistivity	1.0E+13	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	0.020	%
Processing (Melt) Temp	230 - 270	°C
Mold Temperature	50.0 - 110	°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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