

4DUR® 9K22145

Polybutylene Terephthalate

4Plas

Message:

4DUR 9K22145 is a Standard Flow 45% Glass Fibre Reinforced PBT

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 45% filler by weight		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.68	g/cm ³	ISO 1183
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)	16000	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
Flexural Modulus ² (23°C)	12000	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ISO 180/1A
-30°C	8.0	kJ/m ²	ISO 180/1A
23°C	9.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	215	°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			
-- ³	220	°C	ISO 11357
--	225	°C	
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
Glow Wire Ignition Temperature (2.00 mm)	650	°C	IEC 60695-2-13
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. 2.0 mm/min
3. 10 K/min

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