

4DUR® 9K22117

Polybutylene Terephthalate + PET
4Plas

Message:

4DUR 9K22117 is a Standard Flow 17% Glass Fibre Reinforced PBT/PET Alloy

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 17% filler by weight		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.43	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (270°C/2.16 kg)	63	g/10 min	ISO 1133
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	0.15	%	ISO 62
Moisture Content	< 1000	ppm	ISO 960
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	6000	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	110	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	5.0	kJ/m ²	ISO 180/1A
-20°C	7.0	kJ/m ²	ISO 180/1A
23°C	7.5	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength			ISO 180/1U
-30°C	40	kJ/m ²	ISO 180/1U
23°C	45	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	210	°C	ISO 75-2/B
1.8 MPa, not annealed	190	°C	ISO 75-2/A
Vicat Softening Temperature	205	°C	ISO 306/B
Melting Temperature ²	220	°C	ISO 11357
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	ohms	IEC 60093
Volume Resistivity	1.0E+15	ohms · cm	IEC 60093
Comparative Tracking Index	205	V	IEC 60112
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)	750	°C
		IEC 60695-2-13
Injection	Nominal Value	Unit
Drying Temperature	120	°C
Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	0.020	%
Processing (Melt) Temp	240 - 280	°C
Mold Temperature	50.0 - 110	°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	

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