

4DUR® 9K22120 FR5W

Polybutylene Terephthalate

4Plas

Message:

4DUR 9K22120 FR5W is a Standard Flow 20% Glass Fibre Reinforced FR-V0 Halogen Free, Low Warp PBT

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Features	Low warpage		
	Halogen-free		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.62	g/cm ³	ISO 1183
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	0.20	%	ISO 62
Moisture Content	< 800	ppm	ISO 960
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	8500	MPa	ISO 527-2/5
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 (1.8 MPa, Unannealed)	195	°C	ISO 75-2/A
Melting Temperature ²	225	°C	ISO 11357
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.750 mm	V-0		UL 94
1.60 mm	5VA		UL 94
Glow Wire Flammability Index (2.00 mm)	960	°C	IEC 60695-2-12
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

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| 1. | 24 Hrs |
| 2. | 10 K/min |

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