

4DUR® 9K22220 FR1

Polybutylene Terephthalate
4Plas

Message:

4DUR 9K22220 FR1 is a Standard Flow 20% Glass Bead Filled FR-V0 PBT

General Information			
Filler / Reinforcement	Glass beads, 20% filler by weight		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.57	g/cm ³	ISO 1183
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	0.13	%	ISO 62
Moisture Content	< 1000	ppm	ISO 960
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	3750	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	60.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	4.0	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			
-30°C	5.0	kJ/m ²	ISO 179
23°C	6.0	kJ/m ²	ISO 179/B
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	35	kJ/m ²	ISO 179/1eU
23°C	40	kJ/m ²	ISO 179/1eU
Notched Izod Impact			ISO 180/1A
-20°C	4.0	kJ/m ²	ISO 180/1A
23°C	5.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	170	°C	ISO 75-2/B
1.8 MPa, not annealed	70.0	°C	ISO 75-2/A
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	V-0		UL 94
3.20 mm	V-0		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			
1.	24 Hrs		
2.	10 K/min		

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

