

4TECH® 9KL32130

Polybutylene Terephthalate + PET

4Plas

Message:

4TECH 9KL32130 is a High flow 30% Glass Fibre Reinforced PBT / PET Blend

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Features	High liquidity		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.55	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (270°C/2.16 kg)	40	g/10 min	ISO 1133
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)	10000	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	130	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	2.0	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ISO 180/1A
-30°C	7.0	kJ/m ²	ISO 180/1A
23°C	8.0	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	195	°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
0.750 mm	HB		UL 94
1.60 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	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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