

4DUR® 9K22720

Polybutylene Terephthalate
4Plas

Message:

4DUR 9K22720 is a Standard Flow Carbon Fibre Reinforced PBT

General Information			
Filler / Reinforcement	Carbon fiber reinforced material		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.40	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)	16000	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	120	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	1.5	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ISO 180/1A
-30°C	6.0	kJ/m ²	ISO 180/1A
23°C	7.0	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
Melting Temperature ²	225	°C	ISO 11357
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+3	ohms · cm	IEC 60093
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 °CBack Pressure: Low			

NOTE

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

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Recommended distributors for this material

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