

4DUR® 9K29600

Polybutylene Terephthalate

4Plas

Message:

4DUR 9K29600 is a High Viscosity Food Grade PBT

General Information			
Features	Compliance of Food Exposure		
	Viscosity, High		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.30	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (270°C/2.16 kg)	20	g/10 min	ISO 1133
Molding Shrinkage			
Vertical flow direction	1.6	%	
Flow direction	1.6	%	
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2500	MPa	ISO 527-2/5
Tensile Stress (Yield, 23°C)	60.0	MPa	ISO 527-2/5
Tensile Strain (Yield, 23°C)	55	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ISO 180/1A
-30°C	4.0	kJ/m ²	ISO 180/1A
23°C	6.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength (23°C)	No Break		ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	65.0	°C	ISO 75-2/A
Melting Temperature ²	225	°C	ISO 11357
Flammability	Nominal Value		Test Method
Flame Rating (1.60 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	120	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.040	%	
Processing (Melt) Temp	240 - 260	°C	
Mold Temperature	60.0 - 100	°C	

Injection Rate	Moderate-Fast	
Holding Pressure	40.0 - 80.0	MPa
Screw Speed	300	rpm

Injection instructions

Feed Throat Temperature: 50 - 70 °CBack Pressure: Low

NOTE

1.	24 Hrs
2.	10 K/min

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection.All rights belong to the original authors. If any infringement occurs, please contact us immediately.

Recommended distributors for this material

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

