

Ultradur® B 4330 G6 HR BK15045

Polybutylene Terephthalate

BASF Corporation

Message:

Ultradur B 4330 G6 HR BK15045 product is a hydrolysis resistant, pigmented black 30% glass reinforced impact modified injection molding PBT.

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Additive	Impact Modifier		
Features	Hydrolysis Resistant		
	Impact Modified		
Agency Ratings	EC 1907/2006 (REACH)		
RoHS Compliance	RoHS Compliant		
Appearance	Black		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.49	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (250°C/10.0 kg)	46.0	cm ³ /10min	ISO 1133
Viscosity Number (Reduced Viscosity)	106.0	ml/g	ISO 1628
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	8500	MPa	ISO 527-2
Tensile Stress (Break, 23°C)	120	MPa	ISO 527-2
Tensile Strain (Break, 23°C)	3.4	%	ISO 527-2
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	14	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength			ISO 179
-30°C	60	kJ/m ²	
23°C	74	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	220	°C	ISO 75-2/B
1.8 MPa, Unannealed	205	°C	ISO 75-2/A
Melting Temperature (DSC)	223	°C	ISO 3146
Injection	Nominal Value	Unit	
Drying Temperature	100 to 120	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.040	%	

Processing (Melt) Temp	250 to 275	°C
Mold Temperature	40.0 to 70.0	°C
Injection Pressure	3.50 to 12.5	MPa
Injection Rate	Fast	
Back Pressure	< 1.00	MPa

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