

4DUR® 9K22220 HFR1

Polybutylene Terephthalate
4Plas

Message:

4DUR 9K22220 HFR1 is a Standard Flow 20% Glass Bead Filled FR-V0, Heat Stabilised PBT

General Information			
Filler / Reinforcement	Glass beads, 20% filler by weight		
Additive	heat stabilizer		
Features	Thermal Stability		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.52	g/cm ³	ISO 1183
Molding Shrinkage			
Vertical flow direction	1.1	%	
Flow direction	0.40	%	
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)	7500	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	100	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	3.0	%	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
Unnotched Izod Impact Strength			ISO 180/1U
-30°C	50	kJ/m ²	ISO 180/1U
23°C	55	kJ/m ²	ISO 180/1U
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	175	°C	ISO 75-2/A
Vicat Softening Temperature	210	°C	ISO 306/B
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
Comparative Tracking Index	225	V	IEC 60112

Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.750 mm	V-2		UL 94
1.60 mm	V-0		UL 94
Glow Wire Flammability Index			IEC 60695-2-12
1.00 mm	960	°C	IEC 60695-2-12
2.00 mm	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature (2.00 mm)	960	°C	IEC 60695-2-13
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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