

4DUR® 9K22135 IUUV

Polybutylene Terephthalate

4Plas

Message:

4DUR 9K22135 IUUV is a Standard Flow 35% Glass Fibre Reinforced Impact Modified, UV Stabilised PBT

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 35% filler by weight		
Additive	Impact modifier		
	UV stabilizer		
Features	Impact modification		
	Good UV resistance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.55	g/cm ³	ISO 1183
Molding Shrinkage			
Vertical flow direction	1.1	%	
Flow direction	0.30	%	
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	0.10	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	9500	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	135	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	2.5	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ISO 180/1A
-30°C	13	kJ/m ²	ISO 180/1A
23°C	15	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	205	°C	ISO 75-2/A
Vicat Softening Temperature	215	°C	ISO 306/B
Melting Temperature ²	220	°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 - 270	°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 °C Back Pressure: Low

NOTE

1.	24 Hrs
2.	10 K/min

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