

Ultradur® B 2550 FC

Polybutylene Terephthalate

BASF Corporation

Message:

Ultradur B 2550 FC is an unfilled, easy flow PBT offering good heat resistance. This grade is a food contact grade.

Applications

Applications include monofilament, bristles and heat-resistant coatings on paper and board used for packaging frozen foods and oven-ready meals. Also for injection molding applications that call for high flowability.

General Information			
Features	Good liquidity		
	Heat resistance, medium		
	Compliance of Food Exposure		
Uses	monofilament		
	Food packaging		
	Paper coating		
Agency Ratings	EC 1907/2006 (REACH)		
RoHS Compliance	RoHS compliance		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.30	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (250°C/2.16 kg)	40.0	cm ³ /10min	ISO 1133
Viscosity Number (Reduced Viscosity)	107.0	ml/g	ISO 1628
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness	130	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2500	MPa	ISO 527-2
Tensile Stress (Yield, 23°C)	57.0	MPa	ISO 527-2
Tensile Strain (Yield, 23°C)	3.7	%	ISO 527-2
Nominal Tensile Strain at Break (23°C)	35	%	ISO 527-2
Tensile Creep Modulus (1000 hr)	1100	MPa	ISO 899-1
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	6.0	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength (23°C)	250	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	65.0	°C	ISO 75-2/A

Melting Temperature (DSC)	223	°C	ISO 3146
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+13	ohms	IEC 60093
Volume Resistivity	1.0E+14	ohms·cm	IEC 60093
Dielectric Constant			IEC 60250
100 Hz	3.30		IEC 60250
1 MHz	3.30		IEC 60250
Dissipation Factor			IEC 60250
100 Hz	1.3E-3		IEC 60250
1 MHz	0.020		IEC 60250
Comparative Tracking Index	500	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	HB		UL 94
Extrusion	Nominal Value	Unit	
Drying Temperature	100 - 120	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.040	%	
Cylinder Zone 1 Temp.	260 - 265	°C	
Cylinder Zone 2 Temp.	265 - 275	°C	
Cylinder Zone 3 Temp.	260 - 270	°C	
Cylinder Zone 4 Temp.	255 - 265	°C	
Melt Temperature	260 - 270	°C	
Head Temperature	260 - 270	°C	
Extruder Screw L/D Ratio	>25.0:1.0		
Extruder Screw Compression Ratio	3.5:1.0 to 4.0:1.0		
Die Temperature	260 - 270	°C	
Extrusion instructions			

Pump: 260-270 degC (500-518 degF) Recommended Screw: Three section screw: 6D/7D/9D + 3D Water Bath Temperature: 45-60 degC (113-140 degF)

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