

ASTADUR™ PBT B4500

Polybutylene Terephthalate

Marplex Australia Pty. Ltd.

Message:

ASTADUR™ B4500 is a standard grade of Polybutylene Terephthalate (PBT) polymer. It has excellent processability, high rigidity good dimensional stability and is resistant to chemical attack.

Note: The letters "UV" indicate UV stabilisation has been added [ie: ASTADUR™ B4500UV].

General Information			
Features	Good dimensional stability		
	Rigidity, high		
	Workability, good		
	Good chemical resistance		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.31	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	25	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.00 mm)	1.5	%	ASTM D955
Water Absorption (Saturation)	0.50	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	112		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.20 mm)	55.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	100	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2450	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	85.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	40	J/m	ASTM D256
Dart Drop Impact (3.20 mm)	> 84.0	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.20mm	165	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	50.0	°C	ASTM D648
Vicat Softening Temperature	200	°C	ASTM D1525 ⁵
CLTE - Flow	1.0E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+16	ohms · cm	ASTM D257
Dielectric Strength	140	kV/mm	IEC 60243-1
Comparative Tracking Index (Solution A)	550	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method

Flame Rating (1.60 mm)	HB	UL 94
Glow Wire Ignition Temperature (1.60 mm)	550	°C
		AS/NZS 60695
Injection	Nominal Value	Unit
Drying Temperature	100 - 120	°C
Drying Time	4.0 - 6.0	hr
Rear Temperature	230 - 240	°C
Middle Temperature	240 - 250	°C
Front Temperature	250 - 260	°C
Processing (Melt) Temp	230 - 270	°C
Mold Temperature	70.0 - 120	°C
Injection Pressure	40.0 - 130	MPa
Injection Rate	Moderate-Fast	
Back Pressure	0.200 - 0.350	MPa
Screw Speed	40 - 60	rpm
Clamp Tonnage	4.0 - 8.0	kN/cm ²
Extrusion instructions		
Peripheral Speed: 200 mm/s		
NOTE		
1.	5.0 mm/min	
2.	5.0 mm/min	
3.	1.3 mm/min	
4.	1.3 mm/min	
5.	压力1 (10N)	

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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

