

4DUR® 9K22730 FR3

Polybutylene Terephthalate
4Plas

Message:

4DUR 9K22730 FR3 is a Standard Flow 30% Carbon Fibre Reinforced FR-V2 PBT

General Information			
Filler / Reinforcement	Carbon fiber reinforced material, 30% filler by weight		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.40	g/cm ³	ISO 1183
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	0.14	%	ISO 62
Moisture Content	< 1000	ppm	ISO 960
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	24000	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	150	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	1.5	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			
-30°C	6.0	kJ/m ²	ISO 179
23°C	8.0	kJ/m ²	ISO 179/B
Notched Izod Impact			ISO 180/1A
-30°C	6.0	kJ/m ²	ISO 180/1A
23°C	7.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength			ISO 180/1U
-30°C	40	kJ/m ²	ISO 180/1U
23°C	45	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Melting Temperature ²	225	°C	ISO 11357
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	< 1.0E+3	ohms	IEC 60093
Volume Resistivity	< 1.0E+3	ohms · cm	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	V-2		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	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 °CBack Pressure: Low

NOTE

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| 1. | 24 Hrs |
| 2. | 10 K/min |

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Recommended distributors for this material

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



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