

4DUR® 9K22220

Polybutylene Terephthalate

4Plas

Message:

4DUR 9K22220 is a Standard Flow 20% Glass Bead Filled PBT

General Information			
Filler / Reinforcement	Glass beads, 20% filler by weight		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.45	g/cm ³	ISO 1183
Molding Shrinkage			
Vertical flow direction	1.4	%	
Flow direction	1.4	%	
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)	3250	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	55.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	4.0	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ISO 180/1A
-30°C	3.0	kJ/m ²	ISO 180/1A
23°C	4.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	170	°C	ISO 75-2/B
1.8 MPa, not annealed	70.0	°C	ISO 75-2/A
Vicat Softening Temperature	185	°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
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.60 mm	HB		UL 94
3.20 mm	HB		UL 94
Injection	Nominal Value	Unit	Test Method
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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