

4DUR® 9K22130 FR1

Polybutylene Terephthalate

4Plas

Message:

4DUR 9K22130 FR1 is a Standard Flow 30% Glass Fibre Reinforced FR-V0 PBT

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.65	g/cm ³	ISO 1183
Molding Shrinkage			
Vertical flow direction	1.0	%	
Flow direction	0.30	%	
Water Absorption			ISO 62
Saturated, 23°C	0.10	%	ISO 62
Equilibrium, 23°C, 50% RH ¹	0.30	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	11000	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	130	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	2.0	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ISO 180/1A
-30°C	8.0	kJ/m ²	ISO 180/1A
23°C	9.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	220	°C	ISO 75-2/B
1.8 MPa, not annealed	205	°C	ISO 75-2/A
Vicat Softening Temperature	210	°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
Comparative Tracking Index	225	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	V-0		UL 94
Glow Wire Ignition Temperature (2.00 mm)	960	°C	IEC 60695-2-13
Injection	Nominal Value	Unit	
Drying Temperature	120	°C	

Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	0.040	%
Processing (Melt) Temp	230 - 270	°C
Mold Temperature	60.0 - 100	°C
Injection Rate	Moderate-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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