

4DUR® 9K10000

Polybutylene Terephthalate

4Plas

Message:

4DUR 9K10000 is a Extrusion Unfilled PBT

General Information			
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.31	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (270°C/2.16 kg)	10	g/10 min	ISO 1133
Molding Shrinkage			
Vertical flow direction	1.6	%	
Flow direction	1.6	%	
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2500	MPa	ISO 527-2/5
Tensile Stress			ISO 527-2/5
Yield, 23°C	55.0	MPa	ISO 527-2/5
Fracture, 23°C	55.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	30	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ISO 180/1A
-30°C	7.0	kJ/m ²	ISO 180/1A
23°C	8.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	60.0	°C	ISO 75-2/A
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 (3.20 mm)	HB		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	240 - 260	°C
Mold Temperature	60.0 - 100	°C
Injection Rate	Moderate-Fast	
Holding Pressure	40.0 - 80.0	MPa
Screw Speed	300	rpm

Injection instructions

Feed Throat Temperature: 50 - 70 °C Back Pressure: Low

Extrusion	Nominal Value	Unit
Drying Temperature	120	°C
Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	0.040	%
Melt Temperature	240 - 260	°C
Die Temperature	60.0 - 100	°C

NOTE

1. 24 Hrs
2. 10 K/min

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