

# 4DUR® 9K22330 XFR1

Polybutylene Terephthalate

4Plas

Message:

4DUR 9K22330 XFR1 is a Standard Flow 30% Glass Fibre & Bead Reinforced UL listed FR-V0 PBT

| General Information                                       |                                                |                   |             |
|-----------------------------------------------------------|------------------------------------------------|-------------------|-------------|
| UL YellowCard                                             | E362510-102158796                              |                   |             |
| Filler / Reinforcement                                    | Glass Beads \Glass Fiber, 30% Filler by Weight |                   |             |
| Processing Method                                         | Injection molding                              |                   |             |
| Physical                                                  | Nominal Value                                  | Unit              | Test Method |
| Density                                                   | 1.69                                           | g/cm <sup>3</sup> | ISO 1183    |
| Molding Shrinkage - Flow                                  | 1.0                                            | %                 |             |
| Water Absorption <sup>1</sup> (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)                                    | 7500                                           | MPa               | ISO 527-2/5 |
| Tensile Stress (Break, 23°C)                              | 90.0                                           | MPa               | ISO 527-2/5 |
| Tensile Strain (Break, 23°C)                              | 2.5                                            | %                 | ISO 527-2/5 |
| Flexural Modulus <sup>2</sup> (23°C)                      | 7000                                           | MPa               | ISO 178     |
| Flexural Stress                                           | 142                                            | MPa               | ISO 178     |
| Impact                                                    | Nominal Value                                  | Unit              | Test Method |
| Notched Izod Impact                                       |                                                |                   | ISO 180/1A  |
| -30°C                                                     | 6.0                                            | kJ/m <sup>2</sup> | ISO 180/1A  |
| 23°C                                                      | 8.0                                            | kJ/m <sup>2</sup> | ISO 180/1A  |
| Unnotched Izod Impact Strength                            |                                                |                   | ISO 180/1U  |
| -30°C                                                     | 23                                             | kJ/m <sup>2</sup> | ISO 180/1U  |
| 23°C                                                      | 24                                             | kJ/m <sup>2</sup> | ISO 180/1U  |
| Thermal                                                   | Nominal Value                                  | Unit              | Test Method |
| Heat Deflection Temperature                               |                                                |                   |             |
| 0.45 MPa, not annealed                                    | 215                                            | °C                | ISO 75-2/B  |
| 1.8 MPa, not annealed                                     | 195                                            | °C                | ISO 75-2/A  |
| Vicat Softening Temperature                               | 215                                            | °C                | ISO 306/B   |
| Melting Temperature <sup>3</sup>                          | 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                                | 175                                            | V                 | IEC 60112   |
| Flammability                                              | Nominal Value                                  | Unit              | Test Method |

| Flame Rating (1.60 mm)                                | V-0           | UL 94             |
|-------------------------------------------------------|---------------|-------------------|
| Glow Wire Flammability Index (2.00 mm)                | 960           | °C IEC 60695-2-12 |
| 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                                                  |               |                   |
| 1.                                                    | 24 Hrs        |                   |
| 2.                                                    | 2.0 mm/min    |                   |
| 3.                                                    | 10 K/min      |                   |

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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



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