

4TECH® 9KL22115 H

Polybutylene Terephthalate + PET
4Plas

Message:

4TECH 9KL22115 H is a Standard Flow 15% Glass Fibre Reinforced Heat Stabilised PBT / PET Blend

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 15% filler by weight		
Additive	heat stabilizer		
Features	Thermal Stability		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
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)	7500	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	100	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	3.0	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (-30°C)	5.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength (-30°C)	35	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	210	°C	ISO 75-2/B
1.8 MPa, not annealed	175	°C	ISO 75-2/A
Melting Temperature ²	255	°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
0.750 mm	HB		UL 94
1.60 mm	HB		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	0.020	%	
Processing (Melt) Temp	240 - 280	°C	

Mold Temperature	50.0 - 110	°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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