

Arnite® TM4 440

Polybutylene Terephthalate + PET
DSM Engineering Plastics

Message:

Arnite® TM4 440 is a Polybutylene Terephthalate + PET (PBT+PET) material filled with 20% mineral. It is available in Europe. Primary attribute of Arnite® TM4 440: Flame Rated.

General Information			
Filler / Reinforcement	Mineral,20% Filler by Weight		
Forms	Pellets		
Physical	Nominal Value	Unit	Test Method
Density	1.48	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow	1.7	%	
Flow	1.4	%	
Water Absorption			ISO 62
Saturation, 23°C	0.35	%	
Equilibrium, 23°C, 50% RH	0.15	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	5100	MPa	ISO 527-2
Tensile Stress (Break)	57.0	MPa	ISO 527-2
Tensile Strain (Break)	1.9	%	ISO 527-2
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	1.8	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	31	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	195	°C	ISO 75-2/B
1.8 MPa, Unannealed	100	°C	ISO 75-2/A
Melting Temperature ¹	225	°C	ISO 11357-3
Flammability	Nominal Value		Test Method
Flammability Classification (1.50 mm)	HB		IEC 60695-11-10, -20
Injection	Nominal Value	Unit	
Drying Temperature	100 to 120	°C	
Drying Time	3.0 to 12	hr	
Rear Temperature	230 to 240	°C	
Middle Temperature	230 to 250	°C	
Front Temperature	240 to 260	°C	
Nozzle Temperature	240 to 260	°C	
Processing (Melt) Temp	240 to 270	°C	

Mold Temperature	60.0 to 100	°C
Injection Rate	Moderate-Fast	
Back Pressure	3.00 to 10.0	MPa
Screw Compression Ratio	2.5:1.0	

NOTE

1.	10°C/min
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Recommended distributors for this material

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