

4DUR® 23K20000

Polybutylene Terephthalate

4Plas

Message:

4DUR 23K20000 is a Near Prime Standard Flow Unfilled PBT

General Information			
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.31	g/cm ³	ISO 1183
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 (Break, 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	4.0	kJ/m ²	ISO 180/1A
23°C	6.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (0.45 MPa, Unannealed)	160	°C	ISO 75-2/B
Vicat Softening Temperature	175	°C	ISO 306/B
Melting Temperature ²	225	°C	ISO 11357
Flammability	Nominal Value		Test Method
Flame Rating (1.60 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 °CBack Pressure: Low			
NOTE			
1.	24 Hrs		
2.	10 K/min		

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