

# **Ultradur® B 4330 G6 HR** **BK15045** **Polybutylene Terephthalate (PBT)**



## Product Description

Ultradur B 4330 G6 HR BK15045 product is a hydrolysis resistant, pigmented black 30% glass reinforced impact modified injection molding PBT.

PHYSICAL	ISO Test Method	Property Value
Density, g/cm <sup>3</sup>	1183	1.49
Viscosity Number, cm <sup>3</sup> /g	1628	106
RHEOLOGICAL	ISO Test Method	Property Value
Melt Volume Rate (250 C/10 Kg), cc/10min.	1133	46
MECHANICAL	ISO Test Method	Property Value
Tensile Modulus, MPa	527	
23C		8,500
Tensile stress at break, MPa	527	
23C		120
Tensile strain at break, %	527	
23C		3.4
IMPACT	ISO Test Method	Property Value
Charpy Notched, kJ/m <sup>2</sup>	179	
23C		14
Charpy Unnotched, kJ/m <sup>2</sup>	179	
-30C		60
23C		74
THERMAL	ISO Test Method	Property Value
Melting Point, C	3146	223
HDT A, C	75	205
HDT B, C	75	220

## Processing Guidelines

### Material Handling

Max. Water content: 0.04%

To ensure optimum part performance, this product must be dried prior to molding and maintained at a moisture level of less than 0.04%. Dehumidifying or desiccant dryers operating at 100-120C (212-248F) at 4 hours drying time is recommended. Further information concerning safe handling procedures can be obtained from the Safety Data Sheet. Alternatively, please contact your BASF representative.

### Typical Profile

Melt Temperature 250-275C (482-527F)

Mold Temperature 40-70C (105-158F)

Injection and Packing Pressure 35-125 bar (500-1500 psi)

### Mold Temperatures

This product can be processed over mold temperatures of 60-100C (140-212F).

### Pressures

Injection pressure controls the filling of the part and should be applied for 90% of ram travel. Packing pressure affects the final part and can be used effectively in controlling sink marks and shrinkage. It should be applied and maintained until the gate area is completely frozen off.

Back pressure can be utilized to provide uniform melt consistency and reduce trapped air and gas. A maximum of 10 bar (145 psi) is recommended due to the risk of excessive shear.

#### **Fill Rate**

Fast fill rates are recommended to ensure uniform melt delivery to the cavity and prevent premature freezing. Surface appearance is directly affected by injection rate.

#### **Note**

Although all statements and information in this publication are believed to be accurate and reliable, they are presented gratis and for guidance only, and risks and liability for results obtained by use of the products or application of the suggestions described are assumed by the user. NO WARRANTIES OF ANY KIND, EITHER EXPRESS OR IMPLIED, INCLUDING WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE, ARE MADE REGARDING PRODUCTS DESCRIBED OR DESIGNS, DATA OR INFORMATION SET FORTH. Statements or suggestions concerning possible use of the products are made without representation or warranty that any such use is free of patent infringement and are not recommendations to infringe any patent. The user should not assume that toxicity data and safety measures are indicated or that other measures may not be required.