Product Information

Aug 2020

Ultradur® B 4406 G6 Q717
Polybutylene Terephthalate (PBT)

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Product Description

Ultradur B 4406 G6 Q717 is an UL V0 injection molding, PBT grade with 30% glass fiber reinforcement.

PHYSICAL	ISO Test Method	Property Value
Density, g/cm³	1183	1.68
Viscosity Number, cm³/g	1628	98
Moisture, %	62	
(50% RH)		0.2
(Saturation)		0.4
RHEOLOGICAL	**ISO Test Method**	**Property Value**
Melt Volume Rate (275 C/2.16 Kg), cc/10min.	1133	22
MECHANICAL	**ISO Test Method**	**Property Value**
Tensile Modulus, MPa	527	
23C		11,500
Tensile stress at break, MPa	527	
23C		140
Tensile strain at break, %	527	
23C		2.1
Flexural Strength, MPa	178	
23C		220
IMPACT	**ISO Test Method**	**Property Value**
Charpy Notched, kJ/m²	179	
23C		8
Charpy Unnotched, kJ/m²	179	
23C		50
THERMAL	**ISO Test Method**	**Property Value**
Melting Point, C	3146	223
HDT A, C	75	205
HDT B, C	75	220
ELECTRICAL	**ISO Test Method**	**Property Value**
Comparative Tracking Index	IEC 60112	200
Volume Resistivity (Ohm-m)	IEC 60093	>1E13
Dielectric Constant (100 Hz)	IEC 60250	3.9
Dielectric Constant (1 MHz)	IEC 60250	3.9
Dissipation Factor (100 Hz), E-4	IEC 60250	20
Dissipation Factor (1 MHz), E-4	IEC 60250	150
UL RATINGS	**UL Test Method**	**Property Value**
Flammability Rating, 0.4mm	UL94	V-0
Flammability Rating, 0.75mm	UL94	V-0
Relative Temperature Index, 0.75mm	UL746B	
Mechanical w/o Impact, C		125

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Mechanical w/ Impact, C		130
Electrical, C		140
Flammability Rating, 1.5mm	UL94	V-0
Relative Temperature Index, 1.5mm	UL746B	
Mechanical w/o Impact, C		130
Mechanical w/ Impact, C		130
Electrical, C		140
Flammability Rating, 3.0mm	UL94	V-0
Relative Temperature Index, 3.0mm	UL746B	
Mechanical w/o Impact, C		130
Mechanical w/ Impact, C		130
Electrical, C		140

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) for 4 hours drying time are 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 250-270C (482-518F)
Mold Temperature 60-100C (140-212F)
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); however, for optimizing surface appearance, dimensional stability and part performance, mold surface temperatures of at least 80C (176F) are preferred.

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

Note

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