

Ultradur® B 4520 FC Aqua **Polybutylene Terephthalate (PBT)**



Product Description

Ultradur B 4520 FC Aqua is a medium viscosity, rapidly freezing injection molding grade approved for food contact and drinking water contact

PHYSICAL	ISO Test Method	Property Value
Density, g/cm ³	1183	1.30
Viscosity Number, cm ³ /g	1628	130
Mold Shrinkage, parallel, %	294-4	1.5
Mold Shrinkage, normal, %	294-4	1.7
Moisture, %	62	
(50% RH)		0.25
(Saturation)		0.5
RHEOLOGICAL	ISO Test Method	Property Value
Melt Volume Rate (250 C/2.16 Kg), cc/10min.	1133	21
MECHANICAL	ISO Test Method	Property Value
Tensile Modulus, MPa	527	
23C		2,400
Tensile stress at yield, MPa	527	
23C		55
Tensile strain at yield, %	527	
23C		3.7
Nominal strain at break, %	527	
23C		>50
Flexural Strength, MPa	178	
23C		85
Flexural Modulus, MPa	178	
23C		2,400
IMPACT	ISO Test Method	Property Value
Charpy Notched, kJ/m ²	179	
-30C		3
23C		5
Charpy Unnotched, kJ/m ²	179	
23C		N
THERMAL	ISO Test Method	Property Value
Melting Point, C	3146	223
HDT A, C	75	65
HDT B, C	75	165
Coef. of Linear Thermal Expansion, Parallel, mm/mm C		1.3-1.6 X10-4
ELECTRICAL	ISO Test Method	Property Value
Comparative Tracking Index	IEC 60112	550
Volume Resistivity (Ohm-m)	IEC 60093	1E14
Surface Resistivity (Ohm)	IEC 60093	1E13

Dielectric Constant (100 Hz)	IEC 60250	3.4
Dielectric Constant (1 MHz)	IEC 60250	3.3
Dissipation Factor (100 Hz), E-4	IEC 60250	20
Dissipation Factor (1 MHz), E-4	IEC 60250	200
UL RATINGS	UL Test Method	Property Value
Flammability Rating, 0.75mm	UL94	HB
Flammability Rating, 1.5mm	UL94	HB
Flammability Rating, 2.8mm	UL94	HB

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 100-120°C (212-248°F) 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 250-270°C (482-518°F)

Mold Temperature 40-80°C (104-176°F)

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

Mold Temperatures

This product can be processed over mold temperatures of 40-80°C (104-176°F), although 80°C (176°F) will result the best surface.

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

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