

Product description

Injection molding grade with 20 % glass fibers for industrial parts with excellent surface quality, for example external door handles in vehicles, visible sunroof frames, oven door handles, toaster casings, external mirrors, rear screen wiper arms in vehicles and sunroof wind deflectors. Formerly called KR 4040 G4.

Abbreviated designation according to ISO 1043-1: PBT-PET-GF20

Product safety

Ultradur® melts are stable at temperatures up to 280°C and do not give rise to hazards due to molecular degradation or the evolution of gases and vapors. Like all thermoplastic polymers, however, Ultradur decomposes on exposure to excessive thermal stresses, e.g. when it is overheated or as a result of cleaning by burning off. In such cases gaseous decomposition products are formed. Decomposition accelerates above 350°C small quantities of aldehydes and saturated and unsaturated hydrocarbons are also formed. When Ultradur® is properly processed and there is adequate suction at the die no risks to health are to be expected.

Further safety information see safety data sheet of individual product.

Safety data sheet could be ask for at the Ultra-Infopoint under tel: 0621/60-78780 or fax:0621/60-78730.

Physical form and storage

Standard packaging includes the 25-kg-bag and the 1000 kg octabin (octagonal container). Other forms of packaging are possible subject to agreement. All containers are tightly sealed and should be opened only immediately prior to processing. Further precautions for preliminary treatment and drying are described in the processing section of the brochure. The bulk density is about 0,7 to 0,8g/cm³.

Ultradur® can be stored for a longer period of time in dry, well vented rooms without causing problems in processing.

Ultradur® should generally have a moisture content of less than 0,04% when being processed.

In order to ensure reliable production, therefore, pre-drying should generally be the rule and the machine should be loaded via a closed conveyor system. Appropriate equipment is commercially available. Pre-drying is also for the addition of batches, e.g. in the case of inhouse pigmentation.

In order to prevent the formation of condensed water, containers stored in unheated rooms must only be opened when they have attained the temperature prevailing in the processing area. This can possibly take a very long time.

Measurements have shown that the interior of a 25-kg bag originally at 5°C had reached the temperature of 20°C in the processing area only after 48 hours.

Note

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our product, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the product for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein may change without prior information and do not constitute the agreed contractual quality of the product. It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed. In order to check the availability of products please contact us or our sales agency.

Product Information

Typical values for uncoloured product at 23 °C ¹⁾	Test method	Unit	Values ²⁾
Properties			
Polymer abbreviation	-	-	(PBT+PET)-GF20
Density	ISO 1183	kg/m ³	1470
Filler content: Glass fiber (GF), glass balls (GB), Mineral (M)	-	%	GF20
Viscosity number (solution 0,005 g/ml Phenole/1,2 Dichlorbenzol 1:1)	ISO 307, 1157, 1628	cm ³ /g	105
coloured	-	-	+
black	-	-	+
Water absorption, equilibrium in water at 23°C	similar to ISO 62	%	0.4
Moisture absorption, equilibrium 23°C/50% r.h.	similar to ISO 62	%	0.20
Processing			
Melt volume-flow rate MVR at 275 °C and 2.16 kg	ISO 1133	cm ³ /10min	22
Melting temperature, DSC	ISO 11357-1/-3	°C	223
Melt temperature, Injection moulding/Extrusion	-	°C	250 - 280
Mould temperature, Injection moulding	-	°C	60 - 100
Moulding shrinkage, free, longitudinal (plate with film gate 150*150*3 mm ³)	-	%	0.21
Moulding shrinkage, free, transverse (plate with film gate 150*150*3 mm ³)	-	%	1.11
Molding shrinkage (parallel)	ISO 2577, 294-4	%	0.40
Molding shrinkage (normal)	ISO 2577, 294-4	%	0.90
Flammability			
Burning Behav. at 1.6 mm nom. thickn.	IEC 60695-11-10	class	HB
Burning Behav. at thickness d = 0.8 mm	IEC 60695-11-10	class	HB
Automotive materials (thickness d >= 1 mm) ³⁾	FMVSS 302	-	+
Mechanical properties			
Tensile modulus	ISO 527-1/-2	MPa	7500
Stress at break	ISO 527-1/-2	MPa	120
Strain at break	ISO 527-1/-2	%	2.8
Charpy unnotched impact strength (23°C)	ISO 179/1eU	kJ/m ²	40
Charpy unnotched impact strength (-30°C)	ISO 179/1eU	kJ/m ²	40
Charpy notched impact strength (23°C)	ISO 179/1eA	kJ/m ²	5.5
Flexural strength	ISO 178	MPa	190
Flexural modulus	ISO 178	MPa	7010
Ball indentation hardness at 358 N and 30 s	ISO 2039-1	MPa	190
Thermal properties			
HDT A (1.80 MPa)	ISO 75-1/-2	°C	180
HDT B (0.45 MPa)	ISO 75-1/-2	°C	215
Max. service temperature (short cycle operation)	-	°C	210
Coefficient of linear thermal expansion, longitudinal (23-80)°C	ISO 11359-1/-2	E-6/K	20 - 30
Specific heat capacity	-	J/(kg*K)	1100
Electrical properties			
Relative permittivity (100Hz)	IEC 60250	-	3.7
Relative permittivity (1 MHz)	IEC 60250	-	3.5
Dissipation factor (100 Hz)	IEC 60250	E-4	14
Dissipation factor (1 MHz)	IEC 60250	E-4	180
Volume resistivity	IEC 60093	Ohm*m	1E14
Surface resistivity	IEC 60093	Ohm	1E13
Comparative tracking index, CTI, test liquid A	IEC 60112	-	300

Footnotes

- 1) If product name or properties don't state otherwise.
- 2) The asterisk symbol "*" signifies inapplicable properties.
- 3) + = passed

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