Product Information

Ultradur® B 4043 G6 HR BK15073

PBT (Polybutylene Terephthalate)

BASF
The Chemical Company

Product Description

Ultradur B 4043 G6 HR BK15073 is a hydrolysis resistant, pigmented black, 30% fiberglass reinforced PBT exhibiting superior surface finish and low warpage.

Applications

Ultradur B 4043 G6 HR BK15073 was developed for thin walled automotive connectors and sensors designed to meet USCAR Class III and NaOH resistance requirements.

MECHANICAL	ISO Test Method	Property Value
Tensile stress at break, MPa	527	
23C		112
Tensile strain at break, %	527	
23C		4.0
Flexural Strength, MPa	178	
23C		170
Flexural Modulus, MPa	178	
23C		7,100
IMPACT	**ISO Test Method**	**Property Value**
Charpy Notched, kJ/m^2	179	
23C		14
Charpy Unnotched, kJ/m^2	179	
23C		70
THERMAL	**ISO Test Method**	**Property Value**
Melting Point, C	3146	223

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 degC (212-248 degF) at 4 hours drying time is recommended. Further information concerning safe handling procedures can be obtained from the Material Safety Data Sheet. Alternatively, please contact your BASF representative.

Typical Profile
Melt Temperature 265-280 degC (510-536 degF)
Mold Temperature 60-100 degC (140-212 degF)
Injection and Packing Pressure 35-125 bar (500-1500 psi)

Mold Temperatures
This product can be processed over mold temperatures of 60-100 degC (140-212 degF).

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.