

Ultradur® B 4330 G6 HR PBT-I-GF30

BASF

Injection-moulding grade containing 30% glass-fibres, for rigid, tough and dimensionally stable technical parts, used in applications with highest demands on hydrolysis resistance such as automotive connectors and housings for electronic units under the hood.

The black colored product Ultradur® B4330 G6 HR BK15045 has a LS coloration (Laser Sensitive) and can be marked with Nd:YAG lasers.

Abbreviated designation according to ISO 1043: PBT-I-GF30

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	19	cm³/10min	ISO 1133
Temperature	260	°C	-
Load	5	kg	-
Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577
Molding shrinkage, normal	1.1	%	ISO 294-4, 2577

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	8500	MPa	ISO 527
Stress at Break	120	MPa	ISO 527
Strain at Break	3.4	%	ISO 527
Impact Strength (Charpy), +23°C	74	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	65	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	14	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	8	kJ/m²	ISO 179/1eA
Flexural Modulus (23°C)	7860	MPa	ISO 178
Flexural strength	190	MPa	ISO 178

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	223	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	205	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	220	°C	ISO 75-1/-2
Coeff. of Linear Therm. Expansion, parallel	25	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	215	E-6/K	ISO 11359-1/-2
Burning Behav. at 1.5 mm Nom. Thickn.	HB	class	UL 94
Thickness tested	1.5	mm	-
UL recognition	yes	-	-
Burning Behav. at thickness h	HB	class	UL 94
Thickness tested	0.8	mm	-
UL recognition	yes	-	-

Electrical Properties	Value	Unit	Test Standard
ISO Data			
Volume Resistivity	>1E13	Ohm*m	IEC 62631-3-1
Surface Resistivity	1E15	Ohm	IEC 62631-3-2
Electric Strength	42	kV/mm	IEC 60243-1
Comparative tracking index	400	-	IEC 60112

Other Properties	Value	Unit	Test Standard
ISO Data			
Water Absorption	0.4	%	Sim. to ISO 62
Humidity absorption	0.2	%	Sim. to ISO 62
Density	1490	kg/m³	ISO 1183

Material Specific Properties	Value	Unit	Test Standard
ISO Data			
Viscosity number	108	cm³/g	ISO 307, 1157, 1628

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80 - 120	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.04	%	-

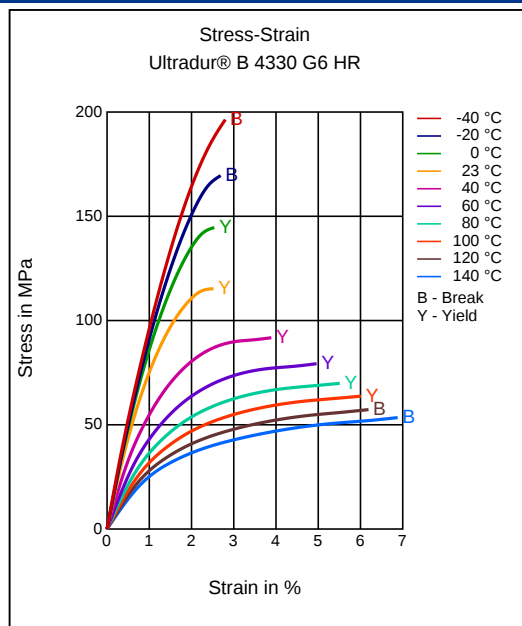
Ultradur® B 4330 G6 HR PBT-I-GF30

BASF

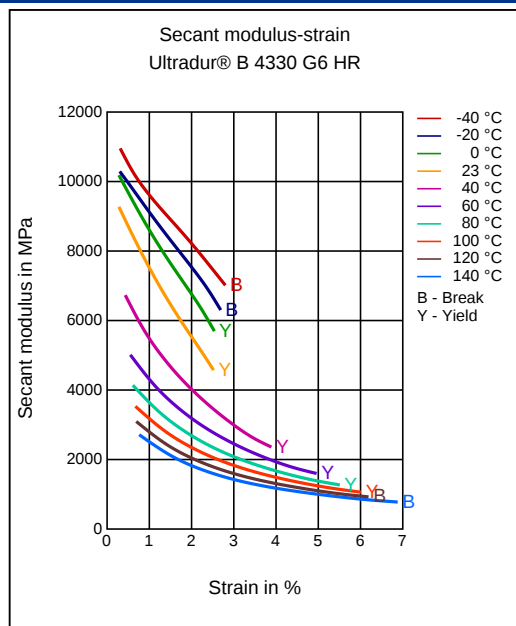
Melt temperature	250 - 280	°C	-
Mold temperature	60 - 100	°C	-

Diagrams

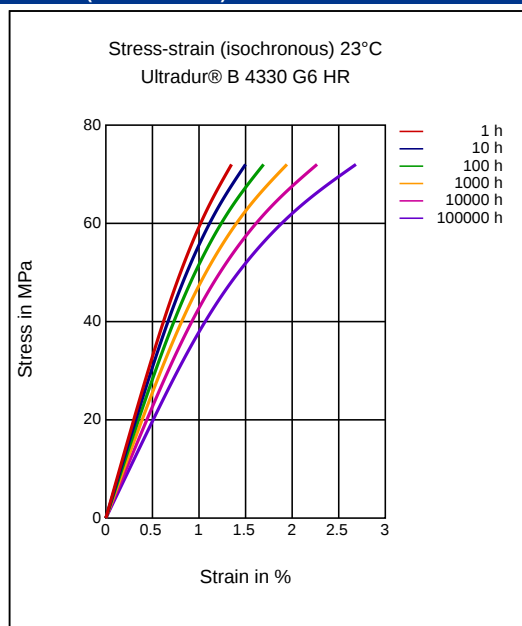
Stress-strain



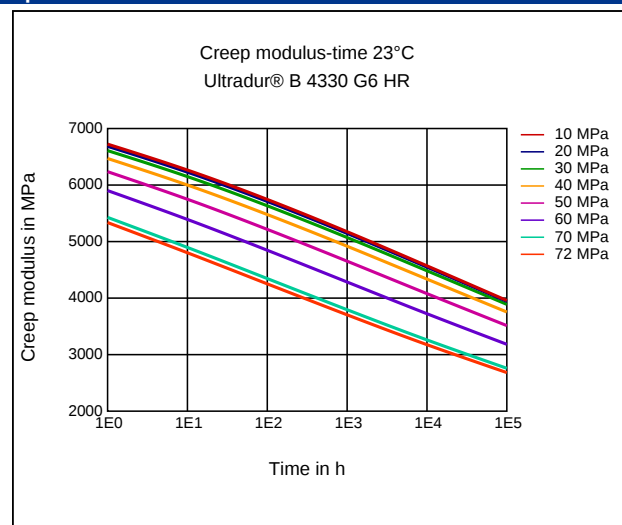
Secant modulus-strain



Stress-strain (isochronous) 23 °C



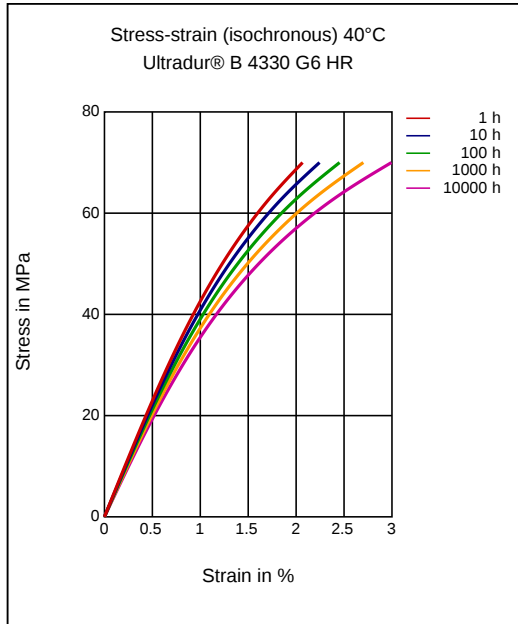
Creep modulus-time 23 °C



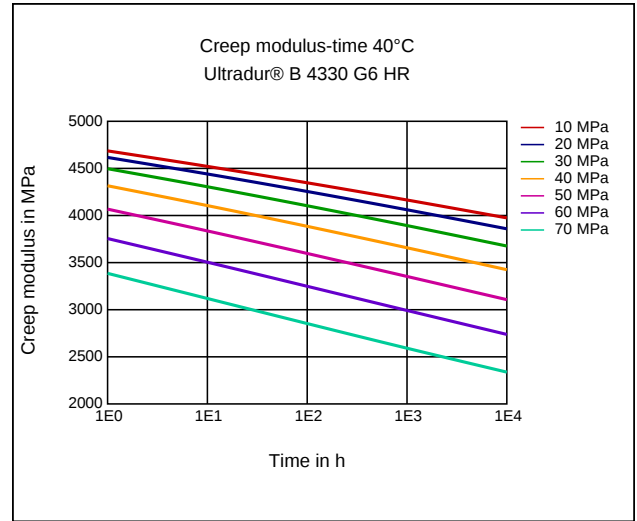
Ultradur® B 4330 G6 HR
PBT-I-GF30

BASF

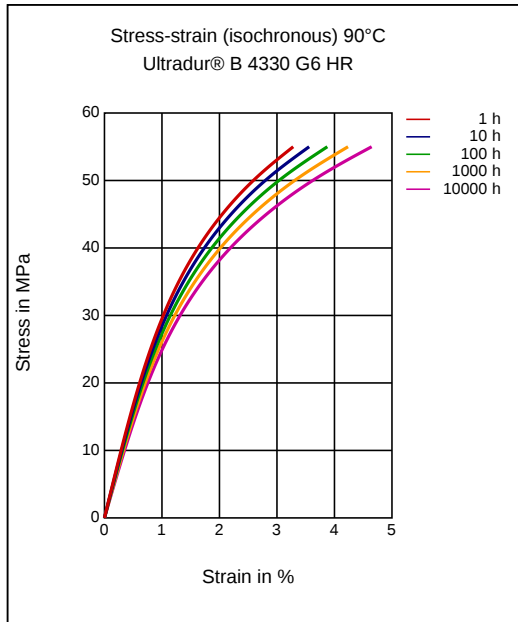
Stress-strain (isochronous) 40 °C



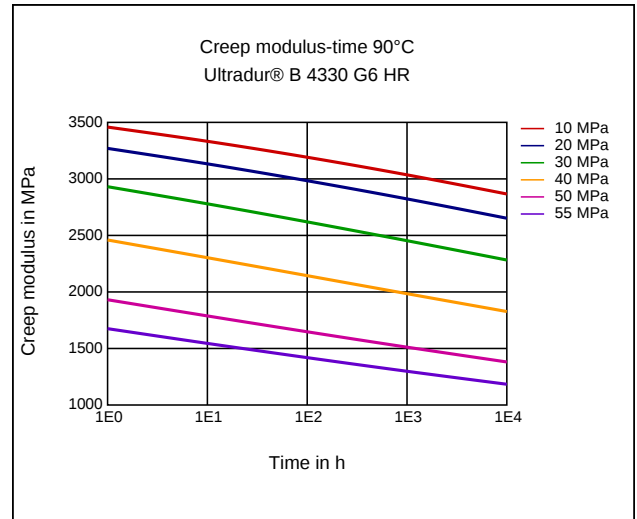
Creep modulus-time 40 °C



Stress-strain (isochronous) 90 °C



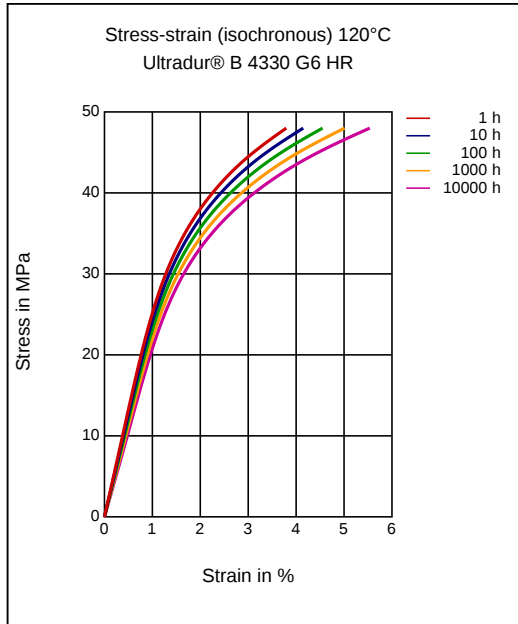
Creep modulus-time 90 °C



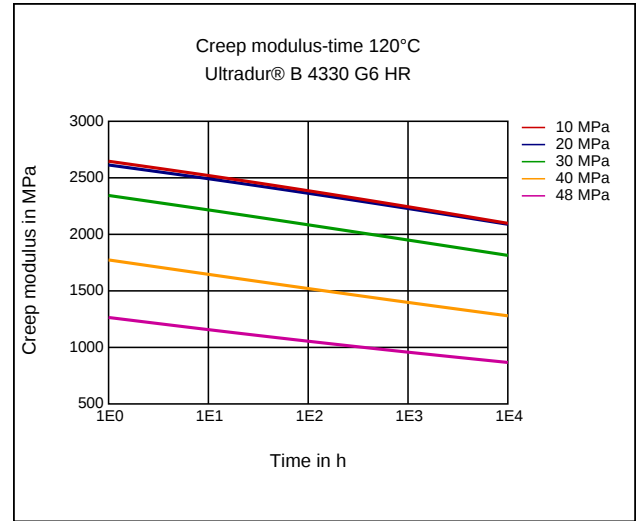
Ultradur® B 4330 G6 HR
PBT-I-GF30

BASF

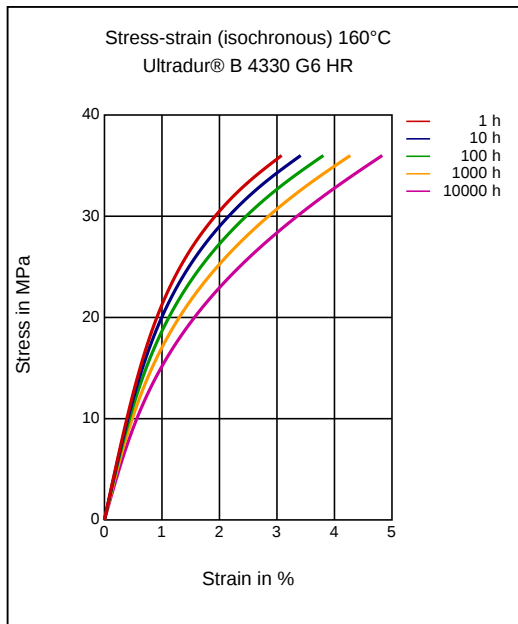
Stress-strain (isochronous) 120°C



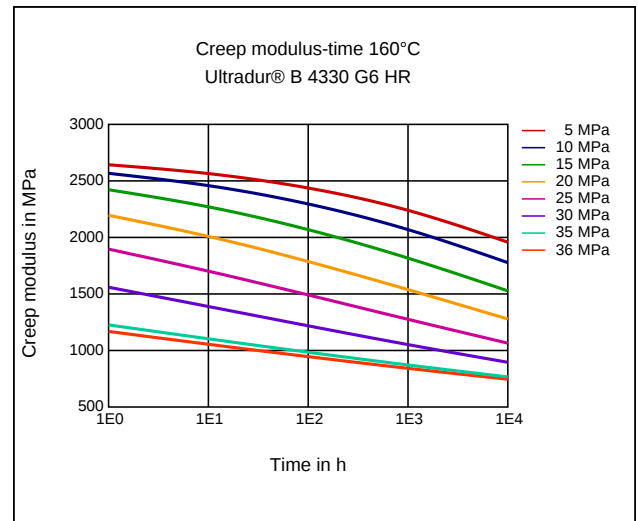
Creep modulus-time 120°C



Stress-strain (isochronous) 160°C



Creep modulus-time 160°C

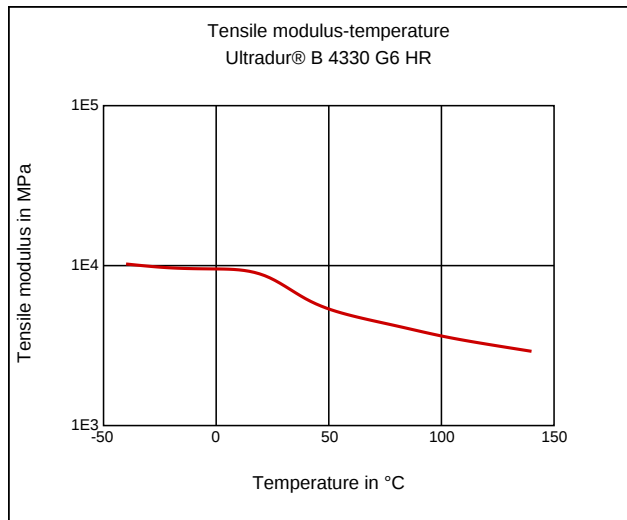


Ultradur® B 4330 G6 HR

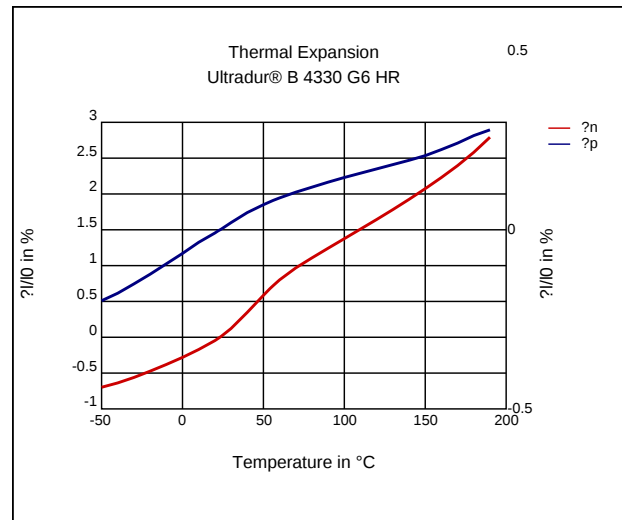
PBT-I-GF30

BASF

Tensile Modulus-Temperature



Coeff. of linear thermal expansion, normal



Characteristics

Processing

Injection Molding

Features

Laser Markable

Special Characteristics

Impact modified

Chemical Resistance

Hydrolysis

Injection Molding

PREPROCESSING

Pre/Post-processing, max. allowed water content: .04 %

Pre/Post-processing, Pre-drying, Temperature: 80 - 120 °C

Pre/Post-processing, Pre-drying, Time: 4 h

PROCESSING

injection molding, Melt temperature, range: 250 - 280 °C

injection molding, Melt temperature, recommended: 260 °C

injection molding, Mold temperature, range: 60 - 100 °C

injection molding, Mold temperature, recommended: 80 °C

Chemical Media Resistance

Acids

- ✓ Acetic Acid (5% by mass) (23°C)