



## PROCESSING GUIDE

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### 4DUR® Polybutylene Terephthalate (PBT)

#### PROCESSING CONDITIONS

	<b>Unreinforced</b>	<b>Impact Modified</b>	<b>Reinforced</b>	<b>Flame Retardant</b>
<b>Drying (°C/Hour)</b>	120/2-4	120/2-4	120/2-4	120/2-4
<b>Maximum Moisture Content (%)</b>	0.04	0.04	0.04	0.04
<b>Feed Throat Temperature (°C)</b>	50 - 70	50 - 70	50 - 70	50 - 70
<b>Processing Temperature (°C)</b>	240 - 260	240 - 260	250 - 270	230 - 260
<b>Mould Temperature (°C)</b>	60 - 100	60 - 100	60 - 100	60 - 100
<b>Hold Pressure (MPa)</b>	40 - 80	40 - 80	40 - 80	40 - 80
<b>Back Pressure</b>	Low	Low	Low	Low
<b>Injection Speed</b>	Medium - Fast	Medium - Fast	Fast	Medium - Fast
<b>Maximum Screw Speed (rpm)</b>	300	300	200	200

\*Products in moisture proof packs do not need pre-drying

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Test Values: Unless specified to the contrary, the values given have been established on standardized test specimens at room temperature. The figures should be regarded as guide values only and not as binding minimum values. Kindly note that, under certain conditions, the properties can be affected to a considerable extent by the design of the mould/ die, the processing conditions and the colouring.