



## PROCESSING GUIDE

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Revision : 001  
Rev. Date : May 2014

### 4DUR® Polybutylene Terephthalate (PBT Blends)

#### 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>	0.02	0.02	0.02	0.02
<b>Feed Throat Temperature (°C)</b>	50 - 70	50 - 70	50 - 70	50 - 70
<b>Processing Temperature (°C)</b>	230 - 270	230 - 270	240 - 280	230 - 260
<b>Mould Temperature (°C)</b>	50 - 110	50 - 110	50 - 110	50 - 110
<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

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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.