



4DUR[®] is the registered trade name for Polybutylene Terephthalate (PBT) compounds produced by 4PLAS.

PROCESSING

For PBT compounds, moisture content should be less than 0.04% before processing. When there is a blend with PET or PC moisture content should not exceed 0.02%. Moisture causes immediate hydrolytic degradation during processing which causes molecular weight reduction and thus a reduction in process stability & product performance. Therefore **4DUR[®]** grades should be dried at 120°C for 2 to 4 hours.

4DUR[®] compounds can be processed on all commercial injection moulding machinery. Guide recommendations for processing parameters are detailed below:

Detailed processing conditions specific for each type of product are available upon request.

RECYCLING

Regrind levels up to 25% can be used depending on the application and requirements. However, for flame retardant grades a maximum 10% addition rate is recommended. Regrind should be clean and free of contamination, should not be thermally degraded and must be dried prior to reuse.

SAFETY

Under normal conditions **4DUR[®]** is not a toxic or hazardous material. During processing preventative action should be taken to avoid direct contact with the polymer melt or inhalation of any gases produced. Processing temperatures above 300°C should be avoided. Detailed safety information can be found in our material safety data sheets (MSDS).

	Processing Temperature (°C)	Mould Temperature (°C)	Hold Pressure (MPa)	Back Pressure
4DUR[®] K (PBT)	240 - 270	60 - 100	40 - 80	Low
4DUR[®] KL (PBT/PET)	250 - 280	80 - 110	40 - 80	Low
4DUR[®] KF (PBT/PC)	240 - 270	60 - 100	40 - 80	Low