

# Ultradur® B 6550 L

## PBT (Polybutylene Terephthalate)



### Product Description

Ultradur B 6550 L is a high viscosity PBT extrusion grade.

### Applications

Typical applications include semi-finished products, profile and hollow rods.

PHYSICAL	ASTM Test Method	Property Value
Specific Gravity	D-792	1.3
Mold Shrinkage (1/8" bar, in/in)		0.015
Moisture, %	D-570	
(50% RH)		0.25
(Saturation)		0.5
MECHANICAL	ASTM Test Method	Property Value
Tensile Strength, Yield, MPa (psi)	D-638	
23C (73F)		50 (7,250)
Elongation, Yield, %	D-638	
23C (73F)		3.5
IMPACT	ASTM Test Method	Property Value
Notched Izod Impact, J/M (ft-lbs/in)	D-256	
23C (73F)		53 (1.0)
THERMAL	ASTM Test Method	Property Value
Melting Point, C(F)	D-3418	223 (433)
Heat Deflection @ 264 psi (1.8 MPa) C(F)	D-648	52 (125)
Heat Deflection @ 66 psi (.45 MPa) C(F)	D-648	132 (269)
ELECTRICAL	ASTM Test Method	Property Value
Volume Resistivity, 1.5 mm	D-257	>1E13
Surface Resistivity, 1.5 mm	D-257	>1E15

### 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 230-290 degC (446-554 degF)

Temperature Settings (degC):

Extruder 250/240/230 degC (482/464/446 degF)



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Adaptor 225 deg C (437 deg F)  
Die 215 deg C (419 deg F)

## Screw Parameters

Metering Section	45%
Transition Section	3 to 4 flights
Feed Section	balance of screw length
Compression Ratio	3:1
L/D Ratio	20:1

## Tooling & Sizing

Die to Finished Tube dia. 2.0-2.5:1 Die Gap 3-4 times the desired wall thickness

The vacuum water calibration method is recommended when producing tube diameters 8 mm and below. Water temperature should be 20 deg C (68 deg F).

## Note

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