

Ultradur® B 4406
PBT FR(17)

BASF

Injection molding grade with migration-free flame retardant; for parts requiring enhanced fire resistance (eg plug-and-socket connectors, housings).

Abbreviated designation according to ISO 1043: PBT FR(17)

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	30	cm³/10min	ISO 1133
Temperature	275	°C	-
Load	2.16	kg	-
Molding shrinkage, parallel	1.8	%	ISO 294-4, 2577
Molding shrinkage, normal	1.9	%	ISO 294-4, 2577

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	3000	MPa	ISO 527
Yield stress	65	MPa	ISO 527
Yield strain	3.9	%	ISO 527
Nominal strain at break	5.3	%	ISO 527
Tensile Creep Modulus, 1h	1800	MPa	ISO 899-1
Impact Strength (Charpy), +23°C	50	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	3.5	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	3.5	kJ/m²	ISO 179/1eA

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)	60	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	170	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	170	°C	ISO 306
Coeff. of Linear Therm. Expansion, parallel	95	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	103	E-6/K	ISO 11359-1/-2
Burning Behav. at 1.5 mm Nom. Thickn.	V-0	class	UL 94
Thickness tested	1.6	mm	-
UL recognition	yes	-	-
Burning Behav. at thickness h	V-0	class	UL 94
Thickness tested	0.4	mm	-
UL recognition	yes	-	-
Oxygen index	29	%	ISO 4589-1/-2

Electrical Properties	Value	Unit	Test Standard
ISO Data			
Relative permittivity, 100Hz	3.3	-	IEC 62631-2-1
Relative permittivity, 1MHz	3.3	-	IEC 62631-2-1
Dissipation Factor, 100Hz	110	E-4	IEC 62631-2-1
Dissipation Factor, 1MHz	170	E-4	IEC 62631-2-1
Volume Resistivity	1E13	Ohm*m	IEC 62631-3-1
Surface Resistivity	1E14	Ohm	IEC 62631-3-2
Electric Strength	40	kV/mm	IEC 60243-1
Comparative tracking index	250	-	IEC 60112

Other Properties	Value	Unit	Test Standard
ISO Data			
Water Absorption	0.4	%	Sim. to ISO 62
Humidity absorption	0.25	%	Sim. to ISO 62
Density	1450	kg/m³	ISO 1183

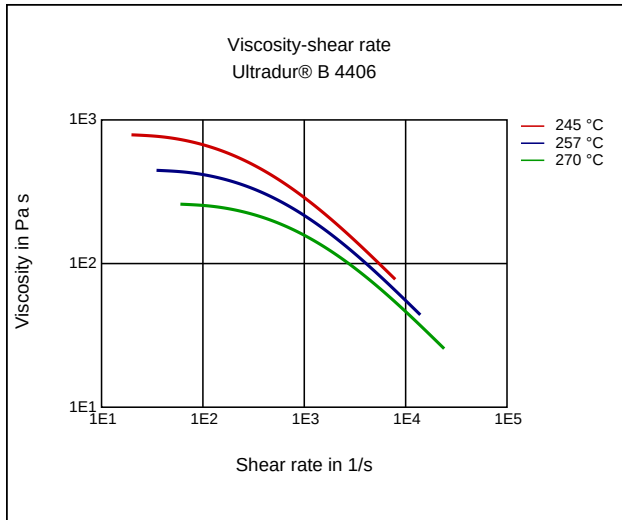
Material Specific Properties	Value	Unit	Test Standard
ISO Data			
Viscosity number	123	cm³/g	ISO 307, 1157, 1628

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	250	°C	ISO 294
Injection Molding, mold temperature	60	°C	ISO 294
Injection Molding, injection velocity	200	mm/s	ISO 294

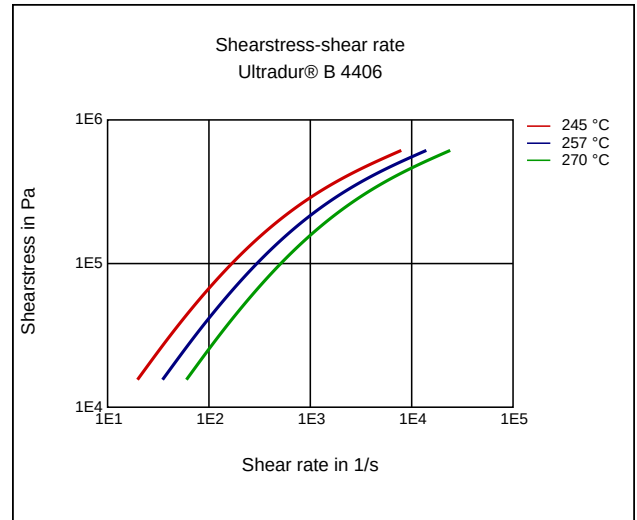
Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80 - 120	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.04	%	-
Melt temperature	245 - 270	°C	-
Mold temperature	40 - 70	°C	-

Diagrams

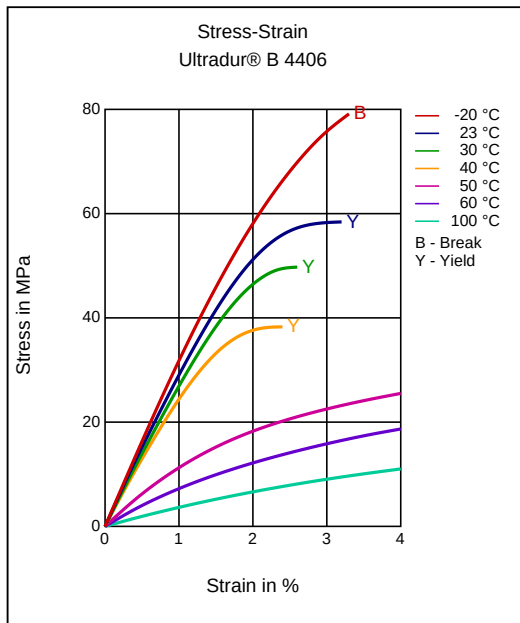
Viscosity-shear rate



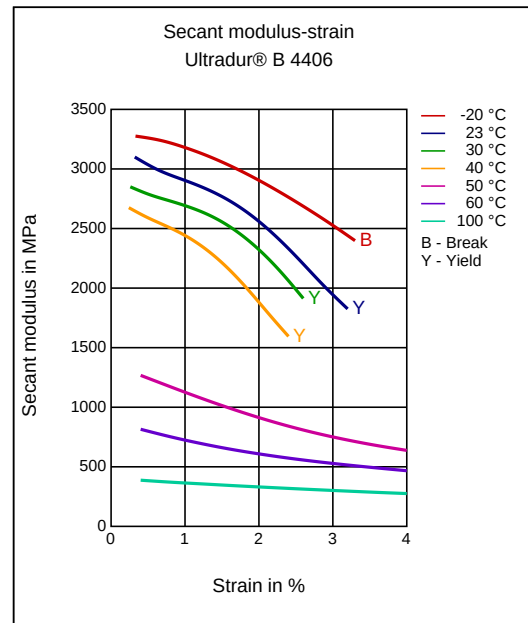
Shearstress-shear rate



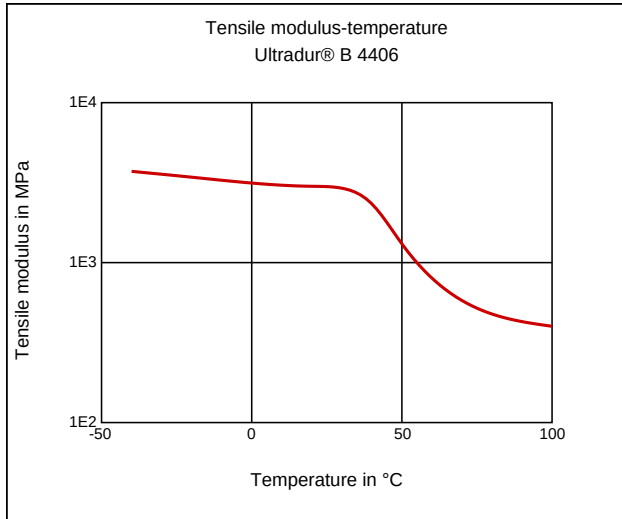
Stress-strain



Secant modulus-strain



Tensile Modulus-Temperature



Characteristics

Processing

Injection Molding

Delivery form

Pellets

Additives

Lubricants

Special Characteristics

Flame retardant, Light stabilized or stable to light, UV stabilized, Heat aging stabilized

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: 245 - 270 °C
injection molding, Melt temperature, recommended: 250 °C
injection molding, Mold temperature, range: 40 - 70 °C
injection molding, Mold temperature, recommended: 60 °C

Disclaimer

Liability Exclusion

These guide values are measured and provided by the product manufacturer and have been determined on standardised test specimens and can be affected by pigmentation, mould design and processing conditions. M-Base has taken the guide values from the producer's original Technical Data Sheet. **ALBIS AND M-BASE ARE THEREFORE NOT RESPONSIBLE FOR THE ACCURACY OF THE GUIDE VALUES AND CANNOT GIVE ANY WARRANTY WITH REGARD TO THEIR CORRECTNESS.**

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