

# Ultradur® B 2300 G6 HR LS BK15045 PBT (Polybutylene Terephthalate)



## Product Description

Ultradur B 2300 G6 HR LS BK15045 is a hydrolysis resistant, laser sensitive, pigmented black 30% fiberglass reinforced PBT, exhibiting superior flow characteristics.

| PHYSICAL   | ISO Test Method | Property Value |
|--|-----------------|----------------|
| Density, g/cm <sup>3</sup>                           | 1183            | 1.53           |
| Viscosity Number, cm <sup>3</sup> /g                 | 1628            | 91             |
| MECHANICAL   | ISO Test Method | Property Value |
| Tensile Modulus, MPa                                 | 527             |                |
| 23C  |                 | 8,400          |
| Tensile stress at break, MPa                         | 527             |                |
| 23C  |                 | 111            |
| Tensile strain at break, %                           | 527             |                |
| 23C  |                 | 2.0            |
| Flexural Modulus, MPa                                | 178             |                |
| 23C  |                 | 7,900          |
| THERMAL  | ISO Test Method | Property Value |
| Melting Point, C                                     | 3146            | 223            |
| HDT A, C   | 75              | 207            |
| Coef. of Linear Thermal Expansion, Parallel, mm/mm C |                 | 0.17 X10-4     |
| Coef. of Linear Thermal Expansion, Normal, mm/mm C   |                 | 1.2 X10-4      |

## 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 100-120C (212-248F) at 4 hours drying time is recommended. Further information concerning safe handling procedures can be obtained from the Safety Data Sheet. Alternatively, please contact your BASF representative.

### Typical Profile

Melt Temperature 250-275C (482-527F)

Mold Temperature 40-70C (105-158F)

Injection and Packing Pressure 35-125 bar (500-1500 psi)

### Mold Temperatures

This product can be processed over mold temperatures of 60-100C (140-212F).

### Pressures

Injection pressure controls the filling of the part and should be applied for 90% of ram travel. Packing pressure affects the final part and can be used effectively in controlling sink marks and shrinkage. It should be applied and maintained until the gate area is completely frozen off.

Back pressure can be utilized to provide uniform melt consistency and reduce trapped air and gas. A maximum of 10 bar (145 psi) is recommended due to the risk of excessive shear.

#### **Fill Rate**

Fast fill rates are recommended to ensure uniform melt delivery to the cavity and prevent premature freezing. Surface appearance is directly affected by injection rate.

#### **Note**

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