

Heppla® H4025GF

Material Description:

Heppla® H4025GF is a Polybutylene Terephthalate (PBT) product filled with 25% glass fiber. Characteristics include: Flame Retardant, Halogenated, High Flow.

General

Material Status	• Commercial: Active
Availability	• Asia Pacific
	• Europe
	• Middle East
Filler/Reinforcement	• Glass Fiber, 25% Filler by Weight
	• Filled
Features	• Flame Retardant
	• High Flow
Processing Method	• Injection Molding

Physical Properties	Typical Value	Unit	Test Method
Density	1.6	g/cm ³	ISO 1183/A
Melt Volume -Flow Rate (MVR) (250°C/2.16 kg)	10	cm ³ /10min	ISO 1133

Mechanical Properties	Typical Value	Unit	Test Method
Tensile Modulus	9500	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	120	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	2.6	%	ISO 527-2/1A/5
Flexural Modulus ¹	8000	MPa	ISO 178
Flexural Stress ¹	185	MPa	ISO 178

Impact Properties	Typical Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
	-30°C	6	
	23°C	6	kJ/m ²
Charpy Unnotched Impact Strength			ISO 179/1eU
	-30°C	40	
	23°C	50	kJ/m ²

Flammability	Typical Value	Unit	Test Method	
Flammability Classification			IEC 60695-11-10, -20	
	0.8 mm	V-0		
	1.6 mm	V-0		
	3.2 mm	V-0		
Glow Wire Flammability Index			IEC 60695-2-12	
	0.75 mm	960		°C
	1.5 mm	960		°C
	3.0 mm	960	°C	
Glow Wire Ignition Temperature			IEC 60695-2-13	
	0.75 mm	650		°C
	1.5 mm	650		°C
	3.0 mm	650	°C	

Electrical Properties	Typical Value	Unit	Test Method
Comparative Tracking Index	200	V	IEC 60112

Thermal Properties	Typical Value	Unit	Test Method
Heat Deflection Temperature			ASTM D648

0.45 MPa,Unannealed	219 °C	ISO 75-2/Bf
1.8 MPa,Unannealed	193 °C	ISO 75-2/Af
Vicat Softening Temperature		
--	215 °C	ISO 306/A50
--	201 °C	ISO 306/B50
Ball Pressure Test (125 °C)	Pass	IEC 60695-10-2

Processing Information	Typical Value	Unit
Drying Temperature	120	°C
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.02	%
Suggested Max Re grind	25	%
Processing (Melt) Temp	250 to 260	°C
Mold Temperature	70 to 90	°C
Injection Rate	Slow-Moderate	
Back Pressure	2.00 to 8.00	MPa
Screw Speed	< 15	m/min

Injection Notes

Mould surfaces in contact with melt should be of non-corrosive steel, chrome content >12%

Notes

¹ 2.0 mm/min

NFD ADVANCED COMPOSITES

Hepla® H4025GF

CAUTION/警告!

Before using, read the Molding Guide, Material Safety Data Sheets, and Bulletins available from NFD Advanced Composites Sales offices and Distributors supplied to your company. Caution! During drying, purging and molding, small amounts of hazardous gases and/or particulate matter may be released. These may irritate eyes, nose and throat. Use adequate local exhaust ventilation during thermal processing. To prevent resin decomposition, do not contaminate the resin or exceed the recommended melt temperature or hold-up time. Avoid inhalation or skin and eyes contact. Sweep up and dispose of spilled resin to eliminate slipping hazard. 在使用之前，请阅读NFD公司销售办事处和经销商提供给贵公司的材料成型指南、材料安全数据表和公告。警告！在干燥、吹扫和成型过程中，少量有害气体或颗粒物可能会在被释放，这些可能会刺激眼睛，鼻子和喉咙。热处理过程中请注意做好排气通风工作。为防止树脂分解，请勿污染树脂或超过我们为您推荐的热融温度或时间。请避免吸入或与皮肤、眼睛等接触。清扫和处理溢出的树脂，以消除滑倒的危险。

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