**Processing Data Sheet** **Ultradur®**

S 4090 G6

09/2026

**PBT+ASA+PET GF30**

We create chemistry

## Product Information

Low-warpage injection molding grade with 30 % glass fibres for technical parts, for which dimensional stability is very important (e.g.housings, plug-and-socket connectors).
The products can also be offered as BMBcert™ and/or Ccycled™. Due to the Massbalance approach the product properties do not change.

Abbreviated designation according to ISO 1043: PBT+ASA+PET GF30

## Product safety

Ultradur® melts are stable at temperatures up to 280°C and do not give rise to hazards due to molecular degradation or the evolution of gases and vapors. Like all thermoplastic polymers, however, Ultradur decomposes on exposure to excessive thermal stresses, e.g. when it is overheated or as a result of cleaning by burning off. At temperatures of > 290 °C can be emitted: carbon monoxide, tetrahydrofuran.
Under special fire conditions traces of other toxic substances are possible. Formation of further decomposition and oxidation products depends upon the fire conditions.
When Ultradur® is properly processed and there is adequate suction at the die no risks to health are to be expected.
Additional safety information can be found in the safety data sheets of the individual products.
Safety data sheets can be requested from the Ultraplaste Infopoint at ultraplaste.infopoint@basf.com.

## Physical form and storage

Standard packaging includes the 25-kg-bag, the 1000 kg octabin (octagonal container) or the 1000 kg big bag. Other forms of packaging are possible subject to agreement. All containers are tightly sealed and should be opened only immediately prior to processing. Further precautions for preliminary treatment and drying are described in the processing section of the brochure. The bulk density is about 0,7 to 0,8g/cm³.
Ultradur® can be stored for a longer period of time in dry, well vented rooms without causing problems in processing.
Ultradur® should generally have a moisture content of less than 0,04% when being processed.
In order to ensure reliable production, therefore, pre-drying should generally be the rule and the machine should be loaded via a closed conveyor system. Appropriate equipment is commercially available. Pre-drying is also for the addition of batches, e.g. in the case of inhouse pigmentation.
In order to prevent the formation of condensed water, containers stored in unheated rooms must only be opened when they have attained the temperature prevailing in the processing area. This can possibly take a very long time.
Measurements have shown that the interior of a 25-kg bag originally at 5°C had reached the temperature of 20°C in the processing area only after 48 hours.

## Note

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our product, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the product for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein may change without prior information and do not constitute the agreed contractual quality of the product. It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed.
In order to check the availability of products please contact us or our sales agency.

BASF SE
67056 Ludwigshafen, Germany

# Ultradur® S 4090 G6

## Processing Data Sheet

We create chemistry

| | Test method | Unit | Values |
|---|---|---|---|
| **Properties** | | | |
| Polymer abbreviation | - | - | **PBT+ASA+PET GF30** |
| Density | ISO 1183 | kg/m³ | **1470** |
| Melt volume rate MVR 275 °C/2.16 kg | ISO 1133 | cm³/10min | **20** |
| **Drying** | | | |
| Moisture, max. | - | % | **0.04** |
| Dryer temperature [1)] | - | °C | **80 - 120** |
| Drying time | - | h | **4** |
| **Injection molding** | | | |
| Melt temperature range | - | °C | **250 - 275** |
| Melt temperature, optimal | - | °C | **270** |
| Mold temperature range | - | °C | **60 - 100** |
| Mold temperature, optimal | - | °C | **80** |
| **Machine Settings** | | | |
| Temperature hopper throat | - | °C | **80** |
| Cylinder temperature 1 (feed zone) | - | °C | **260** |
| Cylinder temperature 2 (compression) | - | °C | **265** |
| Cylinder temperature 3 (metering-zone, in front of the screw) | - | °C | **270** |
| Cylinder temperature 4 (nozzle) | - | °C | **270** |
| Peripheral screw speed | - | m/s | **≤ 0.25** |
| **Shrinkage** | | | |
| Molding shrinkage (parallel) | ISO 294-4 | % | **0.29** |
| Molding shrinkage (normal) | ISO 294-4 | % | **0.75** |
| Molding shrinkage, free, longitudinal, plate, with film gate [2)] | - | % | **0.1** |
| Molding shrinkage, free, transversal, plate with film gate [2)] | - | % | **0.75** |

Footnotes
1) Dry air dryer or vacuum dryer
2) Plate 150 x 150 x 3 mm, film gated

BASF SE

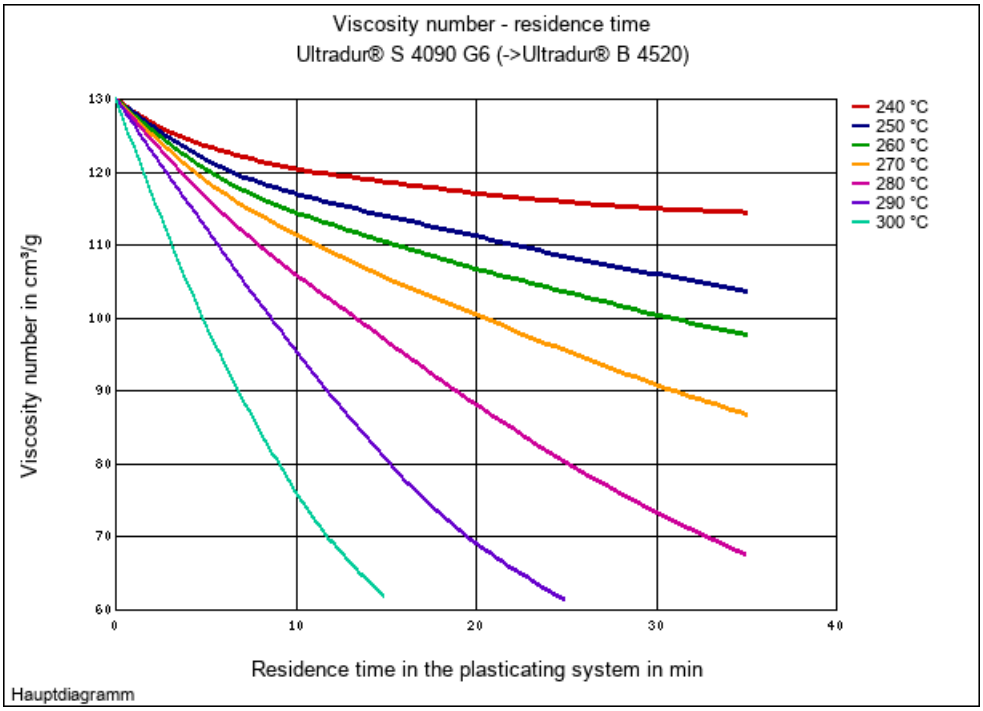
67056 Ludwigshafen, Germany

# Ultradur® S 4090 G6

## Processing Data Sheet

We create chemistry

### VISCOSITY NUMBER - RESIDENCE TIME




Unnecessarily high melt temperatures and excessively long residence times of the melt in the cylinder and the hot runner can bring about molecular degradation.
The figure shows an example (Ultradur® B4520) illustrating how the viscosity number acts as a measure of the molecular weight as a function of the melt temperature and residence time. Based on experience material degradation of less than 10 % based on the measured viscosity in solution of the granules and the molding is tolerable. In the event of values higher than this the processing and drying parameters should be checked.

BASF SE
67056 Ludwigshafen, Germany