

Polybutylene Terephthalate (PBT)

**DURANEX®**

353RA

EF2001/ED3002

Resin Adhesion  
Improved For Multiple  
Injection Molding

**POLYPLASTICS CO., LTD.**

# Introduction

## What can be done with the RA series

Multi-component molding is an injection molding process in which the surface of the first (primary) molded component is melted using the melt heat of the second (secondary) material, thereby creating an adherence or bonding between the first component and the second component.

However, when undertaking multicomponent molding, many cases are seen in which there are problems with the adhesion strength between the first and second components.

In order to achieve this adhesion strength, better results are achievable when the respective materials are as close as possible in terms of properties to each other. Moreover, if the same materials are used, the coefficient of thermal expansion can be the same, so there are benefits to be derived in environmental durability.

For this reason, when the first material or the second material is PBT that has been selected for its electrical properties, stiffness, and durability, it is preferable that the other material is also PBT. However, when multi-component molding is carried out using standard grades of PBT, sufficient adhesion or bonding strength could not be realized.

To this end, we have developed the **Duranex RA series**, which is comprised of adhesion-enhanced grades for multi-component molding. This series utilizes "Lowered Melting Point PBT" base resins, a proprietary technology of our company, and enables resin adhesion to air tightness to be enhanced.

## Why is multi-component molding necessary?

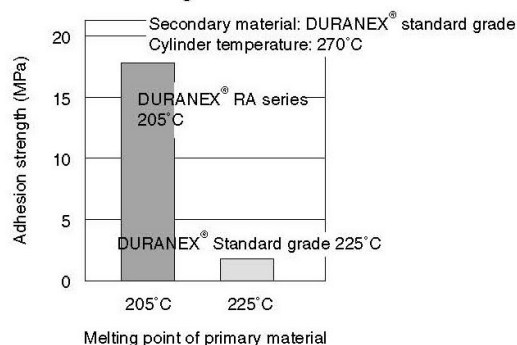
"A coil wrapped with conducting wire is protected by encapsulation with PBT."

"A connector incorporating pins is insert molded to double as part of a PBT housing."

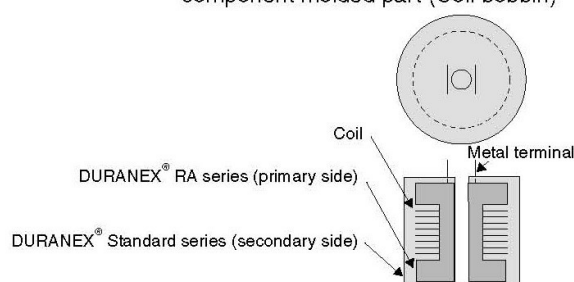
"The part is too complex for single-shot injection, so molding is carried out in two steps. In other words, a portion of the part is molded first, and then this portion is inserted into a mold where the second portion is molded."

Through carrying out such multi-component molding processes, certain types of assembled parts can be encapsulated, products can be insert-molded for protection, and other functionalities can be given.

Adhesion strength of DURANEX® RA series



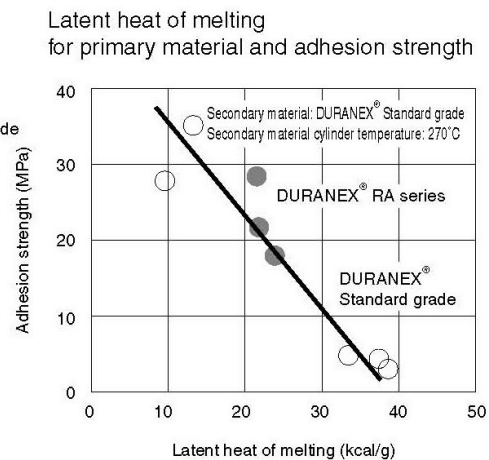
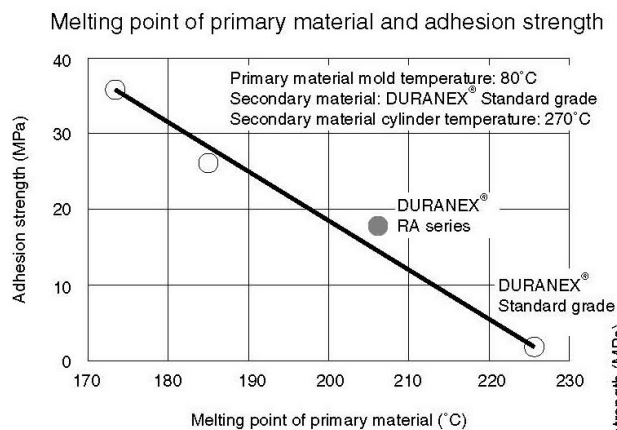
Example of multi-component molded part (Coil bobbin)



## Why do RA series grades adhere?

Duranex RA series resins use "Lowered Melting Point PBT," which is based on our proprietary technology, as a base resin.

Therefore, by using this **RA series** as the material for the first shot, and a standard grade of the material used in the second shot, the large melting point difference between the two grades can be exploited to melt the surface of the primary part molded from **RA series** grade, and thereby achieve strong adhesion and air tightness. In addition, as the melting point of the base resin is lowered, the amount of thermal energy needed to melt the **RA series** (latent heat of melting) is lower than that for standard grades, and therefore, the **RA series** is easier to melt.



# 1. Adhesion properties of DURANEX® RA series

Figure 1-1 Secondary material cylinder temperature and adhesion

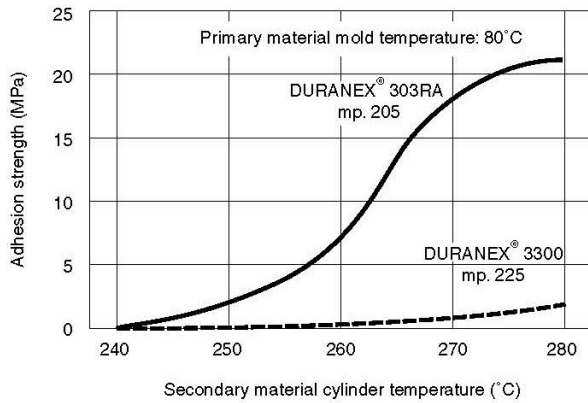


Figure 1-2 Primary material mold temperature and adhesion

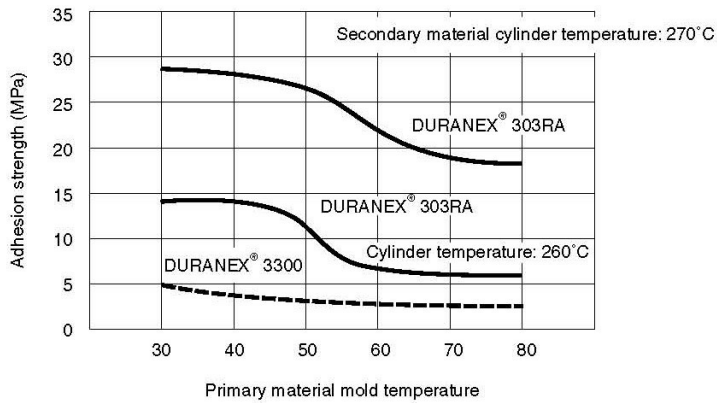
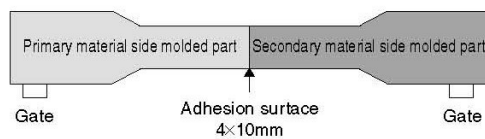


Figure 1-3 Test piece for evaluation of adhesion strength



## Processing parameters for primary material

Cylinder temperature: 240°C  
 Mold temperature: 30, 45, 60, 80°C  
 Injection speed: 17 mm/sec  
 Injection pressure: 49 MPa  
 Cycle: 20 s hold phase/10 s cooling

## Molding of test piece for evaluation of adhesion strength

Firstly, half of the dumbbell test piece is molded from the primary material. This half is then inserted into a mold, and the second half is molded as to bond to the primary part.

## Processing parameters for secondary material

Cylinder temperature: 240, 250, 260, 270, 280°C  
 Mold temperature: 65°C  
 Injection speed: 17 mm/sec  
 Injection pressure: 49 MPa  
 Cycle: 20 s hold phase/10 s cooling

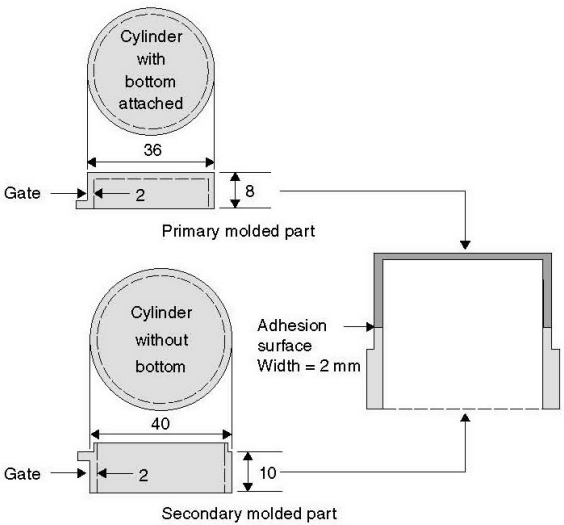
## 2. Air tightness of DURANEX® RA series

Table 2-1 Processing parameters and air tightness

Air pressure: 0.68 MPa

Primary material		DURANEX® 303RA		DURANEX® 3300	
Primary mold T		30°C	70°C	30°C	70°C
Secondary cylinder T	250°C	○	○	○	×
	260°C	○	○	○	○
	270°C	○	○	○	○

Figure 2-1 Test piece for evaluation of air tightness



### Molding of test piece

As shown in Figure 2-1, a cylinder with lid attached is first molded as the primary part. This part is then inserted into the cavity of a mold, and the secondary part, a cylinder with no bottom, is molded so as to bond to the primary part. Through this process, an adhesion surface of width 2 mm is formed between the primary and secondary parts.

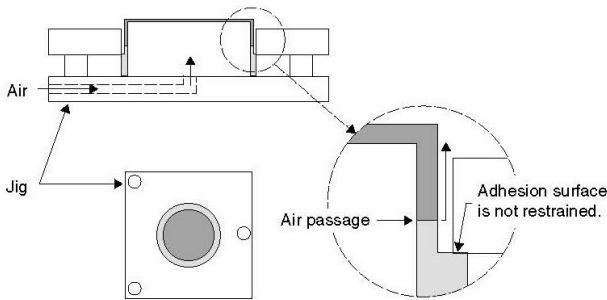
### Processing parameters for primary material

Cylinder temperature: 240°C  
Mold temperature: 30, 70°C  
Injection speed: 17 mm/sec  
Injection pressure: 49 MPa  
Cycle: 20 s hold phase/10 s cooling

### Processing parameters for secondary material

Cylinder temperature: 250, 270°C  
Mold temperature: 65°C  
Injection speed: 17 mm/sec  
Injection pressure: 49 MPa  
Cycle: 20 s hold phase/10 s cooling

Figure 2-2 Evaluation method for air supported.



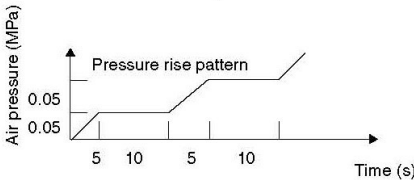
### Evaluation method

The multi-component molded test piece shown in Figure 2-1 is secured in a jig so that the adhesion surface is not supported. This assembly is then immersed in a water tank.

Pressurized air is applied from the bottom, and the air tightness is verified.

### Timing of pressure rises:

An increased of 0.04 MPa in about 5 s, followed by a 10 s holding phase to verify air tightness. Process then repeated over.



# General Properties of 353RA

table1-1 General Properties (ISO)

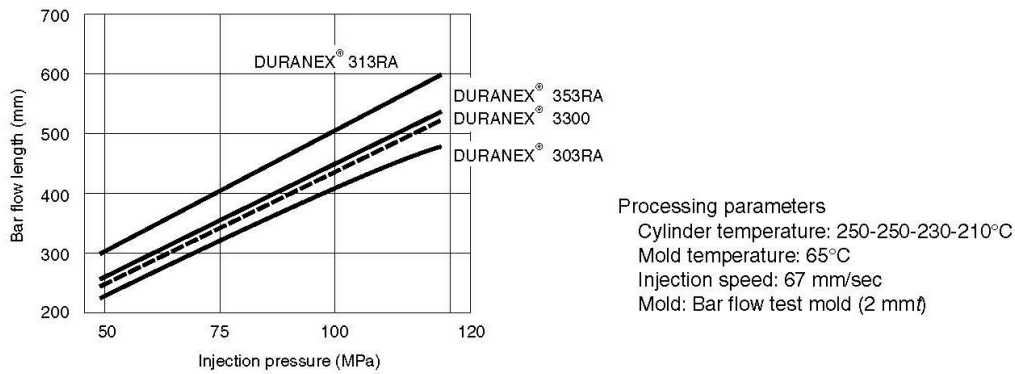
Item	Unit	Test Method	Resin Adhesion Improved For Multiple Injection Molding
			353RA
			GF30% Reinforced, Hydrolysis Resistance
Color			EF2001/ED3002
ISO(JIS)quality-of-the-material display:		ISO11469 (JIS K6999)	>PBT-GF30FR(17)<
Density	g/cm <sup>3</sup>	ISO 1183	1.68
Water absorption (23°C,24hrs,1mmt)	%	ISO 62	0.1
Tensile strength	MPa	ISO 527-1,2	143
Strain at break	%	ISO 527-1,2	2.1
Flexural strength	MPa	ISO 178	221
Flexural modulus	MPa	ISO 178	10,330
Charpy notched impact strength (23°C)	kJ/m <sup>2</sup>	ISO 179/1eA	10.0
Temperature of deflection under load (1.8MPa)	°C	ISO 75-1,2	197
Coefficient of linear thermal expansion (23 - 55°C、Flow direction)	x10 <sup>-5</sup> /°C	Our standard	2
Coefficient of linear thermal expansion (23 - 55°C、Transverse direction)	x10 <sup>-5</sup> /°C	Our standard	7
Electric strength (3mmt)	kV/mm	IEC 60243-1	20
Volume resistivity	Ω・cm	IEC 60093	1 × 10 <sup>16</sup>
Volume resistivity (Our standard)	Ω・cm		-
Tracking resistance (CTI)	V	IEC 60112	-
Rockwell hardness	M(Scale)	ISO2039-2	90
Flammability		UL94	V-0
The yellow card File No.			E213445
Appropriate List number of Ministerial Ordinance for Export Trade Control			Item 16 of Appendix -1

All figures in the table are the typical values of the material and not the minimum values of the material specifications.

## 4. Processing characteristics of DURANEX® RA series

### 4.1 Flow characteristics

Figure 4-1 Bar flow length of DURANEX® RA series HB grades (2 mm $\bar{t}$ )



### 4.2 Mold shrinkage ratio of DURANEX® RA series HB grades (120 $\square$ ×2mm $\bar{t}$ )

Figure 4-2 DURANEX® 303RA

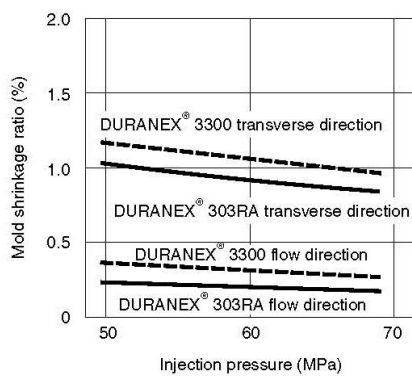
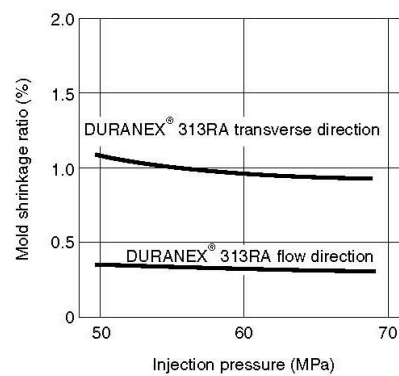
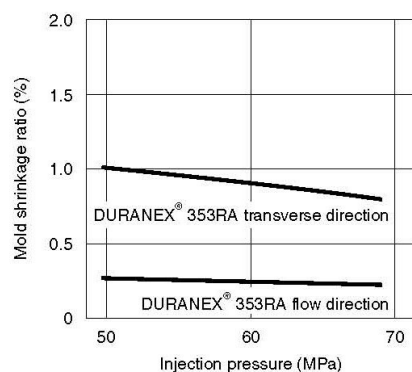


Figure 4-3 DURANEX® 313RA



### 4.3 Mold shrinkage ratio of DURANEX® RA series V-O grade (120 $\square$ ×2mm $\bar{t}$ )

Figure 4-4 DURANEX® 353RA



Processing parameters  
Cylinder temperature: 250-250-230-210°C  
Mold temperature: 65°C  
Injection speed: 17 mm/sec  
Test piece: 120×120×2 mm $\bar{t}$  flat plate  
(4 (W)×2 $\bar{t}$  side gate)

## 5. Heat stability of DURANEX® RA series when molding (limits of cylinder residence time)

Table 5-1 Limits of cylinder residence time

		DURANEX® 303RA	DURANEX® 353RA	DURANEX® 3300
Cylinder T	260°C	○	○	○
	270°C	○	15min	○
	280°C	15min	5min	15min

### 5.1 Cylinder residence time limits as seen from tensile properties

Figure 5-1 DURANEX® 303RA

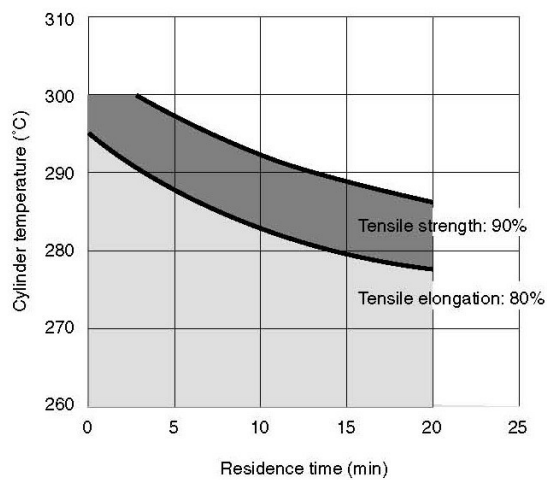


Figure 5-2 DURANEX® 3300

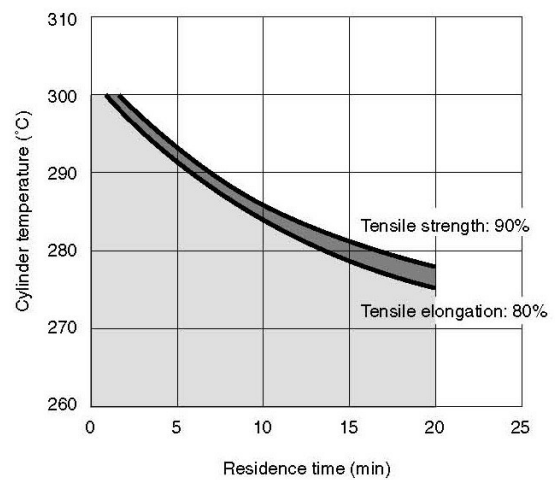
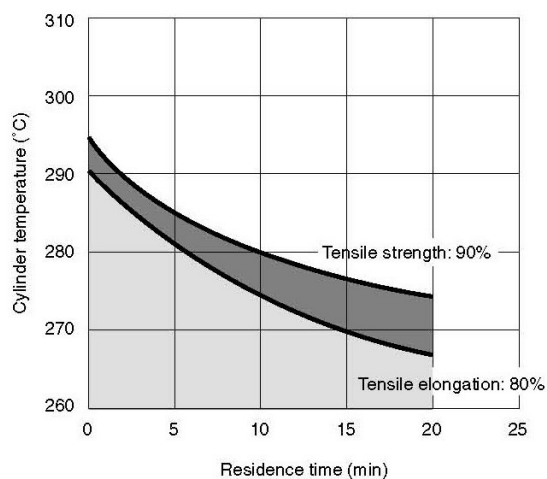


Figure 5-3 DURANEX® 353RA







## NOTES TO USERS

- All property values shown in this brochure are the typical values obtained under conditions prescribed by applicable standards and test methods.
- This brochure has been prepared based on our own experiences and laboratory test data, and therefore all data shown here are not always applicable to parts used under different conditions. We do not guarantee that these data are directly applicable to the application conditions of users and we ask each user to make his own decision on the application.
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