



## CoolPoly® D4302 Thermally Conductive Polybutylene Terephthalate (PBT)

CoolPoly D4302 is a thermally conductive injection molding resin based on a PBT matrix. CoolPoly D4302 is electrically insulative. Thermally conductive polymers like CoolPoly D4302 cool faster than standard injection molding grade resins.

### Typical Injection Molding Conditions

Temperature Settings	SI /Metric	English
Rear Zone	200 - 210 °C	390 - 410 °F
Center Zone	204 - 227 °C	400 - 440 °F
Front Zone	216 - 238 °C	420 - 460 °F
Melt	216 - 238 °C	420 - 460 °F
Mold	27 - 66 °C	80 - 150 °F

### Pressure Settings

Injection	35 - 82 MPa	5000 - 12000 psi
Hold	14 - 28 MPa	2000 - 4000 psi
Back	0 - 0.35 MPa	0 - 50 psi

### Injection Settings

Fill	moderate - fast	moderate - fast
Screw	40 - 100 rpm	40 - 100 rpm

### Drying Conditions

Dew Point	-18 °C	0 °F
Time & Temperature	4hr@ 82 °C	4hr@ 180 °F

### Additional Information

A low compression screw (less than 2.5:1) is recommended

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