

4DUR® 9K24300 FR1

Polybutylene Terephthalate
4Plas

Message:

4DUR 9K24300 FR1 is a Standard Flow High Impact FR-V0 PBT

General Information			
Features	Impact resistance, high		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.42	g/cm ³	ISO 1183
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	3000	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	55.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	30	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ISO 180/1A
-30°C	4.0	kJ/m ²	ISO 180/1A
23°C	10	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength (23°C)	No Break		ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (0.45 MPa, Unannealed)	165	°C	ISO 75-2/B
Vicat Softening Temperature	175	°C	ISO 306/B
Melting Temperature ²	225	°C	ISO 11357
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index	225	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	V-0		UL 94
Glow Wire Flammability Index (2.00 mm)	960	°C	IEC 60695-2-12
Injection	Nominal Value	Unit	
Drying Temperature	120	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.040	%	
Processing (Melt) Temp	240 - 260	°C	
Mold Temperature	60.0 - 100	°C	
Injection Rate	Moderate-Fast		
Holding Pressure	40.0 - 80.0	MPa	
Screw Speed	300	rpm	

Injection instructions

Feed Throat Temperature: 50 - 70 °C Back Pressure: Low

NOTE

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| 1. | 24 Hrs |
| 2. | 10 K/min |

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