

Thermec™ 4301R33H

Polyphthalamide
Technical Polymers, LLC

Message:

Thermec™4301R33H is a polyxylyene amide (PPA) material, which contains a 33% glass fiber reinforced material. This product is available in North America and is processed by injection molding.

Thermec™The main features of 4301R33H are:

flame retardant/rated flame

heat stabilizer

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 33% filler by weight		
Additive	heat stabilizer		
Features	Thermal Stability		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.46	g/cm³	ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (23°C)	207	MPa	ASTM D638
Tensile Elongation (Break, 23°C)	2.5	%	ASTM D638
Flexural Modulus (23°C)	10300	MPa	ASTM D790
Flexural Strength (23°C)	290	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	96	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	271	°C	ASTM D648
Melting Temperature	285	°C	DSC
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms · cm	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		UL 94
Additional Information			
Tensile Elongation, ASTM D638: 2 to 3%Volum Resistivity, ASTM D257: >1e15 ohm-cm			
Injection	Nominal Value	Unit	
Drying Temperature	98.9 - 107	°C	
Drying Time	4.0 - 6.0	hr	
Processing (Melt) Temp	321 - 332	°C	
Mold Temperature	135 - 163	°C	
Injection Rate	Moderate-Fast		
Back Pressure	0.103 - 0.689	MPa	

Screw Speed	50 - 100	rpm
Clamp Tonnage	4.1 - 6.9	kN/cm ²
Cushion	3.18 - 12.7	mm
Screw L/D Ratio	20.0:1.0	
Screw Compression Ratio	2.0:1.0 to 2.5:1.0	

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