

4MID® 9B22130 I3

Polyamide 6

4Plas

Message:

4MID 9B22130 I3 is a Standard Flow 30% Glass Fibre Reinforced High Impact Modified PA6

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Additive	Impact modifier		
Features	Impact modification		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.30	g/cm ³	ISO 1183
Molding Shrinkage			
Vertical flow direction	1.1	%	
Flow direction	0.30	%	
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	1.8	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	8000	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	135	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	4.5	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ISO 180/1A
-30°C	18	kJ/m ²	ISO 180/1A
23°C	28	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	210	°C	ISO 75-2/B
1.8 MPa, not annealed	195	°C	ISO 75-2/A
Vicat Softening Temperature	205	°C	ISO 306/B
Melting Temperature ²	223	°C	ISO 11357
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+13	ohms	IEC 60093
Volume Resistivity	1.0E+15	ohms · cm	IEC 60093
Comparative Tracking Index	500	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.60 mm	HB		UL 94
3.20 mm	HB		UL 94

Glow Wire Flammability Index (2.00 mm)	650	°C	IEC 60695-2-12
Glow Wire Ignition Temperature (2.00 mm)	550	°C	IEC 60695-2-13
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0	hr	
Suggested Max Moisture	0.20	%	
Processing (Melt) Temp	230 - 270	°C	
Mold Temperature	60.0 - 100	°C	
Injection Rate	Moderate-Fast		
Holding Pressure	50.0 - 100	MPa	
Screw Speed	400	rpm	
Injection instructions			
Feed Throat Temperature: 60 - 80 °C Back Pressure: Low			
NOTE			
1.	24 Hrs		
2.	10 K/min		

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