

4MID® 9B22120 H

Polyamide 6
4Plas

Message:

4MID 9B22120 H is a Standard Flow 20% Glass Fibre Reinforced Heat Stabilised PA6

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Additive	heat stabilizer		
Features	Thermal Stability		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.25	g/cm ³	ISO 1183
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	2.3	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	6000	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	120	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	2.5	%	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	5.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (0.45 MPa, Unannealed)	210	°C	ISO 75-2/B
Vicat Softening Temperature	210	°C	ISO 306/B
Melting Temperature ²	223	°C	ISO 11357
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index	500	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		UL 94
Glow Wire Flammability Index (2.00 mm)	650	°C	IEC 60695-2-12
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0	hr	
Suggested Max Moisture	0.20	%	
Processing (Melt) Temp	250 - 270	°C	
Mold Temperature	60.0 - 100	°C	
Injection Rate	Fast		
Holding Pressure	50.0 - 100	MPa	

Screw Speed	200	rpm
Injection instructions		
Feed Throat Temperature: 60 - 80 °CBack Pressure: Low		
NOTE		
1.	24 Hrs	
2.	10 K/min	

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