

4TECH® 9A22740 HFR5

Polyamide 66
4Plas

Message:

4TECH 9A22740 HFR5 is a Standard Flow 40% Carbon Fibre Reinforced FR-V0 Halogen Free, Heat Stabilised PA66

General Information			
Filler / Reinforcement	Carbon fiber reinforced material, 40% filler by weight		
Additive	heat stabilizer		
Features	Thermal Stability		
	Halogen-free		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.52	g/cm ³	ISO 1183
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	2.2	%	ISO 62
Moisture Content	< 2000	ppm	ISO 960
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	40000	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	220	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	1.0	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ISO 180/1A
-30°C	11	kJ/m ²	ISO 180/1A
23°C	12	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	255	°C	ISO 75-2/B
1.8 MPa, not annealed	245	°C	ISO 75-2/A
Melting Temperature ²	262	°C	ISO 11357
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	< 10	ohms	IEC 60093
Volume Resistivity	< 10	ohms · cm	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	V-0		UL 94
Glow Wire Flammability Index (1.00 mm)	960	°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	270 - 300	°C
Mold Temperature	70.0 - 110	°C
Injection Rate	Fast	
Holding Pressure	50.0 - 100	MPa
Screw Speed	200	rpm

Injection instructions

Feed Throat Temperature: 60 - 80 °C Back Pressure: Low

NOTE

1. 24 Hrs
2. 10 K/min

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