

4TECH® 9B20000 CO

Polyamide 6
4Plas

Message:

4TECH 9B20000 CO is a Standard Flow Unfilled Conductive PA6

General Information			
Features	Conductivity		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.18	g/cm ³	ISO 1183
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	2.4	%	ISO 62
Moisture Content	< 2000	ppm	ISO 960
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2500	MPa	ISO 527-2/5
Tensile Stress (Yield, 23°C)	70.0	MPa	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ISO 180/1A
-30°C	6.0	kJ/m ²	ISO 180/1A
23°C	7.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	55.0	°C	ISO 75-2/A
Melting Temperature ²	223	°C	ISO 11357
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+6	ohms	IEC 60093
Volume Resistivity	1.0E+4	ohms · cm	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.60 mm	HB		UL 94
3.20 mm	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0	hr	
Suggested Max Moisture	0.20	%	
Processing (Melt) Temp	240 - 260	°C	
Mold Temperature	70.0 - 90.0	°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

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

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