

4MID® 9B22140

Polyamide 6

4Plas

Message:

4MID 9B22140 is a Standard Flow 40% Glass Fibre Reinforced PA6

| General Information | | | |
|---|---|-------------------|----------------|
| Filler / Reinforcement | Glass fiber reinforced material, 40% filler by weight | | |
| Processing Method | Injection molding | | |
| Physical | Nominal Value | Unit | Test Method |
| Density | 1.46 | g/cm ³ | ISO 1183 |
| Molding Shrinkage | | | |
| Vertical flow direction | 0.80 | % | |
| Flow direction | 0.20 | % | |
| Water Absorption ¹ (Equilibrium, 23°C, 50% RH) | 1.8 | % | ISO 62 |
| Moisture Content | < 2000 | ppm | ISO 960 |
| Mechanical | Nominal Value | Unit | Test Method |
| Tensile Modulus (23°C) | 12000 | MPa | ISO 527-2/5 |
| Tensile Stress (Break, 23°C) | 130 | MPa | ISO 527-2/5 |
| Tensile Strain (Break, 23°C) | 2.0 | % | ISO 527-2/5 |
| Impact | Nominal Value | Unit | Test Method |
| Notched Izod Impact | | | ISO 180/1A |
| -30°C | 10 | 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, Unannealed) | 210 | °C | ISO 75-2/B |
| Vicat Softening Temperature | 215 | °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 |
| 0.750 mm | HB | | UL 94 |
| 1.60 mm | HB | | UL 94 |
| Glow Wire Ignition Temperature (2.00 mm) | 650 | °C | IEC 60695-2-13 |
| Injection | Nominal Value | Unit | Test Method |
| 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 °C Back Pressure: Low

NOTE


1. 24 Hrs
2. 10 K/min

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