

4TECH® 9A22710 H

Polyamide 66
4Plas

Message:

4TECH 9A22710 H is a Standard Flow 10% Carbon Fibre Reinforced Heat Stabilised PA66

General Information			
Filler / Reinforcement	Carbon fiber reinforced material, 10% filler by weight		
Additive	heat stabilizer		
Features	Thermal Stability		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.18	g/cm ³	ISO 1183
Molding Shrinkage			
Vertical flow direction	1.1	%	
Flow direction	0.30	%	
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	2.5	%	ISO 62
Moisture Content	< 2000	ppm	ISO 960
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	9000	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	150	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 (23°C)	5.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (0.45 MPa, Unannealed)	235	°C	ISO 75-2/B
Melting Temperature ²	262	°C	ISO 11357
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	< 1.0E+5	ohms · cm	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating (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	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 °CBack Pressure: Low		
NOTE		
1.	24 Hrs	
2.	10 K/min	

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