

4MID® 9B22115 XHFR1

Polyamide 6
4Plas

Message:

4MID 9B22115 XHFR1 is a Standard Flow 15% Glass Fibre Reinforced UL listed FR-V0, Heat Stabilised PA6

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 15% filler by weight		
Additive	heat stabilizer		
Features	Thermal Stability		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.53	g/cm ³	ISO 1183
Molding Shrinkage			
Vertical flow direction	0.90	%	
Flow direction	0.30	%	
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	1.7	%	ISO 62
Moisture Content	< 2000	ppm	ISO 960
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	7500	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	100	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	8.0	kJ/m ²	ISO 180/1A
23°C	9.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength			ISO 180/1U
-30°C	60	kJ/m ²	ISO 180/1U
23°C	65	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	215	°C	ISO 75-2/B
1.8 MPa, not annealed	195	°C	ISO 75-2/A
Vicat Softening Temperature	210	°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	600	V	IEC 60112

Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.750 mm	V-0		UL 94
1.60 mm	V-0		UL 94
Glow Wire Flammability Index (2.00 mm)	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature (2.00 mm)	825	°C	IEC 60695-2-13
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 °C Back Pressure: Low			
NOTE			
1.	24 Hrs		
2.	10 K/min		

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection. All rights belong to the original authors. If any infringement occurs, please contact us immediately.

Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

