

Stanyl® ForTii™ K11

Polyamide 4T
DSM Engineering Plastics

Message:
For E&E applications

General Information				
Filler / Reinforcement		Glass Fiber,30% Filler by Weight		
Features		Good Flow		
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.41	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow	1.3	--	%	
Flow	0.40	--	%	
Water Absorption (Equilibrium, 23°C, 50% RH)	2.1	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus				ISO 527-2
--	11000	--	MPa	
120°C	8000	--	MPa	
160°C	5000	--	MPa	
200°C	5000	--	MPa	
Tensile Stress				ISO 527-2
Break	180	--	MPa	
Break, 120°C	130	--	MPa	
Break, 160°C	90.0	--	MPa	
Break, 200°C	75.0	--	MPa	
Tensile Strain				ISO 527-2
Break	2.0	--	%	
Break, 120°C	2.8	--	%	
Break, 160°C	4.6	--	%	
Break, 200°C	5.8	--	%	
Flexural Modulus				ISO 178
--	10000	--	MPa	
160°C	5000	--	MPa	
200°C	4000	--	MPa	
Flexural Stress	290	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	10	--	kJ/m ²	ISO 179/1eA

Charpy Unnotched Impact Strength (23°C)	55	--	kJ/m ²	ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	305	--	°C	ISO 75-2/A
Melting Temperature ¹	325	--	°C	ISO 11357-3
CLTE				ASTM D696
Flow	3.0E-5	--	cm/cm/°C	
Transverse	5.0E-5	--	cm/cm/°C	
Electrical	Dry	Conditioned	Unit	Test Method
Volume Resistivity	> 1.0E+15	> 1.0E+15	ohms·cm	IEC 60093
Electric Strength	33	33	kV/mm	IEC 60243-1
Comparative Tracking Index	600	600	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flammability Classification				IEC 60695-11-10, -20
0.800 mm	HB	--		
1.50 mm	HB	--		
Injection	Dry	Unit		
Drying Temperature	100		°C	
Drying Time	4.0 to 8.0		hr	
Rear Temperature	320 to 330		°C	
Middle Temperature	325 to 335		°C	
Front Temperature	330 to 335		°C	
Nozzle Temperature	330 to 335		°C	
Processing (Melt) Temp	330 to 340		°C	
Mold Temperature	100 to 150		°C	
Injection Rate	Moderate-Fast			
Back Pressure	0.500 to 3.00		MPa	
Screw Compression Ratio	2.5:1.0			
NOTE				
1.	10°C/min			

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