

4MID® 9B21030 FR1

Polyamide 6
4Plas

Message:

4MID 9B21030 FR1 is a Standard Flow 30% Mineral Filled FR-V0 PA6

General Information			
Filler / Reinforcement	Mineral filler, 30% filler by weight		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.55	g/cm ³	ISO 1183
Molding Shrinkage			
Vertical flow direction	0.90	%	
Flow direction	0.90	%	
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	1.2	%	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)	70.0	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	1.0	kJ/m ²	ISO 180/1A
23°C	5.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (0.45 MPa, Unannealed)	175	°C	ISO 75-2/B
Vicat Softening Temperature	190	°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 (1.60 mm)	V-0		UL 94
Glow Wire Flammability Index (2.00 mm)	960	°C	IEC 60695-2-12
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 °CBack Pressure: Low

NOTE

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

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