

4MID® 9B22250 HM-R

Polyamide 6

4Plas

Message:

4MID 9B22250 HM-R is a Standard Flow 50% Glass Bead Filled Heat Stabilised, Mould Release PA6

General Information			
Filler / Reinforcement	Glass beads, 50% filler by weight		
Additive	heat stabilizer demoulding		
Features	Thermal Stability Good demoulding performance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.58	g/cm ³	ISO 1183
Molding Shrinkage			
Vertical flow direction	0.70	%	
Flow direction	0.70	%	
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	1.5	%	ISO 62
Moisture Content	< 2000	ppm	ISO 960
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	7000	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	70.0	MPa	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ISO 180/1A
-30°C	3.0	kJ/m ²	ISO 180/1A
23°C	4.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	90.0	°C	ISO 75-2/A
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 (1.60 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	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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