

4TECH® 9G22130 FRR5H

Polyphthalamide
4Plas

Message:

4TECH 9G22130 FRR5H is a Standard Flow 30% Glass Fibre Reinforced FR-V0 Halogen & Red Phosphorous Free, Heat Stabilised PPA

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Additive	heat stabilizer		
Features	Thermal Stability		
	Halogen-free		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.45	g/cm ³	ISO 1183
Molding Shrinkage			
Vertical flow direction	0.90	%	
Flow direction	0.20	%	
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	1.3	%	ISO 62
Moisture Content	< 2000	ppm	ISO 960
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	11500	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	170	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	2.0	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ISO 180/1A
-30°C	7.0	kJ/m ²	ISO 180/1A
23°C	8.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	280	°C	ISO 75-2/A
Melting Temperature ²	315	°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)	850	°C	IEC 60695-2-13
Injection	Nominal Value	Unit	
Drying Temperature	120	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.20	%	
Processing (Melt) Temp	320 - 340	°C	
Mold Temperature	140 - 180	°C	
Injection Rate	Fast		
Holding Pressure	40.0 - 80.0	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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