

4TECH® 9G22135 H

Polyphthalamide
4Plas

Message:

4TECH 9G22135 H is a Standard Flow 35% Glass Fibre Reinforced Heat Stabilised PPA

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 35% filler by weight		
Additive	heat stabilizer		
Features	Thermal Stability		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.47	g/cm ³	ISO 1183
Molding Shrinkage			
Vertical flow direction	1.0	%	
Flow direction	0.20	%	
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	1.6	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	14000	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	200	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	9.0	kJ/m ²	ISO 180/1A
23°C	10	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	550	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.750 mm	HB		UL 94
1.60 mm	HB		UL 94
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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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

