

Mapex HK4920SN

Polyamide 66

Ginar Technology Co., LTD.

Message:

Mapex HK4920SN PA6.6 is a 50 % glass fiber mineral reinforced product for injection moulding in black colour

General Information			
Filler / Reinforcement	Glass \mineral, 50% filler by weight		
Features	Highlight		
	Solvent resistance		
	Good formability		
	Good electrical performance		
	Good chemical resistance		
	Good wear resistance		
	Good weather resistance		
	Fuel resistance		
	Heat resistance, high		
	Oil resistance		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.60	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage - Flow (1.60 mm)	0.10 - 0.30	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	155	MPa	ISO 527-2
Tensile Strain (Break)	1.8	%	ISO 527-2
Flexural Modulus	11700	MPa	ISO 178
Flexural Stress	248	MPa	ISO 178
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	230	°C	ASTM D648, ISO 75-2/A
Melting Temperature	250	°C	DSC
Flammability	Nominal Value		Test Method
Flame Rating (1.50 mm)	HB		UL 94
Additional Information			
Notched Izod Impact Strength, ISO 180/1, notch 0.25 in, 23°C: 90 J/m			
Injection	Nominal Value	Unit	
Drying Temperature	90.0	°C	

Drying Time	4.0	hr
Rear Temperature	250 - 285	°C
Middle Temperature	250 - 285	°C
Front Temperature	250 - 285	°C
Nozzle Temperature	265 - 275	°C
Mold Temperature	30.0 - 100	°C
Injection Pressure	50.0 - 120	MPa
Injection Rate	Moderate-Fast	
Holding Pressure	30.0 - 80.0	MPa
Back Pressure	0.00 - 0.300	MPa
Screw Speed	60 - 100	rpm

Injection instructions

Injection Pressure: 70 to 85% Injection Speed: 70 to 85%

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Recommended distributors for this material

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