

4MID® 9B23300

Polyamide 6
4Plas

Message:

4MID 9B23300 is a Standard Flow FR-V2 PA6

General Information			
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.13	g/cm ³	ISO 1183
Molding Shrinkage			
Vertical flow direction	1.2	%	
Flow direction	1.2	%	
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	3.0	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	3000	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	80.0	MPa	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ISO 180/1A
-30°C	5.0	kJ/m ²	ISO 180/1A
23°C	6.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength			ISO 180/1U
-30°C	No Break		ISO 180/1U
23°C	No Break		ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	180	°C	ISO 75-2/B
1.8 MPa, not annealed	65.0	°C	ISO 75-2/A
Vicat Softening Temperature	200	°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 (3.20 mm)	V-2		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0	hr	

Suggested Max Moisture	0.20	%
Processing (Melt) Temp	240 - 260	°C
Mold Temperature	70.0 - 90.0	°C
Injection Rate	Moderate-Fast	
Holding Pressure	50.0 - 100	MPa
Screw Speed	400	rpm

Injection instructions

Feed Throat Temperature: 60 - 80 °C Back Pressure: Low

NOTE

1. 24 Hrs
2. 10 K/min

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