

ForTii® XS81B

Polyamide 4T

DSM Engineering Plastics

Message:

ForTii®XS81B is a Polyamide 4T (Nylon 4T) material, which contains a 50% glass fiber reinforced material. This product is available in the Asia-Pacific region. ForTii®The main characteristics of XS81B are: flame retardant/rated flame.

General Information				
Filler / Reinforcement		Glass fiber reinforced material, 50% filler by weight		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.63	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Transverse flow	0.45	--	%	ISO 294-4
Flow	0.20	--	%	ISO 294-4
Water Absorption (Equilibrium, 23°C, 50% RH)	1.8	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	17000	17000	MPa	ISO 527-2
Tensile Stress (Break)	280	230	MPa	ISO 527-2
Tensile Strain (Break)	2.5	2.3	%	ISO 527-2
Flexural Modulus	16500	--	MPa	ISO 178
Flexural Stress	380	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	15	--	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	90	--	kJ/m ²	ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	245	--	°C	ISO 75-2/A
Melting Temperature ¹	315	--	°C	ISO 11357-3
Flammability	Dry	Conditioned	Test Method	
Flammability Classification (1.5 mm)	HB	--	IEC 60695-11-10, -20	
Injection	Dry	Unit		
Drying Temperature	100	°C		
Drying Time	4.0 - 8.0	hr		
Rear Temperature	320 - 330	°C		
Middle Temperature	325 - 335	°C		
Front Temperature	330 - 335	°C		
Nozzle Temperature	330 - 335	°C		

Processing (Melt) Temp	330 - 340	°C
Mold Temperature	100 - 150	°C
Injection Rate	Moderate-Fast	
Back Pressure	0.500 - 3.00	MPa
Screw Compression Ratio	2.5:1.0	

NOTE

1. 10°C/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



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