

4MID® 9A22325

Polyamide 66
4Plas

Message:

4MID 9A22325 is a Standard Flow 25% Glass Fibre & Bead Reinforced PA66

General Information			
Filler / Reinforcement	Glass Beads \Glass Fiber, 25% Filler by Weight		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.31	g/cm ³	ISO 1183
Molding Shrinkage - Across Flow	1.1	%	
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	1.8	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	6500	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	100	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	3.0	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			
-30°C	6.0	kJ/m ²	ISO 179
23°C	7.0	kJ/m ²	ISO 179/B
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	35	kJ/m ²	ISO 179/1eU
23°C	40	kJ/m ²	ISO 179/1eU
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
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	245	°C	ISO 75-2/B
1.8 MPa, not annealed	240	°C	ISO 75-2/A
Vicat Softening Temperature	240	°C	ISO 306/B
Melting Temperature ²	262	°C	ISO 11357
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+13	ohms	IEC 60093
Dielectric Strength	35	kV/mm	IEC 60243-1
Relative Permittivity			IEC 60250
1 Hz	3.70		IEC 60250
100 Hz	4.00		IEC 60250

Dissipation Factor			IEC 60250
1 Hz	0.018		IEC 60250
100 Hz	9.0E-3		IEC 60250
Comparative Tracking Index	500	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.60 mm	HB		UL 94
3.20 mm	HB		UL 94
Glow Wire Flammability Index (2.00 mm)	650	°C	IEC 60695-2-12
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0	hr	
Suggested Max Moisture	0.20	%	
Processing (Melt) Temp	270 - 300	°C	
Mold Temperature	70.0 - 110	°C	
Injection Rate	Fast		
Holding Pressure	50.0 - 100	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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