

4MID® 9AB23500 H

Polyamide 66/6 Copolymer

4Plas

Message:

4MID 9AB23500 H is a Standard Flow Halogen Free FR-V0 Heat Stabilised PA66 / PA6 Blend

General Information			
Additive	heat stabilizer		
Features	Thermal Stability		
	Halogen-free		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.16	g/cm ³	ISO 1183
Molding Shrinkage			
Vertical flow direction	1.2	%	
Flow direction	1.2	%	
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	2.5	%	ISO 62
Moisture Content	< 2000	ppm	ISO 960
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	3500	MPa	ISO 527-2/5
Tensile Stress (Yield, 23°C)	70.0	MPa	ISO 527-2/50
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
Thermal	Nominal Value	Unit	Test Method
Melting Temperature ²	245	°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 (1.60 mm)	V-0		UL 94
Glow Wire Flammability Index (2.00 mm)	850	°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	240 - 290	°C
Mold Temperature	50.0 - 90.0	°C
Injection Rate	Moderate-Fast	
Holding Pressure	50.0 - 100	MPa
Screw Speed	400	rpm

Injection instructions

Feed Throat Temperature: 60 - 80 °CBack Pressure: Low

NOTE

1.	24 Hrs
2.	10 K/min

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