

# 4TECH® 9A22730 H

Polyamide 66  
4Plas

Message:

4TECH 9A22730 H is a Standard Flow 30% Carbon Fibre Reinforced Heat Stabilised PA66

| General Information                                       |                                                        |                   |             |
|-----------------------------------------------------------|--------------------------------------------------------|-------------------|-------------|
| Filler / Reinforcement                                    | Carbon fiber reinforced material, 30% filler by weight |                   |             |
| Additive                                                  | heat stabilizer                                        |                   |             |
| Features                                                  | Thermal Stability                                      |                   |             |
| Processing Method                                         | Injection molding                                      |                   |             |
| Physical                                                  | Nominal Value                                          | Unit              | Test Method |
| Density                                                   | 1.25                                                   | g/cm <sup>3</sup> | ISO 1183    |
| Water Absorption <sup>1</sup> (Equilibrium, 23°C, 50% RH) | 2.2                                                    | %                 | ISO 62      |
| Mechanical                                                | Nominal Value                                          | Unit              | Test Method |
| Tensile Modulus (23°C)                                    | 18000                                                  | MPa               | ISO 527-2/5 |
| Tensile Stress (Break, 23°C)                              | 200                                                    | MPa               | ISO 527-2/5 |
| Tensile Strain (Break, 23°C)                              | 2.5                                                    | %                 | ISO 527-2/5 |
| Impact                                                    | Nominal Value                                          | Unit              | Test Method |
| Notched Izod Impact (23°C)                                | 10                                                     | kJ/m <sup>2</sup> | ISO 180/1A  |
| Thermal                                                   | Nominal Value                                          | Unit              | Test Method |
| Heat Deflection Temperature (0.45 MPa, Unannealed)        | 255                                                    | °C                | ISO 75-2/B  |
| Melting Temperature <sup>2</sup>                          | 265                                                    | °C                | ISO 11357   |
| Flammability                                              | Nominal Value                                          | Test Method       |             |
| Flame Rating (1.60 mm)                                    | HB                                                     | UL 94             |             |
| 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 °CBack Pressure: Low     |                                                        |                   |             |
| NOTE                                                      |                                                        |                   |             |
| 1.                                                        | 24 Hrs                                                 |                   |             |
| 2.                                                        | 10 K/min                                               |                   |             |

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