

4MID® 9A22115 I

Polyamide 66

4Plas

Message:

4MID 9A22115 I is a Standard Flow 15% Glass Fibre Reinforced Impact Modified PA66

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 15% filler by weight		
Additive	Impact modifier		
Features	Impact modification		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.24	g/cm ³	ISO 1183
Molding Shrinkage			
Vertical flow direction	1.2	%	
Flow direction	0.40	%	
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	1.5	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	6300	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	130	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	5.0	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ISO 180/1A
-30°C	7.0	kJ/m ²	ISO 180/1A
23°C	8.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	240	°C	ISO 75-2/B
1.8 MPa, not annealed	225	°C	ISO 75-2/A
Vicat Softening Temperature	255	°C	ISO 306/B
Melting Temperature ²	263	°C	ISO 11357
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index	500	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 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	260 - 300	°C
Mold Temperature	50.0 - 110	°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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