

4MID® 9B12130 W

Polyamide 6

4Plas

Message:

4MID 9B12130 W is a Extrusion 30% Glass Fibre Reinforced Low Warp PA6

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Features	Low warpage		
Processing Method	Extrusion		
	Injection molding		

Physical	Nominal Value	Unit	Test Method
Density	1.36	g/cm ³	ISO 1183
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	2.1	%	ISO 62
Moisture Content	< 2000	ppm	ISO 960

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	9500	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	170	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	3.0	%	ISO 527-2/5

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ISO 180/1A
-30°C	10	kJ/m ²	ISO 180/1A
23°C	14	kJ/m ²	ISO 180/1A

Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	220	°C	ISO 75-2/B
1.8 MPa, not annealed	205	°C	ISO 75-2/A
Vicat Softening Temperature	215	°C	ISO 306/B
Melting Temperature ²	223	°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	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	250 - 270	°C
Mold Temperature	60.0 - 100	°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

Extrusion	Nominal Value	Unit
Drying Temperature	80.0	°C
Drying Time	2.0	hr
Suggested Max Moisture	0.20	%
Melt Temperature	250 - 270	°C
Die Temperature	60.0 - 100	°C

NOTE

1. 24 Hrs
2. 10 K/min

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