

# 4TECH® 9B22675

Polyamide 6  
4Plas

Message:

4TECH 9B22675 is a Standard Flow 75% Copper Fibre Reinforced PA6

| General Information                                       |                                     |                   |             |
|-----------------------------------------------------------|-------------------------------------|-------------------|-------------|
| Filler / Reinforcement                                    | Copper filler, 75% filler by weight |                   |             |
| Processing Method                                         | Injection molding                   |                   |             |
| Physical                                                  | Nominal Value                       | Unit              | Test Method |
| Density                                                   | 2.90                                | g/cm <sup>3</sup> | ISO 1183    |
| Water Absorption <sup>1</sup> (Equilibrium, 23°C, 50% RH) | 0.70                                | %                 | ISO 62      |
| Mechanical                                                | Nominal Value                       | Unit              | Test Method |
| Tensile Modulus (23°C)                                    | 4500                                | MPa               | ISO 527-2/5 |
| Tensile Stress (Break, 23°C)                              | 25.0                                | MPa               | ISO 527-2/5 |
| Impact                                                    | Nominal Value                       | Unit              | Test Method |
| Notched Izod Impact (23°C)                                | 5.0                                 | kJ/m <sup>2</sup> | ISO 180/1A  |
| Thermal                                                   | Nominal Value                       | Unit              | Test Method |
| Melting Temperature <sup>2</sup>                          | 223                                 | °C                | ISO 11357   |
| Electrical                                                | Nominal Value                       | Unit              | Test Method |
| Surface Resistivity                                       | 1.0E+13                             | ohms              | IEC 60093   |
| Volume Resistivity                                        | 1.0E+13                             | ohms · cm         | IEC 60093   |
| Flammability                                              | Nominal Value                       | Unit              | Test Method |
| Flame Rating                                              |                                     |                   | UL 94       |
| 0.750 mm                                                  | HB                                  |                   | UL 94       |
| 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                                    | 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 °CBack Pressure: Low     |                                     |                   |             |
| NOTE                                                      |                                     |                   |             |
| 1.                                                        | 24 Hrs                              |                   |             |

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