

4TECH® 9G20000

Polyphthalamide
4Plas

Message:

4TECH 9G20000 is a Standard Flow Unfilled PPA

General Information			
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.20	g/cm ³	ISO 1183
Molding Shrinkage			
Vertical flow direction	1.5	%	
Flow direction	1.5	%	
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	2.4	%	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)	90.0	MPa	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ISO 180/1A
-30°C	4.0	kJ/m ²	ISO 180/1A
23°C	7.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	125	°C	ISO 75-2/A
Melting Temperature ²	245	°C	ISO 11357
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	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-2		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	120	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.20	%	
Processing (Melt) Temp	320 - 340	°C	
Mold Temperature	70.0 - 90.0	°C	
Injection Rate	Moderate-Fast		
Holding Pressure	40.0 - 80.0	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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