

SAXAMID™ 236F4Q32

Polyamide 66

SAX Polymers

Message:

SAXAMID 236 F4Q32 is a impact-modified polyamide 6.6 injection-molding-grade reinforced with 20 % glass fibres and very good flow properties. This grade is suitable for applications requiring extraordinary toughness in combination with low creep properties.

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Additive	Impact Modifier		
Features	Good Creep Resistance		
	Good Flow		
	Good Toughness		
	Impact Modified		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.19	g/cm ³	ISO 1183
Viscosity Number (H2SO4 (Sulphuric Acid))	150	cm ³ /g	ISO 307
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	5500	MPa	ISO 527-2/1
Tensile Stress (Break)	115	MPa	ISO 527-2/5
Tensile Strain (Break)	3.4	%	ISO 527-2/5
Flexural Modulus ¹	4800	MPa	ISO 178
Flexural Stress ²	163	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	10	kJ/m ²	
23°C	17	kJ/m ²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	69	kJ/m ²	
23°C	85	kJ/m ²	
Notched Izod Impact Strength			ISO 180/1A
-30°C	10	kJ/m ²	
23°C	15	kJ/m ²	
Unnotched Izod Impact Strength			ISO 180/1U
-30°C	75	kJ/m ²	
23°C	90	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method

Heat Deflection Temperature ³ (1.8 MPa, Unannealed, 60.0 mm Span)	235	°C	ISO 75-2/A
Vicat Softening Temperature	235	°C	ISO 306/B120
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0 to 6.0	hr	
Suggested Max Moisture	0.20	%	
Processing (Melt) Temp	260 to 290	°C	
Mold Temperature	70.0 to 90.0	°C	
NOTE			
1.	2.0 mm/min		
2.	2.0 mm/min		
3.	80*10*4mm		

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