

4MID® 9A10000

Polyamide 66

4Plas

Message:

4MID 9A10000 is a Extrusion Unfilled PA66

General Information			
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.14	g/cm ³	ISO 1183
Molding Shrinkage			
Vertical flow direction	1.4	%	
Flow direction	1.4	%	
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	2.7	%	ISO 62
Moisture Content	< 2000	ppm	ISO 960
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	3200	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	80.0	MPa	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	5.0	kJ/m ²	ISO 179/1eA
23°C	6.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	No Break		ISO 179/1eU
23°C	No Break		ISO 179/1eU
Notched Izod Impact			ISO 180/1A
-30°C	5.0	kJ/m ²	ISO 180/1A
23°C	6.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	210	°C	ISO 75-2/B
1.8 MPa, not annealed	80.0	°C	ISO 75-2/A
Melting Temperature ²	262	°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	600	V	IEC 60112

Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.60 mm	V-2		UL 94
3.20 mm	V-2		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0	hr	
Suggested Max Moisture	0.20	%	
Processing (Melt) Temp	270 - 290	°C	
Mold Temperature	50.0 - 90.0	°C	
Injection Rate	Moderate-Fast		
Holding Pressure	50.0 - 100	MPa	
Screw Speed	400	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	270 - 290	°C	
Die Temperature	50.0 - 90.0	°C	
NOTE			
1.	24 Hrs		
2.	10 K/min		

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