

4TECH® 9A22740 H

Polyamide 66
4Plas

Message:

4TECH 9A22740 H is a Standard Flow 40% Carbon Fibre Reinforced Heat Stabilised PA66

General Information			
Filler / Reinforcement	Carbon fiber reinforced material, 40% filler by weight		
Additive	heat stabilizer		
Features	Thermal Stability		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.25	g/cm ³	ISO 1183
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	1.6	%	ISO 62
Moisture Content	< 2000	ppm	ISO 960
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	27500	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	240	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	1.5	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	10	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	260	°C	ISO 75-2/B
1.8 MPa, not annealed	255	°C	ISO 75-2/A
Melting Temperature ²	262	°C	ISO 11357
Flammability	Nominal Value	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	270 - 300	°C	
Mold Temperature	70.0 - 110	°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

NOTE

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| 1. | 24 Hrs |
| 2. | 10 K/min |

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