

# 4MID® 9B24300

Polyamide 6

4Plas

Message:

4MID 9B24300 is a Standard Flow High Impact PA6

| General Information                                       |                         |                   |             |
|-----------------------------------------------------------|-------------------------|-------------------|-------------|
| Additive                                                  | Impact modifier         |                   |             |
| Features                                                  | Impact modification     |                   |             |
|                                                           | Impact resistance, high |                   |             |
| Processing Method                                         | Injection molding       |                   |             |
| Physical                                                  | Nominal Value           | Unit              | Test Method |
| Density                                                   | 1.11                    | g/cm <sup>3</sup> | ISO 1183    |
| Molding Shrinkage                                         |                         |                   |             |
| Vertical flow direction                                   | 1.3                     | %                 |             |
| Flow direction                                            | 1.3                     | %                 |             |
| Water Absorption <sup>1</sup> (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)                                    | 2500                    | MPa               | ISO 527-2/5 |
| Tensile Stress                                            |                         |                   | ISO 527-2/5 |
| Yield, 23°C                                               | 65.0                    | MPa               | ISO 527-2/5 |
| Fracture, 23°C                                            | 75.0                    | MPa               | ISO 527-2/5 |
| Tensile Strain (Break, 23°C)                              | 35                      | %                 | ISO 527-2/5 |
| Impact                                                    | Nominal Value           | Unit              | Test Method |
| Notched Izod Impact                                       |                         |                   | ISO 180/1A  |
| -30°C                                                     | 10                      | kJ/m <sup>2</sup> | ISO 180/1A  |
| 23°C                                                      | 17                      | kJ/m <sup>2</sup> | ISO 180/1A  |
| Unnotched Izod Impact Strength                            |                         |                   | ISO 180/1U  |
| -30°C                                                     | No Break                |                   | ISO 180/1U  |
| 23°C                                                      | No Break                |                   | ISO 180/1U  |
| Thermal                                                   | Nominal Value           | Unit              | Test Method |
| Heat Deflection Temperature                               |                         |                   |             |
| 0.45 MPa, not annealed                                    | 140                     | °C                | ISO 75-2/B  |
| 1.8 MPa, not annealed                                     | 55.0                    | °C                | ISO 75-2/A  |
| Vicat Softening Temperature                               | 170                     | °C                | ISO 306/B   |
| 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+15       | ohms·cm | IEC 60093      |
| Comparative Tracking Index                             | 600           | V       | IEC 60112      |
| Flammability                                           | Nominal Value | Unit    | Test Method    |
| Flame Rating                                           |               |         | UL 94          |
| 0.750 mm                                               | HB            |         | UL 94          |
| 1.60 mm                                                | HB            |         | UL 94          |
| Glow Wire Flammability Index (2.00 mm)                 | 650           | °C      | IEC 60695-2-12 |
| Injection                                              | Nominal Value | Unit    |                |
| Drying Temperature                                     | 80.0          | °C      |                |
| Drying Time                                            | 2.0           | hr      |                |
| Suggested Max Moisture                                 | 0.20          | %       |                |
| Processing (Melt) Temp                                 | 230 - 260     | °C      |                |
| Mold Temperature                                       | 70.0 - 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 |               |         |                |
| NOTE                                                   |               |         |                |
| 1.                                                     | 24 Hrs        |         |                |
| 2.                                                     | 10 K/min      |         |                |

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