

Stanyl® ForTii™ LED4U (NC1103Q)

Polyamide 4T
DSM Engineering Plastics

Message:

Stanyl® ForTii™ LED4U (NC1103Q) is a Polyamide 4T (Nylon 4T) material filled with glass fiber. It is available in Asia Pacific, Europe, or North America.

General Information			
UL YellowCard	E47960-100958492		
Filler / Reinforcement	Glass Fiber		
Physical	Nominal Value	Unit	Test Method
Density	1.58	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow	1.0	%	
Flow	1.8	%	
Water Absorption (Equilibrium, 23°C, 50% RH)	1.7	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	7500	MPa	ISO 527-2
Tensile Stress (Break)	65.0	MPa	ISO 527-2
Tensile Strain (Break)	0.90	%	ISO 527-2
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	173	°C	ISO 75-2/A
Melting Temperature ¹	325	°C	ISO 11357-3
Injection	Nominal Value	Unit	
Drying Temperature	100	°C	
Drying Time	4.0 to 8.0	hr	
Rear Temperature	320 to 330	°C	
Middle Temperature	325 to 335	°C	
Front Temperature	330 to 335	°C	
Nozzle Temperature	330 to 335	°C	
Processing (Melt) Temp	330 to 340	°C	
Mold Temperature	100 to 150	°C	
Injection Rate	Moderate-Fast		
Back Pressure	0.500 to 3.00	MPa	
Screw Compression Ratio	2.5:1.0		
NOTE			
1.	10°C/min		

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