

4MID® 9B22115

Polyamide 6
4Plas

Message:

4MID 9B22115 is a Standard Flow 15% Glass Fibre Reinforced PA6

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 15% filler by weight		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.23	g/cm ³	ISO 1183
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	2.5	%	ISO 62
Moisture Content	< 2000	ppm	ISO 960
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	5500	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	110	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	3.0	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
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
Unnotched Izod Impact Strength			ISO 180/1U
-30°C	35	kJ/m ²	ISO 180/1U
23°C	40	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	205	°C	ISO 75-2/B
1.8 MPa, not annealed	190	°C	ISO 75-2/A
Vicat Softening Temperature	210	°C	ISO 306/B
Melting Temperature ²	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	500	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 Ignition Temperature (2.00 mm)	650	°C	IEC 60695-2-13

Injection	Nominal Value	Unit
Drying Temperature	80.0	°C
Drying Time	2.0	hr
Suggested Max Moisture	0.20	%
Processing (Melt) Temp	250 - 270	°C
Mold Temperature	60.0 - 100	°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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