

TECHNICAL DATASHEET

TRAMID® 4113H40

PA6 GFMF

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.48
Water Absorption (24 hours at 23°C)	%	D570	0.2
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	1,100
Tensile Elongation at break	%	D638	3
Flexural Strength at yield	kg _f /cm ²	D790	1,650
Flexural Modulus	kg _f /cm ²	D790	64,400
Izod Impact Strength, notched, 23°C (1/8")	kg _f ·cm/cm	D256	5
THERMAL			
HDT, 18.6 kg _f /cm ²	°C	D648	205
ELECTRICAL			
OTHERS			
Mold Shrinkage (3mm thickness)	%	D955	0.4~0.7

※ The figures listed in this table are typical values obtained under the standard test methods and may not be applicable for products that are under different application condition.

PROCESSING GUIDE

TRAMID® 4113H40 GRADE

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- General processing conditions for TRAMID4113H40 are shown below. Drying prior to processing is essential to ensure desired appearance and property performance.

SPECIFICATION	UNIT	CONDITIONS
Drying Temperature	℃	90
Drying Time	hr	5~7
Moisture Content, Max	%	0.02
Melt Temperature	℃	250~280
Nozzle Temperature	℃	260~280
Front Temperature	℃	260~280
Middle Temperature	℃	260~280
Rear Temperature	℃	205~270
Mold Temperature	℃	60~80
Back Pressure	MPa	0.3~0.5
Screw Speed	rpm	50~70

Global Network

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