

TECHNICAL DATASHEET

TRAMID[®] 4210G15

PA66 GF15

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.24
Water Absorption (24 hours at 23°C)	%	D570	0.9
Melt Flow Rate (275°C, 2.16kg)	g/10min	D1238	8
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	1,150
Tensile Elongation at break	%	D638	3
Flexural Strength at yield	kg _f /cm ²	D790	1,850
Flexural Modulus	kg _f /cm ²	D790	58,000
Izod Impact Strength, notched, 23°C (1/8")	kg _f ·cm/cm	D256	4
THERMAL			
HDT, 18.6 kgf/cm ²	°C	D648	240
ELECTRICAL			
OTHERS			
Mold Shrinkage (3mm thickness)	%	D955	0.8~1.2

※ 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® 4210G15 GRADE

PA66 GF15

- General processing conditions for TRAMID4210G15 are shown below. Drying prior to processing is essential to ensure desired appearance and property performance.

SPECIFICATION	UNIT	CONDITIONS
Drying Temperature	℃	120
Drying Time	hr	5~7
Moisture Content, Max	%	0.2
Melt Temperature	℃	270~290
Nozzle Temperature	℃	270~300
Front Temperature	℃	270~300
Middle Temperature	℃	260~290
Rear Temperature	℃	220~260
Mold Temperature	℃	20~70
Back Pressure	MPa	0.1~0.5
Screw Speed	rpm	30~70
Vent Depth	mm	0.02~0.08

Global Network

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