

TECHNICAL DATASHEET

TRAMID[®] 4210GNH30

PA66

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.40
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	125
Tensile Elongation at break	%	D638	> 1.8
Flexural Strength at yield	kg _f /cm ²	D790	185
Flexural Modulus	kg _f /cm ²	D790	9,000
Izod Impact Strength, notched, 23°C (1/8")	kg _f ·cm/cm	D256	55
THERMAL			
HDT, 18.6 kg _f /cm ²	°C	D648	235
ELECTRICAL			
Dielectric Constant	-	D150	4.0
OTHERS			
UL-94 Flammability (0.75, 1.5, 3.0mm)	-	(UL 94)	V-0
Mold Shrinkage	%		0.3~0.8

※ 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® 4210GNH30 GRADE

PA66

- General processing conditions for TRAMID4210GNH30 are shown below. Drying prior to processing is essential to ensure desired appearance and property performance.

SPECIFICATION	UNIT	CONDITIONS
Drying Temperature	℃	80~100
Drying Time	hr	4~6
Melt Temperature	℃	270~290
Nozzle Temperature	℃	270~290
Front Temperature	℃	270~290
Middle Temperature	℃	260~280
Rear Temperature	℃	240~260
Mold Temperature	℃	60~100
Back Pressure	MPa	<70
Screw Speed	rpm	<60
Injection Pressure	MPa	<70
Injection Speed	%	<60
Hold Pressure	MPa	<50
Injection Cushion	mm	3~6

Global Network

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