

TECHNICAL DATASHEET

TRAMID[®] 4211

PA66

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.13
Water Absorption (24 hours at 23°C)	%	D570	1.3
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	800
Tensile Elongation at break	%	D638	20
Flexural Strength at yield	kg _f /cm ²	D790	1,050
Flexural Modulus	kg _f /cm ²	D790	25,000
Izod Impact Strength, notched, 23°C (1/8")	kg _f ·cm/cm	D256	7
Rockwell Hardness	R scale	D785	110
THERMAL			
HDT, 18.6 kg _f /cm ²	°C	D648	67
ELECTRICAL			
OTHERS			

※ 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® 4211 GRADE

PA66

- General processing conditions for TRAMID4211 are shown below. Drying prior to processing is essential to ensure desired appearance and property performance.

SPECIFICATION	UNIT	CONDITIONS
Drying Temperature	℃	80-90
Drying Time	hr	3-5
Moisture Content, Max	%	0.2
Melt Temperature	℃	260~280
Nozzle Temperature	℃	260-290
Front Temperature	℃	255-285
Middle Temperature	℃	250~280
Rear Temperature	℃	245-275
Mold Temperature	℃	60-90

Global Network

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