

GLAMIDE® T-422V0 R

PA6-MX23

Toyobo Co., Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	20	g/10min	ASTM D 1238
Mold Shrinkage, MD	0.0015	mm/mm	ASTM D 955

Mechanical properties	dry / cond	Unit	Test Standard
ASTM Data			
Tensile Strength	51 / 38	MPa	ASTM D 638
Compressive Strength	62 / 45	MPa	ASTM D 695
Flexural Modulus	6100 / 4400	MPa	ASTM D 790
Flexural Strength	90 / 63	MPa	ASTM D 790
Rockwell Hardness	R 118 /	-	ASTM D 785
Taber Abrasion Resistance	32	mg/1000 cycles	ASTM D 1044
Izod Impact notched, 1/8 in	40 / 70	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	30 / 45	J/m	ASTM D 256
Temperature	-40	°C	-

Thermal properties	Value	Unit	Test Standard
ASTM Data			
UL 94 Flame rating	V-0	-	UL 94
Thickness tested	0.73	mm	-
Coefficient of Thermal Expansion, MD	42	E-6/K	ASTM D 696
DTUL @ 66 psi	205	°C	ASTM D 648
DTUL @ 264 psi	160	°C	ASTM D 648

Electrical properties	dry / cond	Unit	Test Standard
ISO Data			
Comparative tracking index	350 / 350	-	IEC 60112
ASTM Data			
Dielectric Strength, Short Time	29 / 20	kV/mm	ASTM D 149
Volume Resistivity	1E15 / 1E12	Ohm*cm	ASTM D 257
Arc Resistance	25 / 15	s	ASTM D 495

Other properties	Value	Unit	Test Standard
Water Absorption, 24hr	0.5	%	ASTM D 570
Water Absorption, Equilibrium	1.8	%	ASTM D 570
Density	1560	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80 - 120	°C	-
Pre-drying - Time	3 - 5	h	-
Melt temperature	250 - 285	°C	-
Mold temperature	60	°C	-
Injection pressure	40 - 60	MPa	-

Characteristics**Processing**

Injection Molding

Regional Availability

North America, Europe, Asia Pacific

Special Characteristics

Flame retardant, Halogen-free