

**GLAMIDE® T-422-02**

PA6-MX35

Toyobo Co., Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
Melt Flow Index, MFI	3	g/10min	ASTM D 1238
Mold Shrinkage, MD	0.0015	mm/mm	ASTM D 955

Mechanical properties	dry / cond	Unit	Test Standard
<b>ASTM Data</b>			
Tensile Strength	95 / 65	MPa	ASTM D 638
Compressive Strength	100 / 68	MPa	ASTM D 695
Flexural Modulus	7300 / 5000	MPa	ASTM D 790
Flexural Strength	145 / 96	MPa	ASTM D 790
Rockwell Hardness	R 120 /	-	ASTM D 785
Taber Abrasion Resistance	30	mg/1000 cycles	ASTM D 1044
Izod Impact notched, 1/8 in	95 / 270	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	58 / 70	J/m	ASTM D 256
Temperature	-40	°C	-

Thermal properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	1.5	mm	-
Coefficient of Thermal Expansion, MD	45	E-6/K	ASTM D 696
DTUL @ 66 psi	210	°C	ASTM D 648
DTUL @ 264 psi	175	°C	ASTM D 648

Electrical properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Comparative tracking index	600 / 600	-	IEC 60112
<b>ASTM Data</b>			
Dielectric Strength, Short Time	29 / 20	kV/mm	ASTM D 149
Volume Resistivity	1E15 / 1E12	Ohm*cm	ASTM D 257
Arc Resistance	130 / 120	s	ASTM D 495

Other properties	Value	Unit	Test Standard
Water Absorption, 24hr	0.7	%	ASTM D 570
Water Absorption, Equilibrium	2.3	%	ASTM D 570
Density	1420	kg/m <sup>3</sup>	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	260 - 290	°C	-
Mold temperature	60 - 100	°C	-
Injection pressure	40 - 80	MPa	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

North America, Europe, Asia Pacific

**Special Characteristics**

Heat stabilized or stable to heat