

GLAMIDE™ T-422VOR
TOYOBO MC Corporation - Polyamide 6

General Information			
Product Description			
MD Reinforced, Flame Retardant			
General			
Material Status	• Commercial: Active		
Filler / Reinforcement	• Mineral, 25% Filler by Weight		
Features	• Flame Retardant	• Good Dimensional Stability	• Pleasing Surface Appearance
Uses	• Automotive Applications • Automotive Exterior Parts	• General Purpose • Industrial Applications	
Forms	• Pellets		
Processing Method	• Injection Molding		
Part Marking Code (ISO 11469)	• >PA6-MD25FR<		
Revision Date	• 9/4/2025		
ASTM & ISO Properties			
Physical	Nominal Value	Unit	Test Method
Density	1.56	g/cm³	ISO 1183
Molding Shrinkage ¹			Internal Method
Flow : 2.00 mm	0.50	%	
Across Flow : 2.00 mm	0.60	%	
Water Absorption (24 hr, 23°C)	0.80	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	50.0	MPa	ISO 527
Tensile Elongation (Break)	1.5	%	ISO 527
Flexural Modulus	6600	MPa	ISO 178
Flexural Strength	110	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	1.8	kJ/m²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed	180	°C	ISO 75-2/B
1.8 MPa, Unannealed	80.0	°C	ISO 75-2/A
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms·cm	IEC 60250
Processing Information			
Injection		Unit	
Drying Temperature	100 to 120	°C	
Drying Time	3.0 to 5.0	hr	
Middle Temperature	240 to 270	°C	
Front Temperature	240 to 270	°C	
Nozzle Temperature	240 to 270	°C	
Mold Temperature	70 to 90	°C	

