

**KEPAMID® 2333GF**

PA66-GF33

Korea Engineering Plastics Co. Ltd.

<b>Processing/Physical Characteristics</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Molding shrinkage, parallel	<b>0.7</b>	%	ISO 294-4, 2577
<b>Mechanical properties</b>			
<b>ISO Data</b>			
Tensile Strength	<b>195</b>	MPa	ISO 527
Strain at break	<b>3</b>	%	ISO 527
Flexural modulus, 23°C	<b>9800</b>	MPa	ISO 178
Charpy notched impact strength, +23°C	<b>11</b>	kJ/m <sup>2</sup>	ISO 179/1eA
Rockwell hardness	<b>R121</b>	-	ISO 2039-2
<b>Thermal properties</b>			
<b>ISO Data</b>			
Melting temperature, 10°C/min	<b>260</b>	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	<b>255</b>	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	<b>260</b>	°C	ISO 75-1/-2
Burning behav. at thickness h	<b>HB</b>	class	IEC 60695-11-10
Thickness tested	<b>0.8</b>	mm	-
<b>Electrical properties</b>			
<b>ISO Data</b>			
Relative permittivity, 1MHz	<b>3.2</b>	-	IEC 62631-2-1
<b>Other properties</b>			
Humidity absorption	<b>0.7</b>	%	Sim. to ISO 62
Density	<b>1390</b>	kg/m <sup>3</sup>	ISO 1183
<b>Processing Recommendation Injection Molding</b>			
Pre-drying - Temperature	<b>80 - 90</b>	°C	-
Pre-drying - Time	<b>4 - 8</b>	h	-
Processing humidity	<b>≤0.05</b>	%	-
Mold temperature	<b>70 - 90</b>	°C	-
Feed temperature	<b>60 - 80</b>	°C	-
Zone 1	<b>280</b>	°C	-
Zone 2	<b>285</b>	°C	-
Zone 3	<b>285</b>	°C	-
Nozzle temperature	<b>290</b>	°C	-
Screw speed	<b>80 - 120</b>	rpm	-
Back pressure	<b>0.5 - 1</b>	MPa	-

**Characteristics****Processing**

Injection Molding

**Applications**

Automotive, Electrical and Electronical

**Special Characteristics**

Heat stabilized or stable to heat

**Regional Availability**

North America, Europe, Asia Pacific