KOPA® KN333HI5

PA66 — Kolon Industries

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	**2.0**	%	ISO 294-4, 2577
Molding shrinkage, normal	**2.0**	%	ISO 294-4, 2577
ASTM Data			
Mold Shrinkage, MD	**0.0175**	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Strength	**60**	MPa	ISO 527
Flexural modulus, 23°C	**2200**	MPa	ISO 178
Charpy notched impact strength, +23°C	**55**	kJ/m²	ISO 179/1eA
Rockwell hardness	**R 113**	-	ISO 2039-2
ASTM Data			
Tensile Strength	**59**	MPa	ASTM D 638
Flexural Modulus	**2256**	MPa	ASTM D 790
Flexural Strength	**88**	MPa	ASTM D 790
Rockwell Hardness	**R 110**	-	ASTM D 785
Izod Impact notched, 1/8 in	**490**	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Melting temperature, 10°C/min	**255**	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	**66**	°C	ISO 75-1/-2
ASTM Data			
UL 94 Flame rating	**HB**	-	UL 94
Thickness tested	**0.8**	mm	-
Coefficient of Thermal Expansion, MD	**60**	E-6/K	ASTM D 696
DTUL @ 66 psi	**210**	°C	ASTM D 648
DTUL @ 264 psi	**70**	°C	ASTM D 648
Melting Temperature	**255**	°C	ASTM D 3418

Electrical properties	Value	Unit	Test Standard
ASTM Data			
Dielectric Strength, Short Time	**20**	kV/mm	ASTM D 149
Dielectric Constant, 1 MHz	**3.1**	-	ASTM D 150
Arc Resistance	**125**	s	ASTM D 495

Other properties	Value	Unit	Test Standard
Density	**1100**	kg/m³	ISO 1183
Density	**1100**	kg/m³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**80 - 100**	°C	-
Pre-drying - Time	**4 - 5**	h	-
Processing humidity	**≤0.05**	%	-
Mold temperature	**60 - 80**	°C	-
Zone 1	**250**	°C	-
Zone 2	**260**	°C	-
Zone 3	**265**	°C	-
Nozzle temperature	**270**	°C	-

Characteristics

Processing

Injection Molding

Applications

Electrical and Electronical

Special Characteristics
High impact or impact modified

Regional Availability
North America, Asia Pacific