Reny 1002HUS

PAMXD6-GF30 — Mitsubishi Engineering-Plastics Corporation

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	**4.6 / ***	cm³/10min	ISO 1133
Temperature	**275 / ***	°C	-
Load	**2.16 / ***	kg	-
Melt flow index, MFI	**6.9**	g/10min	ISO 1133
Temperature	**275**	°C	-
Load	**2.16**	kg	-
Molding shrinkage, parallel	**0.3 / ***	%	ISO 294-4, 2577
Molding shrinkage, normal	**0.7 / ***	%	ISO 294-4, 2577

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	**15000 / 13900**	MPa	ISO 527
Stress at break	**192 / 182**	MPa	ISO 527
Strain at break	**1.4 / 1.4**	%	ISO 527
Flexural modulus, 23°C	**13100 / 13000**	MPa	ISO 178
Flexural strength	**308 / 271**	MPa	ISO 178
Charpy impact strength, +23°C	**48 / 35**	kJ/m²	ISO 179/1eU
Charpy notched impact strength, +23°C	**7 / 5.8**	kJ/m²	ISO 179/1eA

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**237 / ***	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	**250 / ***	°C	ISO 75-1/-2
Burning behav. at 1.5 mm nom. thickn.	**HB / ***	class	IEC 60695-11-10
Thickness tested	**1.6 / ***	mm	-
Yellow Card available	**yes / ***	-	-

Other properties	dry / cond	Unit	Test Standard
Humidity absorption	**1.1 / ***	%	Sim. to ISO 62
Density	**1490 / -**	kg/m³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**120**	°C	-
Pre-drying - Time	**3**	h	-
Mold temperature	**120 - 140**	°C	-
Zone 1	**270**	°C	-
Zone 2	**275**	°C	-
Zone 3	**280**	°C	-
Nozzle temperature	**280**	°C	-
Screw speed	**60 - 150**	rpm	-
Injection pressure	**20 - 150**	MPa	-

Characteristics

Processing

Injection Molding

Applications

Automotive, Electrical and Electronical, General Purpose

Special Characteristics

Light stabilized or stable to light, U.V. stabilized or stable to weather

Regional Availability

North America, Europe, Asia Pacific, South and Central America, Near East/Africa

Copyright Altair Engineering GmbH. Altair Engineering GmbH assumes no liability for the system to be free of errors. The user takes sole responsibility for the use of this data under the exclusion of every liability from Altair Engineering GmbH; this is especially valid for claims of compensation resulting from consequential damages. Altair explicitly points out that any decision about the application of materials must be double checked with the producer of this material. This includes all contents of this system. Copyright laws are applicable for the content of this system.