Reny 1507

PAMXD6-GF30 — Mitsubishi Engineering-Plastics Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	**0.3**	%	ISO 294-4, 2577
Molding shrinkage, normal	**0.7**	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	**12500**	MPa	ISO 527
Stress at break	**169**	MPa	ISO 527
Strain at break	**1.8**	%	ISO 527
Flexural modulus, 23°C	**12000**	MPa	ISO 178
Flexural strength	**288**	MPa	ISO 178
Charpy impact strength, +23°C	**52**	kJ/m²	ISO 179/1eU
Charpy notched impact strength, +23°C	**7.8**	kJ/m²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**222**	°C	ISO 75-1/-2
Burning behav. at 1.5 mm nom. thickn.	**V-0**	class	IEC 60695-11-10
Thickness tested	**1.6**	mm	-
Yellow Card available	**yes**	-	-

Electrical properties	Value	Unit	Test Standard
ISO Data			
Comparative tracking index	**325**	-	IEC 60112

Other properties	Value	Unit	Test Standard
Density	**1510**	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	**265**	°C	-
Zone 2	**270**	°C	-
Zone 3	**275**	°C	-
Nozzle temperature	**275**	°C	-
Screw speed	**60 - 150**	rpm	-
Injection pressure	**20 - 150**	MPa	-

Characteristics

Processing

Injection Molding

Applications

Automotive, Electrical and Electronical, General Purpose

Special Characteristics

Flame retardant, Halogen-free

Regional Availability

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

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