

Reny 4511

PAMXD6-GF40

Mitsubishi Engineering-Plastics Corporation

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	1 / *	cm ³ /10min	ISO 1133
Temperature	280 / *	°C	-
Load	2.16 / *	kg	-
Melt flow index, MFI	1.8	g/10min	ISO 1133
Temperature	280	°C	-
Load	2.16	kg	-

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	20900 / 20600	MPa	ISO 527
Stress at break	130 / 125	MPa	ISO 527
Strain at break	0.6 / 0.8	%	ISO 527
Flexural modulus, 23°C	22200 / 22000	MPa	ISO 178
Flexural strength	215 / 208	MPa	ISO 178
Charpy impact strength, +23°C	12 / 12	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	6.9 / 8.9	kJ/m ²	ISO 179/1eA

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	223 / *	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	234 / *	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	8 / *	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	40 / *	E-6/K	ISO 11359-1/-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	dry / cond	Unit	Test Standard
ISO Data			
Volume resistivity	3 / 7E6	Ohm*m	IEC 62631-3-1
Surface resistivity	* / 40000	Ohm	IEC 62631-3-2

Other properties	dry / cond	Unit	Test Standard
Humidity absorption	0.7 / *	%	Sim. to ISO 62
Density	1770 / -	kg/m ³	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

Special Characteristics

Increased electrical conductivity, Flame retardant

Applications

Automotive, Electrical and Electronical, General Purpose

Regional Availability

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