

**Reny 1071**

PAMXD6-GF55

Mitsubishi Engineering-Plastics Corporation

<b>Processing/Physical Characteristics</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Molding shrinkage, parallel	<b>0.3 / *</b>	%	ISO 294-4, 2577
Molding shrinkage, normal	<b>0.6 / *</b>	%	ISO 294-4, 2577

<b>Mechanical properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Tensile Modulus	<b>24900 / 23700</b>	MPa	ISO 527
Stress at break	<b>264 / 237</b>	MPa	ISO 527
Strain at break	<b>1.6 / 1.6</b>	%	ISO 527
Flexural modulus, 23°C	<b>20600 / 20900</b>	MPa	ISO 178
Flexural strength	<b>423 / 384</b>	MPa	ISO 178
Charpy impact strength, +23°C	<b>83 / 66</b>	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	<b>17 / 16</b>	kJ/m <sup>2</sup>	ISO 179/1eA

<b>Thermal properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	<b>230 / *</b>	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	<b>11 / *</b>	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	<b>25 / *</b>	E-6/K	ISO 11359-1/-2
Burning behav. at thickness h	<b>HB / *</b>	class	IEC 60695-11-10

<b>Other properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
Humidity absorption	<b>1.5 / *</b>	%	Sim. to ISO 62
Density	<b>1700 / -</b>	kg/m <sup>3</sup>	ISO 1183

<b>Processing Recommendation Injection Molding</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Pre-drying - Temperature	<b>120</b>	°C	-
Pre-drying - Time	<b>3</b>	h	-
Mold temperature	<b>120 - 140</b>	°C	-
Zone 1	<b>265</b>	°C	-
Zone 2	<b>270</b>	°C	-
Zone 3	<b>275</b>	°C	-
Nozzle temperature	<b>275</b>	°C	-
Screw speed	<b>60 - 150</b>	rpm	-
Injection pressure	<b>20 - 150</b>	MPa	-

**Characteristics****Processing**

Injection Molding

**Applications**

Automotive, Electrical and Electronical, General Purpose

**Regional Availability**

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