Reny 1371

PAMXD6-GF55 — Mitsubishi Engineering-Plastics Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	**0.2**	%	ISO 294-4, 2577
Molding shrinkage, normal	**0.6**	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	**20800**	MPa	ISO 527
Stress at break	**242**	MPa	ISO 527
Strain at break	**1.9**	%	ISO 527
Flexural modulus, 23°C	**19600**	MPa	ISO 178
Flexural strength	**403**	MPa	ISO 178
Charpy impact strength, +23°C	**93**	kJ/m²	ISO 179/1eU
Charpy notched impact strength, +23°C	**16**	kJ/m²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**227**	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	**236**	°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	Value	Unit	Test Standard
Humidity absorption	**0.9**	%	Sim. to ISO 62
Density	**1660**	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

High impact or impact modified

Regional Availability

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