Reny 2686

PAMXD6-GF65 — Mitsubishi Engineering-Plastics Corporation

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	**6.9 / ***	cm³/10min	ISO 1133
Temperature	**275 / ***	°C	-
Load	**2.16 / ***	kg	-
Melt flow index, MFI	**7.6**	g/10min	ISO 1133
Temperature	**275**	°C	-
Load	**2.16**	kg	-
Molding shrinkage, parallel	**0.7 / ***	%	ISO 294-4, 2577
Molding shrinkage, normal	**0.7 / ***	%	ISO 294-4, 2577

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	**9800 / 7300**	MPa	ISO 527
Stress at break	**73 / 52**	MPa	ISO 527
Strain at break	**1.7 / 1.8**	%	ISO 527
Flexural modulus, 23°C	**9600 / 6600**	MPa	ISO 178
Flexural strength	**147 / 103**	MPa	ISO 178
Charpy impact strength, +23°C	**32 / 40**	kJ/m²	ISO 179/1eU
Charpy notched impact strength, +23°C	**2.2 / 2.4**	kJ/m²	ISO 179/1eA

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**147 / ***	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	**213 / ***	°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	**0.7 / ***	%	Sim. to ISO 62
Density	**1800 / -**	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

Features

Low Warpage

Regional Availability

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