KEPAMID® 1310GSU

PA6-GF8 — Korea Engineering Plastics Co. Ltd.

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

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Strength	**77**	MPa	ISO 527
Strain at break	**4**	%	ISO 527
Flexural modulus, 23°C	**3300**	MPa	ISO 178
Charpy notched impact strength, +23°C	**7.5**	kJ/m²	ISO 179/1eA
Rockwell hardness	**R112**	-	ISO 2039-2

Thermal properties	Value	Unit	Test Standard
ISO Data			
Melting temperature, 10°C/min	**220**	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	**190**	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	**205**	°C	ISO 75-1/-2
Burning behav. at thickness h	**HB**	class	IEC 60695-11-10
Thickness tested	**0.8**	mm	-

Electrical properties	Value	Unit	Test Standard
ISO Data			
Relative permittivity, 1MHz	**3.8**	-	IEC 62631-2-1

Other properties	Value	Unit	Test Standard
Humidity absorption	**1.45**	%	Sim. to ISO 62
Density	**1150**	kg/m³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**80 - 90**	°C	-
Pre-drying - Time	**4 - 8**	h	-
Processing humidity	**≤0.05**	%	-
Mold temperature	**70 - 90**	°C	-
Feed temperature	**60 - 80**	°C	-
Zone 1	**250**	°C	-
Zone 2	**260**	°C	-
Zone 3	**260**	°C	-
Nozzle temperature	**260**	°C	-
Screw speed	**80 - 120**	rpm	-
Back pressure	**0.5 - 1**	MPa	-

Characteristics

Processing
Injection Molding

Applications
Automotive, Electrical and Electronical

Special Characteristics
High impact or impact modified, U.V. stabilized or stable to weather, Heat stabilized or stable to heat

Regional Availability
North America, Europe, Asia Pacific