

KEPAMID® 2325GVF

PA66-GF25

Korea Engineering Plastics Co. Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.3	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Strength	145	MPa	ISO 527
Strain at break	3	%	ISO 527
Flexural modulus, 23°C	8100	MPa	ISO 178
Charpy notched impact strength, +23°C	10	kJ/m ²	ISO 179/1eA
Rockwell hardness	R118	-	ISO 2039-2

Thermal properties	Value	Unit	Test Standard
ISO Data			
Melting temperature, 10°C/min	260	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	235	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	255	°C	ISO 75-1/-2
Burning behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	0.8	mm	-

Electrical properties	Value	Unit	Test Standard
ISO Data			
Relative permittivity, 1MHz	3.4	-	IEC 62631-2-1

Other properties	Value	Unit	Test Standard
Humidity absorption	0.6	%	Sim. to ISO 62
Density	1530	kg/m ³	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	280	°C	-
Zone 2	285	°C	-
Zone 3	290	°C	-
Nozzle temperature	300	°C	-
Screw speed	80 - 120	rpm	-
Back pressure	0.5 - 1	MPa	-

Characteristics**Processing**

Injection Molding

Applications

Automotive, Electrical and Electronical

Special Characteristics

Flame retardant, Heat stabilized or stable to heat

Regional Availability

North America, Europe, Asia Pacific