KEPAMID® 2340M8

PA66-MX40 — Korea Engineering Plastics Co. Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	**0.8**	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Strength	**95**	MPa	ISO 527
Strain at break	**4**	%	ISO 527
Flexural modulus, 23°C	**8520**	MPa	ISO 178
Charpy notched impact strength, +23°C	**4.5**	kJ/m²	ISO 179/1eA
Rockwell hardness	**R119**	-	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	**225**	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	**250**	°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	**3.4**	-	IEC 62631-2-1

Other properties	Value	Unit	Test Standard
Humidity absorption	**0.6**	%	Sim. to ISO 62
Density	**1510**	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	**280**	°C	-
Zone 2	**285**	°C	-
Zone 3	**285**	°C	-
Nozzle temperature	**290**	°C	-
Screw speed	**80 - 120**	rpm	-
Back pressure	**0.5 - 1**	MPa	-

Characteristics

Processing
Injection Molding

Special Characteristics
Heat stabilized or stable to heat

Features
Low Warpage

Applications
Automotive, Electrical and Electronical

Regional Availability
North America, Europe, Asia Pacific