

Reny 4011

PAMXD6-GF40

Mitsubishi Engineering-Plastics Corporation

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	4.5 / *	cm ³ /10min	ISO 1133
Temperature	275 / *	°C	-
Load	2.16 / *	kg	-
Melt flow index, MFI	6.3	g/10min	ISO 1133
Temperature	275	°C	-
Load	2.16	kg	-
Molding shrinkage, parallel	0.3 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6 / *	%	ISO 294-4, 2577

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	21600 / 18600	MPa	ISO 527
Stress at break	152 / 143	MPa	ISO 527
Strain at break	1 / 1.1	%	ISO 527
Flexural modulus, 23°C	19800 / 19100	MPa	ISO 178
Flexural strength	235 / 228	MPa	ISO 178
Charpy impact strength, +23°C	16 / 16	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	7.3 / 7.5	kJ/m ²	ISO 179/1eA

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	226 / *	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	235 / *	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	10 / *	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	40 / *	E-6/K	ISO 11359-1/-2
Burning behav. at 1.5 mm nom. thickn.	HB / *	class	IEC 60695-11-10
Thickness tested	1.6 / *	mm	-
Yellow Card available	yes / *	-	-

Electrical properties	dry / cond	Unit	Test Standard
ISO Data			
Volume resistivity	300 / 6E8	Ohm*m	IEC 62631-3-1
Surface resistivity	* / 3E6	Ohm	IEC 62631-3-2

Other properties	dry / cond	Unit	Test Standard
Humidity absorption	0.9 / *	%	Sim. to ISO 62
Density	1660 / -	kg/m ³	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

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Special Characteristics

Increased electrical conductivity

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