

Reny 1022HS

PAMXD6-GF50

Mitsubishi Engineering-Plastics Corporation

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	3.31 / *	cm ³ /10min	ISO 1133
Temperature	275 / *	°C	-
Load	2.16 / *	kg	-
Melt flow index, MFI	5.5	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	21900 / 21000	MPa	ISO 527
Stress at break	236 / 233	MPa	ISO 527
Strain at break	1.5 / 1.6	%	ISO 527
Flexural modulus, 23°C	19100 / 19000	MPa	ISO 178
Flexural strength	384 / 326	MPa	ISO 178
Charpy impact strength, +23°C	61 / 40	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	12 / 12	kJ/m ²	ISO 179/1eA

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	245 / *	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	12 / *	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	43 / *	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			
Relative permittivity, 1MHz	4.65 / -	-	IEC 62631-2-1
Dissipation factor, 1MHz	91 / -	E-4	IEC 62631-2-1
Volume resistivity	1.1E14 / -	Ohm*m	IEC 62631-3-1
Electric strength	33 / -	kV/mm	IEC 60243-1

Other properties	dry / cond	Unit	Test Standard
Humidity absorption	0.87 / *	%	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	270	°C	-
Zone 2	275	°C	-
Zone 3	280	°C	-
Nozzle temperature	280	°C	-
Screw speed	60 - 150	rpm	-
Injection pressure	20 - 150	MPa	-

Characteristics**Processing**

Injection Molding

Regional Availability

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

Applications

Automotive, Electrical and Electronical, General Purpose