

Reny 1027HU

PAMXD6-GF50

Mitsubishi Engineering-Plastics Corporation

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	1.1 / *	cm ³ /10min	ISO 1133
Temperature	275 / *	°C	-
Load	2.16 / *	kg	-
Melt flow index, MFI	1.6	g/10min	ISO 1133
Temperature	275	°C	-
Load	2.16	kg	-
Molding shrinkage, parallel	0.3 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.9 / *	%	ISO 294-4, 2577

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	18700 / 17200	MPa	ISO 527
Stress at break	227 / 197	MPa	ISO 527
Strain at break	1.6 / 1.7	%	ISO 527
Flexural modulus, 23°C	18300 / 15900	MPa	ISO 178
Flexural strength	329 / 292	MPa	ISO 178
Charpy impact strength, +23°C	45 / 45	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	9 / 9.2	kJ/m ²	ISO 179/1eA

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	221 / *	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	233 / *	°C	ISO 75-1/-2

Other properties	dry / cond	Unit	Test Standard
Humidity absorption	0.8 / *	%	Sim. to ISO 62
Density	1630 / -	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

Special Characteristics

Light stabilized or stable to light, U.V. stabilized or stable to weather

Applications

Automotive, Electrical and Electronical, General Purpose

Regional Availability

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