

**Reny G-09S**

PAMXD6-GF50

Mitsubishi Engineering-Plastics Corporation

<b>Processing/Physical Characteristics</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Melt volume-flow rate, MVR	2.7 / *	cm <sup>3</sup> /10min	ISO 1133
Temperature	275 / *	°C	-
Load	2.16 / *	kg	-
Melt flow index, MFI	4.6	g/10min	ISO 1133
Temperature	275	°C	-
Load	2.16	kg	-
Molding shrinkage, parallel	0.3 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6 / *	%	ISO 294-4, 2577

<b>Mechanical properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Tensile Modulus	19700 / 19000	MPa	ISO 527
Stress at break	250 / 220	MPa	ISO 527
Strain at break	1.9 / 2.1	%	ISO 527
Flexural modulus, 23°C	18700 / -	MPa	ISO 178
Flexural strength	382 / -	MPa	ISO 178
Charpy impact strength, +23°C	61 / -	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	11 / -	kJ/m <sup>2</sup>	ISO 179/1eA

<b>Thermal properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	246 / *	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	255 / *	°C	ISO 75-1/-2
Burning behav. at 1.5 mm nom. thickn.	HB / *	class	IEC 60695-11-10
Thickness tested	1.6 / *	mm	-
Yellow Card available	yes / *	-	-

<b>Other properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
Humidity absorption	0.9 / *	%	Sim. to ISO 62
Density	1710 / -	kg/m <sup>3</sup>	ISO 1183

<b>Processing Recommendation Injection Molding</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
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

**Applications**

Automotive, Electrical and Electronical, General Purpose

**Regional Availability**

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