

General Information				
Product Description				
GF-reinforced; Toughness, Good				
General				
Filler / Reinforcement	• Glass Fiber, 50% Filler by Weight			
Features	• Good Toughness			
Uses	• Automotive Applications • Automotive Electronics		• Electrical/Electronic Applications • General Purpose	
ASTM & ISO Properties ¹				
Physical	Dry	Conditioned	Unit	Test Method
Density	1.67	--	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR)				ISO 1133
275°C/2.16 kg	7.7	--	g/10 min	
Melt Volume-Flow Rate (MVR)				ISO 1133
275°C/2.16 kg	4.7	--	cm³/10min	
Molding Shrinkage ²				Internal Method
Across Flow : 130°C, 2.00 mm	0.61	--	%	
Flow : 130°C, 2.00 mm	0.30	--	%	
Water Absorption				Internal Method
24 hr, 23°C	0.14	--	%	
Equilibrium, 23°C, 50% RH	1.0	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	19600	18300	MPa	ISO 527-1/1
Tensile Stress (Break)	275	229	MPa	ISO 527-2/5
Tensile Strain (Break)	1.9	2.0	%	ISO 527-2/5
Flexural Modulus ³	18800	17600	MPa	ISO 178
Flexural Stress ³	436	385	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179
23°C	14	13	kJ/m²	
Charpy Unnotched Impact Strength				ISO 179
23°C	77	82	kJ/m²	
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				
0.45 MPa, Unannealed	238	233	°C	ISO 75-2/B
1.8 MPa, Unannealed	231	225	°C	ISO 75-2/A
CLTE				ISO 11359-2
Flow	1.0E-5	--	cm/cm/°C	
Transverse	4.0E-5	--	cm/cm/°C	

Reny™ 1025

Mitsubishi Engineering-Plastics Corp - Polyamide MXD6

Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (1.6 mm)	HB	--		UL 94

Additional Information				
Conditioned	Conditioned to 50% RH			

Processing Information				
Injection	Dry Unit			
Drying Temperature				
Hot Air Dryer, A	120 °C			
Hot Air Dryer, B	80 °C			
Drying Time				
Hot Air Dryer, A	> 3.0 hr			
Hot Air Dryer, B	> 12 hr			
Rear Temperature	265 °C			
Middle Temperature	270 °C			
Front Temperature	275 °C			
Nozzle Temperature	275 °C			
Mold Temperature	120 to 140 °C			
Injection Pressure	20.0 to 150 MPa			
Injection Rate	Moderate-Fast			
Screw Speed	60 to 150 rpm			

Notes

¹ Typical properties: these are not to be construed as specifications.

² 100-mm square

³ 2.0 mm/min

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