

Reny™ 1027HU

Mitsubishi Engineering-Plastics Corp - Polyamide MXD6

General Information

Product Description

GF-reinforced; Weather Resistant; HB equivalent per in-house testing

General

Filler / Reinforcement	• Glass Fiber, 50% Filler by Weight	
Features	• Good Weather Resistance	• Light Stabilized
Uses	• Automotive Applications	• Electrical/Electronic Applications
	• Automotive Electronics	• General Purpose

ASTM & ISO Properties ¹

Physical	Dry	Conditioned	Unit	Test Method
Density	1.63	--	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)				ISO 1133
275°C/2.16 kg	1.6	--	g/10 min	
Melt Volume-Flow Rate (MVR)				ISO 1133
275°C/2.16 kg	1.1	--	cm ³ /10min	
Molding Shrinkage ²				Internal Method
Across Flow : 130°C, 2.00 mm	0.60	--	%	
Flow : 130°C, 2.00 mm	0.30	--	%	
Water Absorption				Internal Method
24 hr, 23°C	0.14	--	%	
Equilibrium, 23°C, 50% RH	0.80	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	18700	17200	MPa	ISO 527-1/1
Tensile Stress (Break)	227	197	MPa	ISO 527-2/5
Tensile Strain (Break)	1.6	1.7	%	ISO 527-2/5
Flexural Modulus ³	18300	15900	MPa	ISO 178
Flexural Stress ³	329	292	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179
23°C	9.0	9.2	kJ/m ²	
Charpy Unnotched Impact Strength				ISO 179
23°C	45	45	kJ/m ²	
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				
0.45 MPa, Unannealed	233	231	°C	ISO 75-2/B
1.8 MPa, Unannealed	221	215	°C	ISO 75-2/A

Additional Information

Conditioned Conditioned to 50% RH

(+) 18816996168

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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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