

General Information				
Product Description				
GF-reinforced; Thick Parts; HB equivalent per in-house testing				
General				
Filler / Reinforcement	• Glass Fiber, 55% Filler by Weight			
Uses	• Automotive Applications • Automotive Electronics	• Electrical/Electronic Applications • General Purpose	• Thick-walled Parts	
ASTM & ISO Properties ¹				
Physical	Dry	Conditioned	Unit	Test Method
Density	1.70	--	g/cm³	ISO 1183
Molding Shrinkage ²				Internal Method
Across Flow : 130°C, 2.00 mm	0.55	--	%	
Flow : 130°C, 2.00 mm	0.29	--	%	
Water Absorption				Internal Method
24 hr, 23°C	0.10	--	%	
Equilibrium, 23°C, 50% RH	1.5	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	24900	23700	MPa	ISO 527-1/1
Tensile Stress (Break)	264	237	MPa	ISO 527-2/5
Tensile Strain (Break)	1.6	1.6	%	ISO 527-2/5
Flexural Modulus ³	20600	20900	MPa	ISO 178
Flexural Stress ³	423	384	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179
23°C	17	16	kJ/m²	
Charpy Unnotched Impact Strength				ISO 179
23°C	83	66	kJ/m²	
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				ISO 75-2/A
1.8 MPa, Unannealed	230	--	°C	
CLTE				ISO 11359-2
Flow	1.1E-5	--	cm/cm/°C	
Transverse	2.5E-5	--	cm/cm/°C	
Additional Information				
Conditioned	Conditioned to 50% RH			

Reny™ 1071

Mitsubishi Engineering-Plastics Corp - Polyamide MXD6

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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