

General Information

Product Description

GF-reinforced; Rigidity, High; Impact Resistance, High

General

Filler / Reinforcement	• Glass Fiber, 55% Filler by Weight	
Features	• High Impact Resistance	• High Rigidity
Uses	• Automotive Applications	• Electrical/Electronic Applications
	• Automotive Electronics	• General Purpose

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.66	g/cm ³	ISO 1183
Molding Shrinkage ²			Internal Method
Across Flow : 130°C, 2.00 mm	0.55	%	
Flow : 130°C, 2.00 mm	0.23	%	
Water Absorption			Internal Method
24 hr, 23°C	0.11	%	
Equilibrium, 23°C, 50% RH	0.90	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	20800	MPa	ISO 527-1/1
Tensile Stress (Break)	242	MPa	ISO 527-2/5
Tensile Strain (Break)	1.9	%	ISO 527-2/5
Flexural Modulus ³	19600	MPa	ISO 178
Flexural Stress ³	403	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	16	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength (23°C)	93	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed	236	°C	ISO 75-2/B
1.8 MPa, Unannealed	227	°C	ISO 75-2/A
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.6 mm)	HB		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Hot Air Dryer, A	120	°C
Hot Air Dryer, B	80	°C

Reny™ 1371

Mitsubishi Engineering-Plastics Corp - Polyamide MXD6

Injection	Nominal Value	Unit
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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