

General Information

Product Description

GF-reinforced; None-Halogen V-0

General

Filler / Reinforcement	• Glass Fiber, 50% Filler by Weight		
Features	• Bromine Free	• Flame Retardant	• Halogen Free
Uses	• Automotive Applications • Automotive Electronics	• Electrical/Electronic Applications • General Purpose	

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.71	g/cm ³	ISO 1183
Molding Shrinkage ²			Internal Method
Across Flow : 130°C, 2.00 mm	0.61	%	
Flow : 130°C, 2.00 mm	0.27	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	19000	MPa	ISO 527-1/1
Tensile Stress (Break)	220	MPa	ISO 527-2/5
Tensile Strain (Break)	1.6	%	ISO 527-2/5
Flexural Modulus ³	20000	MPa	ISO 178
Flexural Stress ³	360	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	12	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength (23°C)	61	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ISO 75-2/A
1.8 MPa, Unannealed	231	°C	
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index	325	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.6 mm, All color	V-1		
1.6 mm, Natural color, White, Black	V-0		

Processing Information

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

Reny™ 1527

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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