

General Information				
Product Description				
GF/Mineral-reinforced; V-0; Warpage, Low				
General				
Filler / Reinforcement	• Glass Fiber\Mineral, 15% Filler by Weight			
Features	• Flame Retardant		• Low Warpage	
Uses	• Automotive Applications • Automotive Electronics		• Electrical/Electronic Applications • General Purpose	
ASTM & ISO Properties ¹				
Physical	Dry	Conditioned	Unit	Test Method
Density	1.81	--	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR)				ISO 1133
275°C/2.16 kg	11	--	g/10 min	
Melt Volume-Flow Rate (MVR)				ISO 1133
275°C/2.16 kg	6.2	--	cm³/10min	
Molding Shrinkage ²				Internal Method
Across Flow : 130°C, 2.00 mm	0.45	--	%	
Flow : 130°C, 2.00 mm	0.27	--	%	
Water Absorption				Internal Method
24 hr, 23°C	0.13	--	%	
Equilibrium, 23°C, 50% RH	0.70	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	13900	13600	MPa	ISO 527-1/1
Tensile Stress (Break)	124	109	MPa	ISO 527-2/5
Tensile Strain (Break)	1.2	1.1	%	ISO 527-2/5
Flexural Modulus ³	13600	12900	MPa	ISO 178
Flexural Stress ³	200	176	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179
23°C	3.2	3.0	kJ/m²	
Charpy Unnotched Impact Strength				ISO 179
23°C	25	20	kJ/m²	
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				
0.45 MPa, Unannealed	236	231	°C	ISO 75-2/B
1.8 MPa, Unannealed	215	205	°C	ISO 75-2/A
Electrical	Dry	Conditioned	Unit	Test Method
Comparative Tracking Index	> 600	--	V	IEC 60112

Reny™ 2505

Mitsubishi Engineering-Plastics Corp - Polyamide MXD6

Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (1.6 mm)	V-0	--		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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