

General Information

Product Description

GF-reinforced; Warpage, Low; Rigidity, High

General

Filler / Reinforcement	• Glass Fiber, 65% Filler by Weight	
Features	• High Rigidity	• Low Warpage
Uses	• Automotive Applications • Automotive Electronics	• Electrical/Electronic Applications • General Purpose

ASTM & ISO Properties ¹

Physical	Dry	Conditioned	Unit	Test Method
Density	1.80	--	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)				ISO 1133
275°C/2.16 kg	7.6	--	g/10 min	
Melt Volume-Flow Rate (MVR)				ISO 1133
275°C/2.16 kg	6.9	--	cm ³ /10min	
Molding Shrinkage ²				Internal Method
Across Flow : 130°C, 2.00 mm	0.70	--	%	
Flow : 130°C, 2.00 mm	0.69	--	%	
Water Absorption				Internal Method
24 hr, 23°C	0.11	--	%	
Equilibrium, 23°C, 50% RH	0.70	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	9800	7300	MPa	ISO 527-1/1
Tensile Stress (Break)	73.0	52.0	MPa	ISO 527-2/5
Tensile Strain (Break)	1.7	1.8	%	ISO 527-2/5
Flexural Modulus ³	9600	6600	MPa	ISO 178
Flexural Stress ³	147	103	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179
23°C	2.2	2.4	kJ/m ²	
Charpy Unnotched Impact Strength				ISO 179
23°C	32	40	kJ/m ²	
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				
0.45 MPa, Unannealed	213	207	°C	ISO 75-2/B
1.8 MPa, Unannealed	147	116	°C	ISO 75-2/A
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (1.6 mm)	HB	--		UL 94

Reny™ 2686

Mitsubishi Engineering-Plastics Corp - Polyamide MXD6

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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