

General Information				
Product Description				
GF-reinforced; Electrically Conductive; V-0; Rigidity, High				
General				
Filler / Reinforcement	• Glass Fiber, 40% Filler by Weight			
Features	• Electrically Conductive	• Flame Retardant	• High Rigidity	
Uses	• Automotive Applications • Automotive Electronics	• Electrical/Electronic Applications • General Purpose		
ASTM & ISO Properties ¹				
Physical	Dry	Conditioned	Unit	Test Method
Density	1.77	--	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR)				ISO 1133
280°C/2.16 kg	1.8	--	g/10 min	
Melt Volume-Flow Rate (MVR)				ISO 1133
280°C/2.16 kg	1.0	--	cm³/10min	
Water Absorption				Internal Method
24 hr, 23°C	0.060	--	%	
Equilibrium, 23°C, 50% RH	0.70	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	20900	20600	MPa	ISO 527-1/1
Tensile Stress (Break)	130	125	MPa	ISO 527-2/5
Tensile Strain (Break)	0.60	0.80	%	ISO 527-2/5
Flexural Modulus ²	22200	22000	MPa	ISO 178
Flexural Stress ²	215	208	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179
23°C	6.9	8.9	kJ/m²	
Charpy Unnotched Impact Strength				ISO 179
23°C	12	12	kJ/m²	
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				
0.45 MPa, Unannealed	234	232	°C	ISO 75-2/B
1.8 MPa, Unannealed	223	218	°C	ISO 75-2/A
CLTE				ISO 11359-2
Flow	8.0E-6	--	cm/cm/°C	
Transverse	4.0E-5	--	cm/cm/°C	
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	5.0E+3	4.0E+4	ohms	IEC 60093
Volume Resistivity	3.0E+2	7.0E+8	ohms·cm	IEC 60093

Reny™ 4511

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 2.0 mm/min

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