

Kepamid® 1350GF

Polyamide 6

Korea Engineering Plastics Co., Ltd

Message:

KEPAMID 1350GF is a glass fiber 50%-reinforced PA6 grade.

It has strong mechanical properties and heat resistance.

It is suitable for automotive, electrical & electronics, and industrial parts requiring high stiffness and heat resistance.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 50% filler by weight		
Features	Rigidity, high		
	Heat resistance, high		
Uses	Electrical/Electronic Applications		
	Industrial components		
	Application in Automobile Field		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.57	g/cm ³	ISO 1183
shrinkage-Flow (3.00 mm)	0.20 - 0.30	%	Internal method
Water Absorption (Equilibrium, 23°C, 50% RH)	1.0	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	120		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress	210	MPa	ISO 527-2
Tensile Strain (Break)	2.0	%	ISO 527-2
Flexural Modulus	14000	MPa	ISO 178
Flexural Stress	300	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	15	kJ/m ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	220	°C	ISO 75-2/B
1.8 MPa, not annealed	210	°C	ISO 75-2/A
Melting Temperature ¹	220	°C	ISO 11357-3
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms · cm	IEC 60093

Relative Permittivity (1 MHz)	3.80		IEC 60250
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.8 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature			
--	90	°C	
Dry Air Dryer	80	°C	
Drying Time			
--	6.0 - 8.0	hr	
Dry Air Dryer	4.0 - 6.0	hr	
Suggested Max Moisture	0.050	%	
Hopper Temperature	60 - 80	°C	
Rear Temperature	250	°C	
Middle Temperature	250	°C	
Front Temperature	250	°C	
Nozzle Temperature	260	°C	
Mold Temperature	70 - 90	°C	
Back Pressure	0.490 - 0.981	MPa	
Screw Speed	80 - 120	rpm	
NOTE			
1.	10°C/min		

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