

Reny™ 1002H

Mitsubishi Engineering-Plastics Corp - Polyamide MXD6

General Information

Product Description

GF-reinforced; Surface Finish, Good; Standard grade

General

Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight	
Features	• General Purpose	• Good Surface Finish
Uses	• Automotive Applications • Automotive Electronics	• Electrical/Electronic Applications • General Purpose

ASTM & ISO Properties ¹

Physical	Dry	Conditioned	Unit	Test Method
Density	1.46	--	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)				ISO 1133
275°C/2.16 kg	41	--	g/10 min	
Melt Volume-Flow Rate (MVR)				ISO 1133
275°C/2.16 kg	31	--	cm ³ /10min	
Molding Shrinkage ²				Internal Method
Across Flow : 130°C, 2.00 mm	0.72	--	%	
Flow : 130°C, 2.00 mm	0.31	--	%	
Water Absorption				Internal Method
24 hr, 23°C	0.20	--	%	
Equilibrium, 23°C, 50% RH	1.5	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	12100	11100	MPa	ISO 527-1/1
Tensile Stress (Break)	181	148	MPa	ISO 527-2/5
Tensile Strain (Break)	1.7	1.8	%	ISO 527-2/5
Flexural Modulus ³	11600	10700	MPa	ISO 178
Flexural Stress ³	286	265	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179
23°C	6.3	6.2	kJ/m ²	
Charpy Unnotched Impact Strength				ISO 179
23°C	35	33	kJ/m ²	
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				
0.45 MPa, Unannealed	237	232	°C	ISO 75-2/B
1.8 MPa, Unannealed	224	212	°C	ISO 75-2/A
CLTE				ISO 11359-2
Flow	2.0E-5	--	cm/cm/°C	
Transverse	5.0E-5	--	cm/cm/°C	

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Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	7.0E+14	2.0E+14	ohms	IEC 60093
Volume Resistivity	1.0E+16	2.0E+15	ohms·cm	IEC 60093
Electric Strength				IEC 60243-1
1.00 mm	31	29	kV/mm	
2.00 mm	27	22	kV/mm	
Dielectric Constant				IEC 60250
1 MHz	--	4.00		
100 MHz	--	5.00		
Dissipation Factor				IEC 60250
1 MHz	--	0.016		
100 MHz	--	0.020		
Comparative Tracking Index	525	550	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (1.6 mm)	HB	--		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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