

PA6 | KEPAMID 1325GV2 | Flame retardant grade

- KEPAMID 1325GV2 is a glass fiber 25%-reinforced and flame retardant(UL V-2) PA6 grade.
- It has strong mechanical properties, heat resistance, and flame retardance.
- It is suitable for applications such as automotive, electrical & electronics, and industrial parts.

Physical properties	Test Standard	Unit	Value
Filler contents	ISO 1172	%	25
Specific gravity	ISO 1183	-	1.52
Water absorption(23 °C, 50 %RH)	ISO 62	%	1.1~1.5

Mechanical properties	Test Standard	Unit	Value
Tensile stress	ISO 527	MPa	155
Elongation at break	ISO 527	%	2.9
Tensile modulus	ISO 527	MPa	9600
Flexural strength	ISO 178	MPa	230
Flexural modulus	ISO 178	MPa	8750
Charpy impact strength(Notched) @ 23°C	ISO 179/1eA	kJ/m ²	7.5
Charpy impact strength(Notched) @ -30°C	ISO 179/1eA	kJ/m ²	6.0
Rockwell Hardness(R-Scale)	ISO 2039	-	120

Thermal properties	Test Standard	Unit	Value
Melting point(10 °C/min)	ISO 11357	°C	220
Heat deflection temperature(0.45 MPa)	ISO 75	°C	220
Heat deflection temperature(1.8 MPa)	ISO 75	°C	210
Flammability(t = 0.8 mm)	UL 94	Class	V-2

Electrical properties	Test Standard	Unit	Value
Permittivity(1 MHz)	IEC 60250	-	3.8
Volume resistivity	IEC 60093	Ω/ cm	10 ¹⁵

Revision No :

Injection molding condition



Pre-drying (Suggested max. moisture : 0.05 %)

It is recommend to dry material at 80°C(176°F) for 4 h ~ 6 h at dehumidified dryer.

It is recommend to dry material at 90°C(194°F) for 6 h ~ 8 h at dryer.

Temperature

Mold temperature : 70 °C ~ 90 °C(158 °F ~ 194 °F)

Barrel temperature : 250 °C ~ 260 °C(482 °F ~ 500 °F)

Mold	Bn(Nozzle)	B3(Metering)	B2(Compression)	B1(Feeding)	Hopper
70 ~ 90 °C	260 °C	250 °C	250 °C	250 °C	60 ~ 80 °C
158 ~ 194 °F	500 °F	482 °F	482 °F	482 °F	140 ~ 176 °F

Plastification

Screw speed : 80 ~ 120 rpm

Back pressure : 5 ~ 10 kgf/cm²

Disclaimer

Notice to users : The information contained in this data sheet is based on our current knowledge and experience, so it may change as new knowledge and experience becomes available. This information is based on only above-mentioned product produced in Korea Engineering Plastics Co., Ltd. ("KEP") through relevant test methods and conditions and doesn't relate to any products made of this product with the inclusion of other additives, such as processing aids or colorants. This information should not be construed as a promise or guarantee of specific properties of this product described or its suitability for a particular application, so users make their own determination as to its suitability to their purposes prior to use this product. It is the sole responsibility of the users to investigate whether any existing patents are infringed by the use of this product. This product is not intended for use in medical and dental implants and users should meet all safety and health standards. KEP makes no warranty and assumes no liability in connection with any use of this information.