PA66 | KEPAMID 2320GF | Glass fiber reinforced grade

- KEPAMID 2320GF is a glass fiber 20%-reinforced PA66 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.

Physical properties	Test Standard	Unit	Value
Filler contents	ISO 1172	%	20
Specific gravity	ISO 1183	-	1.27
Water absorption(23 ℃, 50 %RH)	ISO 62	%	0.9
Mold shrinkage(Flow direction, Φ = 100 mm, t = 3 mm)	KEP Method	%	0.6~1.0

Mechanical properties	Test Standard	Unit	Value
Tensile stress	ISO 527	MPa	147
Elongation at break	ISO 527	%	3
Flexural strength	ISO 178	MPa	230
Flexural modulus	ISO 178	MPa	6500
Charpy impact strength(Notched) @ 23℃	ISO 179/1eA	kJ/m^2	8
Rockwell Hardness(R-Scale)	ISO 2039	-	121

Thermal properties	Test Standard	Unit	Value
Melting point(10 ℃/min)	ISO 11357	℃	260
Heat deflection temperature(0.45 MPa)	ISO 75	℃	260
Heat deflection temperature(1.8 MPa)	ISO 75	℃	250
Flammability(t = 0.8 mm)	UL 94	Class	HB

Electrical properties	Test Standard	Unit	Value
Permittivity(1 MHz)	IEC 60250	-	3.7
Volume resistivity	IEC 60093	Ω/ cm	10^{15}

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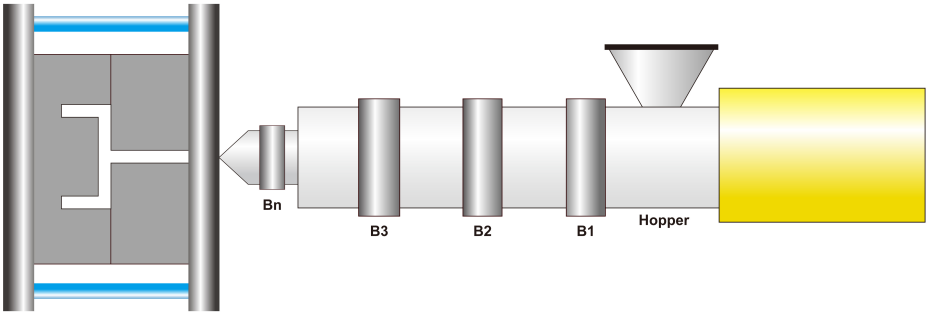
Injection molding condition



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

It is recommend to dry material at 80℃(176℉) for 4 h ~ 6 h at dehumidified dryer.
It is recommend to dry material at 90℃(194℉) for 6 h ~ 8 h at dryer.

Temperature

Mold temperature : 70 ℃ ~ 90 ℃(158 ℉ ~ 194 ℉)
Barrel temperature : 280 ℃ ~ 290 ℃(536 ℉ ~ 554 ℉)

Mold	Bn(Nozzle)	B3(Metering)	B2(Compression)	B1(Feeding)	Hopper
70 ~ 90 ℃	290 ℃	285 ℃	285 ℃	280 ℃	60 ~ 80 ℃
158 ~ 194 ℉	554 ℉	545 ℉	545 ℉	536 ℉	140 ~ 176 ℉

Plastification

Screw speed : 80 ~ 120 rpm
Back pressure : 5 ~ 10 kgf/cm^2

Disclaimer