

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 °C, 50 %RH)	ISO 62	%	0.9
Mold shrinkage(Flow direction, $\Phi = 100 \text{ mm}$, $t = 3 \text{ mm}$)	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°C	ISO 179/1eA	kJ/m ²	8
Rockwell Hardness(R-Scale)	ISO 2039	-	121

Thermal properties	Test Standard	Unit	Value
Melting point(10 °C/min)	ISO 11357	$^{\circ}\!\mathrm{C}$	260
Heat deflection temperature(0.45 MPa)	ISO 75	°C	260
Heat deflection temperature(1.8 MPa)	ISO 75	°C	250
Flammability(t = 0.8 mm)	UL 94	Class	НВ

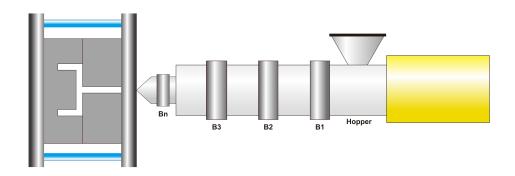
Electrical properties	Test Standard	Unit	Value
Permittivity(1 MHz)	IEC 60250	-	3.7
Volume resistivity	IEC 60093	Ω/ cm	10 ¹⁵

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Injection molding condition



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

It is recommend to dry material at $80^{\circ}\text{C}(176^{\circ}\text{F})$ for $4\text{ h} \sim 6\text{ h}$ at dehumidified dryer.

It is recommend to dry material at $90^{\circ}\text{C}(194^{\circ}\text{F})$ for 6 h ~ 8 h at dryer.

Temperature

Mold temperature : $70 \,^{\circ}\text{C} \sim 90 \,^{\circ}\text{C} (158 \,^{\circ}\text{F} \sim 194 \,^{\circ}\text{F})$ Barrel temperature : $280 \,^{\circ}\text{C} \sim 290 \,^{\circ}\text{C} (536 \,^{\circ}\text{F} \sim 554 \,^{\circ}\text{F})$

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

Plastification

Screw speed: 80 ~ 120 rpm Back pressure: 5 ~ 10 kgf/cm²

Disclaimer

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