

PPA | KEPAMID 6130GFH | Glass fiber reinforced grade

- KEPAMID-PPA 6130GFH is a glass fiber 30%-reinforced PPA grade.
- It is suitable for automotive, electrical & electronics, and consumer parts requiring excellent mechanical strength and heat resistance.

Physical properties	Test Standard	Unit	Value
Filler contents	ISO 1172	%	30
Specific gravity	ISO 1183	-	1.45
Water absorption(23 °C, 50 %RH)	ISO 62	%	0.5
Mold shrinkage(Flow direction, Φ = 100 mm, t = 3 mm)	ISO 294	%	0.3~0.7

Thermal properties	Test Standard	Unit	Value
Melting point(10 °C/min)	ISO 11357	°C	310
Coefficient of linear thermal expansion	ISO 11359	X 10 ⁻⁵ /°C	2.2~5.3
Heat deflection temperature(1.8 MPa)	ISO 75	°C	275
Flammability(t = 0.8 mm)	UL 94	Class	HB

Mechanical properties	Test Standard	Unit	Value
Elongation at break	ISO 527	%	2.2
Tensile stress	ISO 527	MPa	210
Flexural strength	ISO 178	MPa	300
Flexural modulus	ISO 178	MPa	10100
Charpy impact strength(Notched) @ 23°C	ISO 179/1eA	kJ/m ²	11

Electrical properties	Test Standard	Unit	Value
Permittivity(1 MHz)	IEC 60250	-	4.2
Dissipation factor(1MHz)	IEC 60250	-	0.002
Surface resistivity	IEC 60093	Ω	10 ¹⁶
Volume resistivity	IEC 60093	Ω/ cm	10 ¹⁵
Dielectric strength	IEC 60243	KV/mm	28

Revision No : 1 (2015-02-13)

Injection molding condition



Pre-drying (Suggested max. moisture : 0.1%)

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

It is recommend to dry material at 120°C(248°F) for 4 h at dehumidified dryer.

Temperature

Mold temperature : 130 °C ~ 150 °C(266 °F ~ 302 °F)

Barrel temperature : 310 °C ~ 340 °C(590 °F ~ 644 °F)

Mold	Bn(Nozzle)	B3(Metering)	B2(Compression)	B1(Feeding)	Hopper
130 ~ 150 °C	320 ~ 340 °C	315 ~ 340 °C	310 ~ 335 °C	310 ~ 330 °C	60 ~ 80 °C
266 ~ 302 °F	608 ~ 644 °F	599 ~ 644 °F	590 ~ 635 °F	590 ~ 626 °F	140 ~ 176 °F

Plastification

Screw speed :

Back pressure :

Disclaimer

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