PPA | KEPAMID 6150GFH | Glass fiber reinforced grade

- KEPAMID-PPA 6150GFH is a glass fiber 50%-reinforced PPA grade.

- It is suitable for automotive, electrical & electronics, and consumer parts requiring exellent mechanical strength and heat resistance.

Physical properties	Test Standard	Unit	Value
Filler contents	ISO 1172	%	50
Specific gravity	ISO 1183	-	1.65
Water absorption(23 ℃, 50 %RH)	ISO 62	%	0.3
Mold shrinkage(Flow direction, Φ = 100 mm, t = 3 mm)	ISO 294	%	0.2~0.6

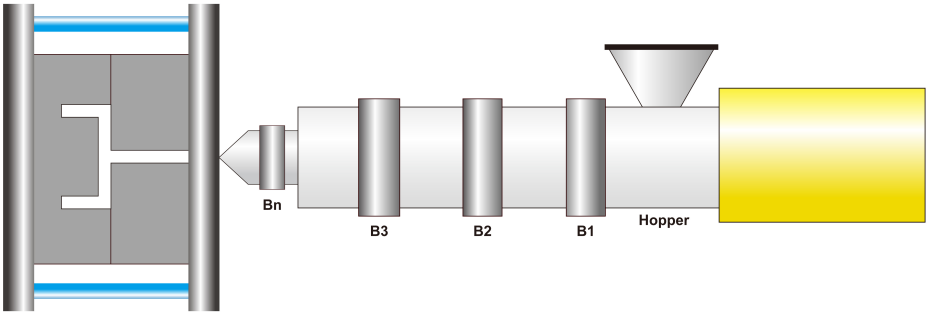
Thermal properties	Test Standard	Unit	Value
Melting point(10 ℃/min)	ISO 11357	℃	310
Coefficient of linear thermal expansion	ISO 11359	X 10^{-5}/℃	1.5~4.5
Heat deflection temperature(1.8 MPa)	ISO 75	℃	280
Flammability(t = 0.8 mm)	UL 94	Class	HB

Mechanical properties	Test Standard	Unit	Value
Elongation at break	ISO 527	%	2.2
Tensile stress	ISO 527	MPa	295
Flexural strength	ISO 178	MPa	420
Flexural modulus	ISO 178	MPa	16400
Charpy impact strength(Notched) @ 23℃	ISO 179/1eA	kJ/m^2	15

Electrical properties	Test Standard	Unit	Value
Permittivity(1 MHz)	IEC 60250	-	4.5
Dissipation factor(1MHz)	IEC 60250	-	0.001
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℃(194℉) for 8 h at dehumidified dryer.
It is recommend to dry material at 120℃(248℉) for 4 h at dehumidified dryer.

Temperature

Mold temperature : 130 ℃ ~ 150 ℃(266 ℉ ~ 302 ℉)
Barrel temperature : 310 ℃ ~ 340 ℃(590 ℉ ~ 644 ℉)

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

Plastification

Screw speed :
Back pressure :

Disclaimer