

PA.MXD6 | MAXIMID 7250GF | Glass fiber reinforced grade

- MAXIMID 7250GF is a glass fiber 50%-reinforced MXD6-PA/PA66 grade.

- It is suitable for automotive, electrical & electronics, and consumer parts.

Physical properties	Test Standard	Unit	Value
Filler contents	ISO 4351	%	50
Specific gravity	ISO 1183	-	1.64
Water absorption(23 °C, 50 %RH)	ISO 62	%	0.23
Mold shrinkage(Flow direction, $\Phi = 100$ mm, t = 3 mm)	KEP Method	%	0.4~0.5

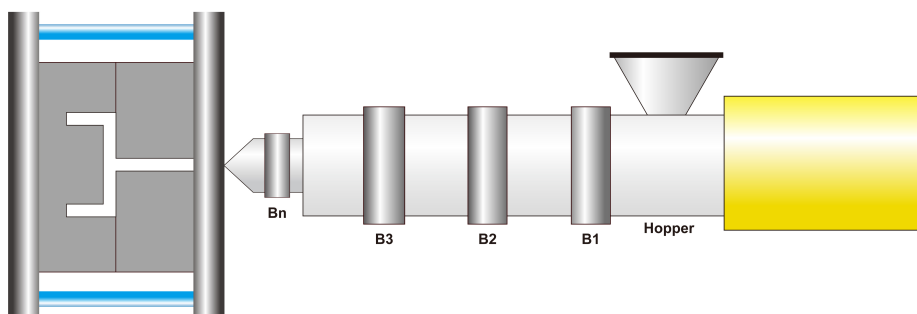
Mechanical properties	Test Standard	Unit	Value
Tensile stress	ISO 527	MPa	280
Elongation at break	ISO 527	%	2
Flexural strength	ISO 178	MPa	390
Flexural modulus	ISO 178	MPa	18500
Charpy impact strength(Notched) @ 23°C	ISO 179/1eA	kJ/m ²	11.5

Thermal properties	Test Standard	Unit	Value
Melting point	DSC	°C	238
Heat deflection temperature(1.8 MPa)	ISO 75	°C	227
Coefficient of linear thermal expansion	ISO 11359	X 10 ⁻⁵ /°C	-
Flammability(t = 0.8 mm)	UL 94	Class	HB

Electrical properties	Test Standard	Unit	Value
Dielectric strength	IEC 60243	KV/mm	-

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 : 120 °C ~ 140 °C(248 °F ~ 284 °F)

Barrel temperature : 250 °C ~ 280 °C(482 °F ~ 536 °F)

Mold	Bn(Nozzle)	B3(Metering)	B2(Compression)	B1(Feeding)	Hopper
120 ~ 140 °C	270 ~ 280 °C	265 ~ 275 °C	260 ~ 270 °C	250 ~ 260 °C	60 ~ 80 °C
248 ~ 284 °F	518 ~ 536 °F	509 ~ 527 °F	500 ~ 518 °F	482 ~ 500 °F	140 ~ 176 °F

Plastification

Screw speed :

Back pressure :

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.