PA.MXD6 | MAXIMID 7255GM8 | G/F reinforced and mineral filler filled grade

- MAXIMID 7255GM8 is a glass fiber/mineral filler 55%-reinforced/filled MXD6-PA/PA66 grade.

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

Physical properties	Test Standard	Unit	Value
Filler contents	ISO 4351	%	55
Specific gravity	ISO 1183	-	1.71
Water absorption(23 ℃, 50 %RH)	ISO 62	%	0.21
Mold shrinkage(Flow direction, Φ = 100 mm, t = 3 mm)	KEP Method	%	0.5~0.6

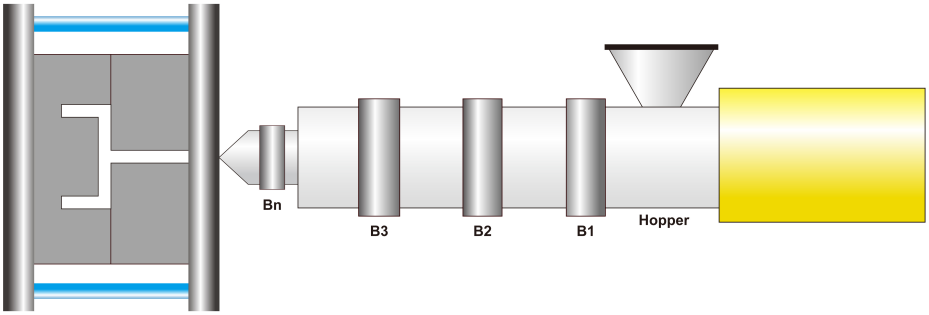
Mechanical properties	Test Standard	Unit	Value
Tensile stress	ISO 527	MPa	195
Elongation at break	ISO 527	%	1.4
Flexural strength	ISO 178	MPa	280
Flexural modulus	ISO 178	MPa	17800
Charpy impact strength(Notched) @ 23℃	ISO 179/1eA	kJ/m^2	5

Thermal properties	Test Standard	Unit	Value
Melting point	DSC	℃	238
Heat deflection temperature(1.8 MPa)	ISO 75	℃	224
Coefficient of linear thermal expansion	ISO 11359	$X\ 10^{-5}/℃$	-
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℃(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 : 120 ℃ ~ 140 ℃(248 ℉ ~ 284 ℉)
Barrel temperature : 250 ℃ ~ 280 ℃(482 ℉ ~ 536 ℉)

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

Plastification

Screw speed :
Back pressure :

Disclaimer