

KOPA[®] KN133G15

Injection Molding, PA6+GF15%, Medium viscosity

Application

General

Properties	Measurement condition	Test Method	Unit	Typical value
Physical				
Density		ASTM D792	—	1.24
Shrinkage		ASTM D955	%	0.4~1.0
Water Absorption	23℃, H ₂ O, 24hr	ASTM D570	%	1.5
Mechanical				
Tensile Strength at Break (3.2mm)	5 mm/min	ASTM D638	MPa	120
Elongation at Break (3.2mm)	5 mm/min	ASTM D638	%	—
Flexural Strength (3.2mm)	5 mm/min	ASTM D790	MPa	200
Flexural Modulus (3.2mm)	5 mm/min	ASTM D790	MPa	5100
Izod Impact Strength (6.4mm)		ASTM D256		
(Notched)	23 ℃		J/m	60
Rockwell Hardness	R scale	ASTM D785	—	120
Thermal				
Melting Point	20 ℃/min	ASTM D1525	℃	225
Heat Deflection Temperature	1.8 MPa	ASTM D648	℃	190
Flammability (0.8mm)		UL94	Class	HB

※ 1Mpa = 10.197162 Kg/cm², 1J/m = 0.10197 Kg · cm/cm, (Test specimen Thickness)

Processing Guide (Injection Molding)

Drying Temperature(℃)	80 ~ 90			
	(Dehumidifying Dryer)			
Drying Time(hr)	3~5			
Processing Moisture Contents(%)	≤ 0.1			
Cylinder Temperature(℃)	Nozzle	Front	Middle	Rear
	245~275	250	245	240
Mold Temperature(℃)	60~100			

