

KOPA[®] KN133G15HSBL

Injection Molding, PA6+GF15%, High-heat Resistance

Application

General/Engine Part

Properties	Measurement condition	Test Method	Unit	Typical value
Physical				
Density		ASTM D792	—	1.22
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	125
Elongation at Break (3.2mm)	5 mm/min	ASTM D638	%	—
Flexural Strength (3.2mm)	5 mm/min	ASTM D790	MPa	210
Flexural Modulus (3.2mm)	5 mm/min	ASTM D790	MPa	5500
Izod Impact Strength (6.4mm)		ASTM D256		
(Notched)	23 ℃		J/m	85
Rockwell Hardness	R scale	ASTM D785	—	120
Thermal				
Melting Point	20 ℃/min	ASTM D1525	℃	225
Heat Deflection Temperature	1.8 MPa	ASTM D648	℃	195
Flammability (0.8mm)		UL94	Class	HB

※ 1Mpa = 10.197162 Kgf/cm², 1J/m = 0.10197 Kgf · 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
	250	245	240	230
Mold Temperature(℃)	60~100			

