

KOPA[®] KN136

Injection Molding, PA6

Application

Automotive

Properties	Measurement condition	Test Method	Unit	Typical value
Physical				
Specific Gravity		ISO 1183	-	1.14
Shrinkage		ISO 294-4	%	0.9~1.5
Water Absorption	23°C, H ₂ O, 24hr	ISO 62	%	1.8
Mechanical				
Tensile Strength at Break (4.0mm)	50 mm/min	ISO 527	MPa	70
Elongation at Break (4.0mm)	50 mm/min	ISO 527	%	50
Flexural Strength (4.0mm)	2 mm/min	ISO 178	MPa	100
Flexural Modulus (4.0mm)	2 mm/min	ISO 178	MPa	2,400
Izod Impact strength (4.0mm)		ISO 180		
(Notched)	23 °C		kJ/m ²	5.5
Rockwell Hardness	R scale	ISO 2039-2	-	-
Thermal				
Melting Point	20 °C/min	ISO 11357-1	°C	220
Heat Deflection Temperature	1.8 MPa	ISO 75	°C	60
Flammability (0.8mm)		UL94	Class	HB

※ (Test specimen Thickness)



Processing Guide (Injection Molding)

Drying Temperature(°C)	80 ~ 90	(Dehumidifying Dryer)			
Drying Time(hr)	3~5				
Processing Moisture Contents(%)	≤ 0.1				
Cylinder Temperature(°C)	Nozzle	Front	Middle	Rear	
	240 ~ 260	240 ~ 260	230 ~ 250	220 ~ 240	
Mold Temperature(°C)	60~100				

