

KOPA® KN153HB40BL

Injection Molding, PA6+GF/MF40%, Dimensional Stabilization

Application

Roof Side Molding

Properties	Measurement condition	Test Method	Unit	Typical value
Physical				
Density		ASTM D792	—	1.44
Shrinkage		ASTM D955	%	0.3~0.9
Water Absorption	23℃, H ₂ O, 24hr	ASTM D570	%	0.9
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	180
Flexural Modulus (3.2mm)	5 mm/min	ASTM D790	MPa	7000
Izod Impact Strength (6.4mm)		ASTM D256		
(Notched)	23 ℃		J/m	55
Rockwell Hardness	R scale	ASTM D785	—	115
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 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
	260	255	250	240
Mold Temperature(℃)	60~100			

