

KOPA® KN133HRF

Injection Molding, PA6, Heat Resistance, High-fast Crystallization

Application

E&E(Cable)

Properties	Measurement condition	Test Method	Unit	Typical value
Physical				
Density		ASTM D792	-	1.13
Shrinkage		ASTM D955	%	0.9 ~ 1.5
Water Absorption	23℃, H ₂ O, 24hr	ASTM D570	%	1.8
Mechanical				
Tensile Strength at Break (3.2mm)	50 mm/min	ASTM D638	MPa	90
Elongation at Break (3.2mm)	50 mm/min	ASTM D638	%	20
Flexural Strength (3.2mm)	5 mm/min	ASTM D790	MPa	130
Flexural Modulus (3.2mm)	5 mm/min	ASTM D790	MPa	3200
Izod Impact Strength (6.4mm) (Notched)	23 ℃	ASTM D256	J/m	70
	-30 ℃		J/m	-
Rockwell Hardness	R scale	ASTM D785	-	115
Thermal				
Melting Point	20 ℃/min	ASTM D1525	℃	225
Heat Deflection Temperature	1.8 MPa	ASTM D648	℃	60
Coefficient of linear expansion		ASTM D696	× 10 ⁻⁴ cm/cm·℃	-
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
	240~260	240~260	230~250	220~240
Mold Temperature(℃)	60~100			

