

KOPA® KN3311F

Injection Molding , PA66, General Purpose

Application

Automotive(Clip)

Properties	Measurement condition	Test Method	Unit	Typical value
Physical				
Density		ASTM D792	-	1.14
Shrinkage		ASTM D955	%	1.1~1.7
Water Absorption	23℃, H ₂ O, 24hr	ASTM D570	%	1.30
Mechanical				
Tensile Strength at Break (3.2mm)	50 mm/min	ASTM D638	MPa	80
Elongation at Break (3.2mm)	50 mm/min	ASTM D638	%	40
Flexural Strength (3.2mm)	5 mm/min	ASTM D790	MPa	130
Flexural Modulus (3.2mm)	5 mm/min	ASTM D790	MPa	3000
Izod Impact Strength (6.4mm)		ASTM D256		
(Notched)	23 ℃		J/m	69
Rockwell Hardness	R scale	ASTM D785	-	120
Thermal				
Melting Point	20 ℃/min	ASTM D1525	℃	260
Heat Deflection Temperature	1.8 MPa	ASTM D648	℃	75
Flammability (0.8mm)		UL94	Class	V2

※ 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
	270~290	270~290	265~285	260~280
Mold Temperature(℃)	40~60			

