

KOPA® KN333H15

Injection Molding , PA66, High Impact

Application

Auto(Clip, Protector)

Properties	Measurement condition	Test Method	Unit	Typical value
Physical				
Density		ASTM D792	-	1.10
Shrinkage		ASTM D955	%	1.3~1.9
Water Absorption	23℃, H ₂ O, 24hr	ASTM D570	%	1.00
Mechanical				
Tensile Strength at Break (3.2mm)	50 mm/min	ASTM D638	MPa	60
Elongation at Break (3.2mm)	50 mm/min	ASTM D638	%	40
Flexural Strength (3.2mm)	5 mm/min	ASTM D790	MPa	100
Flexural Modulus (3.2mm)	5 mm/min	ASTM D790	MPa	2300
Izod Impact Strength (6.4mm)		ASTM D256		
(Notched)	23 ℃		J/m	600
Rockwell Hardness	R scale	ASTM D785	-	110
Thermal				
Melting Point	20 ℃/min	ASTM D1525	℃	260
Heat Deflection Temperature	1.8 MPa	ASTM D648	℃	70
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
	275~305	250	245	240
Mold Temperature(℃)	40~60			

