

KOPA[®] KN333MT30BL

Injection Molding , PA66+MF30% , Good Dimensional Stability

Application

Automotive(Cam Shafts)

Properties	Measurement condition	Test Method	Unit	Typical value
Physical				
Density		ASTM D792	-	1.34
Shrinkage		ASTM D955	%	0.5~0.9
Water Absorption	23℃, H ₂ O, 24hr	ASTM D570	%	0.90
Mechanical				
Tensile Strength at Break (3.2mm)	50 mm/min	ASTM D638	MPa	75
Elongation at Break (3.2mm)	50 mm/min	ASTM D638	%	-
Flexural Strength (3.2mm)	5 mm/min	ASTM D790	MPa	118
Flexural Modulus (3.2mm)	5 mm/min	ASTM D790	MPa	4100
Izod Impact Strength (6.4mm)		ASTM D256		
(Notched)	23 ℃		J/m	50
Rockwell Hardness	R scale	ASTM D785	-	120
Thermal				
Melting Point	20 ℃/min	ASTM D3418	℃	260
Heat Deflection Temperature	1.8 MPa	ASTM D648	℃	230
Coefficient of linear expansion		ASTM D696	× 10 ⁻⁴ cm/cm·℃	-
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
	285~315	285~315	275~305	265~295
Mold Temperature(℃)	60~100			

