

KOPA® KN333G30

Injection Molding , PA66+GF30%, General Purpose

Application

Automotive(Engine Covers)

Properties	Measurement condition	Test Method	Unit	Typical value
Physical				
Density		ASTM D792	–	1.36
Shrinkage		ASTM D955	%	0.3-0.9
Water Absorption	23°C , H ₂ O, 24hr	ASTM D570	%	1.0
Mechanical				
Tensile Strength at Break (3.2mm)	5 mm/min	ASTM D638	MPa	180
Elongation at Break (3.2mm)	5 mm/min	ASTM D638	%	–
Flexural Strength (3.2mm)	5 mm/min	ASTM D790	MPa	295
Flexural Modulus (3.2mm)	5 mm/min	ASTM D790	MPa	8.900
Izod Impact Strength (6.4mm)		ASTM D256		
(Notched)	23 °C		J/m	100
Rockwell Hardness	R scale	ASTM D785	–	120
Thermal				
Melting Point	20 °C/min	ASTM D1525	°C	260
Heat Deflection Temperature	1.8 MPa	ASTM D648	°C	245
Flammability (0.8mm)		UL94	Class	HB

※ 1MPa = 10.197162 Kg/cm², 1J/m = 0.10197 Kg · cm/cm, (Test specimen Thickness)

updated : 01 / Oct / 2019

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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	290	285	270
Mold Temperature(℃)	60~100			

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