

KOPA®

KN3311

Injection Molding, PA66

Application

Automotive(Clip)

Properties	Measurement condition	Test Method	Unit	Typical value
Physical				
Specific gravity		ASTM D792	-	1.14
Water absorption	23℃, H ₂ O, 24hr	ASTM D570	%	1.3
Shrinkage	Parallel	ASTM D955	%	1.3 ~ 1.5
	Normal			1.3 ~ 1.5
Mechanical				
Tensile strength	50 mm/min	ASTM D638	MPa	80
Elongation at Break	50 mm/min	ASTM D790	%	40
Tensile modulus	50 mm/min	ASTM D790	MPa	
Flexural strength	5 mm/min	ASTM D790	MPa	130
Flexural modulus	5 mm/min	ASTM D790	MPa	3,000
Izod impact strength (Notched)	23℃	ASTM D256	J/m	65
	-30℃			
Rockwell hardness	R scale	ASTM D785	-	120
Thermal				
Melting point		ASTM D1525	℃	260
Heat deflection temperature	1.8 MPa	ASTM D648	℃	75
	0.45Mpa			
Coefficient of linear expansion		ASTM D696	× 10 ⁻⁴ cm/cm·℃	
Electrical and flammability				
Flammability	0.8mm	UL94	Class	

The values of each item in this document provide general information about the product and may be different from actual ones as reference dimensions for customer's convenience of material selection. This information cannot be viewed as a Certificate of Analysis(COA) issued by the Company to customers, nor can it be used as a basis for legal disputes such as lawsuits. The value of each item cannot be compared with the measurement result of other environment, equipment and method because it is measured under the specific condition using the existing measurement equipment and external authorized agency equipment. The characteristics described above are subject to change, and you are solely responsible for the determination and use of this product. In addition, these materials do not apply when adding pigments and other additives to the product depending on the customer's purpose of use. The value of the shrinkage factor in the above data is the value measured under the specific injection condition using our standard test piece and may be changed according to other test piece (product) and condition. Therefore, it is the customer's responsibility to apply the correction by considering the required characteristics of the molded product, the mold design condition, the product shape, the injection conditions, etc. Even if there is a difference in the shrinkage rate of the product in the mold manufactured by applying this shrinkage ratio, we also assume no guarantee or liability.

Processing Guide (Injection Molding)

Drying Temperature(℃)	80 ~ 90	(Dehumidifying Dryer)		
Drying Time(hr)	3 ~ 5			
Processing Moisture Contents(%)	≤ 0.1			
Cylinder Temperature(℃)	Nozzle 270 ~ 290	Front 270 ~ 290	Middle 270 ~ 285	Rear 260 ~ 275
Mold Temperature(℃)	50~90			

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