

Reny® 4511

Polyarylamide

Mitsubishi Engineering-Plastics Corp

Message:

Reny® 4511 is a Polyarylamide (PARA) material filled with 40% glass fiber. It is available in Asia Pacific, Europe, or North America for injection molding. Important attributes of Reny® 4511 are:

Flame Rated

Flame Retardant

Conductive

General Information				
UL YellowCard		E41179-231773		
Filler / Reinforcement		Glass Fiber,40% Filler by Weight		
Additive		Flame Retardant		
Features		Electrically Conductive		
		Flame Retardant		
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.77	--	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (280°C/3.8 kg)	1.8	--	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (280°C/3.8 kg)	1.00	--	cm ³ /10min	ISO 1133
Molding Shrinkage	0.35	--	%	
Water Absorption				ISO 62
Saturation, 23°C	0.060	--	%	
Equilibrium, 23°C, 50% RH	0.70	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	20900	20600	MPa	ISO 527-2
Tensile Stress (Break)	130	125	MPa	ISO 527-2
Tensile Strain (Break)	0.60	0.80	%	ISO 527-2
Flexural Modulus	22200	22000	MPa	ISO 178
Flexural Stress	215	208	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	6.9	8.9	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength (23°C)	12	12	kJ/m ²	ISO 179
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				

0.45 MPa, Unannealed	234	232	°C	ISO 75-2/B
1.8 MPa, Unannealed	223	218	°C	ISO 75-2/A
CLTE				ISO 11359-2
Flow	8.0E-6	--	cm/cm/°C	
Transverse	4.0E-5	--	cm/cm/°C	
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	5.0E+3	4.0E+4	ohms	IEC 60093
Volume Resistivity	3.0E+2	7.0E+8	ohms·cm	IEC 60093
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (1.60 mm)	V-0	--		UL 94
Injection	Dry	Unit		
Drying Temperature				
A	120		°C	
B	80.0		°C	
Drying Time				
A	> 3.0		hr	
B	> 12		hr	
Rear Temperature	260		°C	
Middle Temperature	265		°C	
Front Temperature	270		°C	
Nozzle Temperature	270		°C	
Mold Temperature	120 to 140		°C	
Injection Pressure	20.0 to 150		MPa	
Injection Rate	Moderate-Fast			
Screw Speed	60 to 150		rpm	

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