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KAPHI350**PA6+ABS Alloy**

General Information

● **Characteristic:** Injection grade, Super Toughness, Good Surface Property, Matt Surface Effect

Physical Property

| Property | Test method | Test condition | Unit | Nominal Values |
|----------------------------|-------------|--------------------|--------------------|--------------------|
| Mechanical Property | | | | |
| Notched Izod impact | ASTM D256 | 23°C, 3.2mm | KJ/m ² | 45 |
| Rock well hardness | ASTM D-785 | R-Scal | R-Scal | 105 |
| Tensile Strength at yield | ASTM D638 | 23°C, 50 mm/min | Mpa | 53 |
| Elongation at break | | | % | >100 |
| Flexural modulus | ASTM D790 | 23°C 10mm/min | Mpa | 1700 |
| Flexural strength | | | Mpa | 74 |
| Flammability | | | | |
| Flammability | UL94 | ¼ inch (3.2 mm) | HB(<76mm/min) | HB |
| Thermal Property | | | | |
| HDT(Heat Deflection Temp) | ASTM D648 | unannealed 0.46MPa | °C | 130 |
| HDT(Heat Deflection Temp) | ASTM D648 | unannealed 1.8MPa | °C | 55 |
| Polymer property | | | | |
| Melting Point | DSC Method | | °C | 220 |
| Density | ASTMD792 | 23°C | g/cm ³ | 1.04 |
| Mold shrinkage | ASTM D955 | 100*100*3.2 mm | % | 1.8~2.4 |
| Water Absorption | ASTM D570 | 23°C, water, 24h | % | 1.2 |
| Electrical | | | | |
| Dielectric Strength | ASTM D149 | | Kv/mm | 20 |
| Volume Resistivity | ASTM D257 | | Ω.cm | 3*10 ¹⁵ |
| Dielectric Constant | ASTM D150 | | 10 ⁶ HZ | 3 |

1-typical values are not our specification and not be used for part or tool design.

2-all properties ,except Melt Flow Index are measured on injection molded specimens and after 48 hour storage at 23°C and in RH of 50%..

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KAPHI350 PA6+ABS Alloy**Processing guid (Injection molding condition)**

| Processing parameters | unit | value |
|-----------------------|--------------------|------------|
| Drying Temperature | °C | 60~80 |
| Drying Time | hrs | 2~4 |
| Moisture content | % | <0.1 |
| Melt Temperature | °C | 220 |
| Cylinder Temperature | Reare | °C 220~230 |
| | Middle | °C 220~230 |
| | Front | °C 220~230 |
| Nozzel Temperature | °C | 230~240 |
| Mold Temperature | °C | 70~90 |
| Injection Pressure | kg/cm ² | 60~150 |
| Screw Speed | rpm | 30~60 |

Note):Some modifications may be required depending on the specific molding equipment and part configuration.

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