



Kimia Baspar Golpa

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/m2	45
Rock well hardness	ASTM D-785	R-Scal	R-Scal	95
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	75
Flammability				
Flammability	UL94	½ inch (3.2 mm)	HB(<76mm/min)	HB
Thermal Property				
HDT(Heat Deflection Temp)	ASTM D648	unannealed0.46MPa	°C	145
HDT(Heat Deflection Temp)	ASTM D648	unannealed1.8MPa	°C	75
Polymer property				
Melting Point	DSC Method		°C	220
Density	ASTMD792	23°c	g/cm3	1.06
Mold shrinkage	ASTM D955	100*100*3.2 mm	%	1.0~1.4
Water Absorption	ASTM D570	23°c,water,24h	%	1.0
Electrical				
Dielectric Strength	ASTM D149		Kv/mm	20
Volume Resistivity	ASTM D257		Ω.cm	
Dielectric Constant	ASTM D150		10°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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Processing guid (Injection molding condition)
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Processing parameters	unit	value
Drying Temprature	°C	60~80
Drying Time	hrs	2~4
Moisture content	%	<0.1
Melt Temprature	°C	220
Cylinder Tempratre	Reare	°C 220~230
	Middle	°C 220~230
	Front	°C 220~230
Nozzel Temprature	°C	230~240
Mold Temprature	°C	70~90
Injection Pressure	kg/cm2	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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