

KELON A H CEG/40

Polyamide 66 (PA66) based compound.

Heat stabilised. Glass fibres / Mineral filler.

PHYSICAL PROPERTIES	STANDARD	VALUE MEASURE UNITS
Density	ISO 1183	1.49 g/cm ³
Linear shrinkage at moulding		
Longitudinal (2.0mm/60MPa)	ISO 294-4	0.80 ÷ 1.10 %
Transversal (2.0mm/60MPa)	ISO 294-4	1.00 ÷ 1.30 %
Dimensional stability	---	63
Moisture absorption (in air)		
after 24hrs	ISO 62-4	0.26 %
MECHANICAL PROPERTIES	STANDARD	VALUE MEASURE UNITS
CHARPY impact strength		
Unnotched, at +23°C	ISO 179-1eU	25.0 kJ/m ²
Notched, at +23°C	ISO 179-1eA	3.5 kJ/m ²
Tensile elongation		
At break (5 mm/min), 23°C	ISO 527 (1)	2.9 %
At break (5 mm/min), 60°C	ISO 527 (1)	3.5 %
At break (5 mm/min), 90°C	ISO 527 (1)	6.5 %
At break (5 mm/min), 120°C	ISO 527 (1)	8.0 %
At break (5 mm/min), 150°C	ISO 527 (1)	12.0 %
Tensile strength		
At break (5 mm/min), 23°C	ISO 527 (1)	90 MPa
At break (5 mm/min), 60°C	ISO 527 (1)	70 MPa
At break (5 mm/min), 90°C	ISO 527 (1)	45 MPa
At break (5 mm/min), 120°C	ISO 527 (1)	35 MPa
At break (5 mm/min), 150°C	ISO 527 (1)	25 MPa
Elastic modulus		
Tensile (speed 1 mm/min), at 23°C	ISO 527 (1)	6600 MPa
Tensile (speed 1 mm/min), at 60°C	ISO 527 (1)	5000 MPa
Tensile (speed 1 mm/min), at 90°C	ISO 527 (1)	4100 MPa
Tensile (speed 1 mm/min), at 120°C	ISO 527 (1)	3700 MPa
Tensile (speed 1 mm/min), at 150°C	ISO 527 (1)	2600 MPa

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THERMAL PROPERTIES	STANDARD	VALUE MEASURE UNITS
Coefficient of linear thermal expansion (CLTE)		
+30°C to +100°C (longitudinal)	ISO 11359-2	20 µm/(m·°C)
VICAT - Softening point		
49 N (heating rate 50°C/h)	ISO 306	230 °C
HDT - Heat Deflection Temperature		
0.45 MN/m ²	ISO 75	240 °C
1.81 MN/m ²	ISO 75	180 °C
C.U.T. - Continuous Use Temperature		
Long period (20,000h)	---	125 °C

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MATERIAL - STORAGE

Sealed, undamaged packages has to be kept in dry storage facilities, providing they are also able to protect them from weather and accidental damage.

HANDLING AND SAFETY

Detailed information about a safe treatment of the material are indicated in the "Material Safety Data Sheet" (MSDS) furnished with the first material supply. The MSDS may be also sent again in case of loss.

PREDRYING CONDITIONS

At least 3 hours at $90 \div 100^{\circ}\text{C}$

These are the suggested conditions to reduce the moisture content to adequate levels. Temperature and drying time can be reduced by using vacuum ovens. Particularly wet material may need a longer drying time.

ACTUAL MELT TEMPERATURE

$280 \div 310^{\circ}\text{C}$

The injection moulding machine settings needed to obtain the suggested melt temperature will depend greatly on shot size and machine capacity, as well as other moulding parameters such as: injection speed, screw RPM, back pressure, etc. On small machines, running short cycles, it is possible to use higher melt temperatures to improve plastification, fluidity and surface appearance, paying attention to any indication of material degradation.

MOULD TEMPERATURE

$80 \div 100^{\circ}\text{C}$

The mould temperature suggested above is the actual tool steel temperature. This can be significantly different from the tool settings, due to the cooling system efficiency and the accuracy of the temperature control on the tool.

INJECTION SPEED

Medium

The advisable injection speed greatly depends on cavity geometry and injection moulding machine size. The use of high injection speed can improve the surface appearance, but it can also cause outgassing and burn marks due to overheating through shear stress.

REGRIND USAGE

The use of regrind is possible, but should be assessed on the basis of the project, moulding parameters, and type of grinding used. The effect of using regrind on material properties must be evaluated by the customer on its specific project and process. High percentages of regrind may cause a reduction in viscosity and fibre length, reducing mechanical properties, first resilience.

HOT RUNNER MOULDS

Hot runner moulds may be used when a very tight temperature control is assured.

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TO AVOID

Shut-off nozzles and internally heated hot runners have to be avoided. In order to prevent any material degradation, over-dimensioned machines should be avoided.

EQUIPMENT WEAR

Usually, critical processing conditions (high injection rate, high back pressure and high screw rotating speed, etc.) and/or disadvantageous geometric conditions (low wall thickness, low diameters, sharp fillet radius, etc.) generate wear on equipment. Wear increases in case of filled materials (particularly fibre filled ones). Appropriate equipment surface treatments are suggested in these cases, as well as a proper venting to avoid material overheating.

NOTES

The products mentioned herein are not suitable for applications in contact with foodstuff or for potable water transportation, or for toy manufacturing. The products mentioned herein are not suitable for applications in the pharmaceutical, medical or dental sector.

CONTACTS

LATI Industria Termoplastici S.p.A.