

Kelon® A H CEG/40

Polyamide 66

LATI S.p.A.

Message:

Compound based on Polyamide 66 (PA 66).

Heat stabilised. Mineral filler / Glass fibres.

General Information			
Filler / Reinforcement	Glass\Mineral,40% Filler by Weight		
Additive	Heat Stabilizer		
Features	Heat Stabilized		
Physical	Nominal Value	Unit	Test Method
Density	1.49	g/cm ³	ISO 1183
Molding Shrinkage ¹			ISO 294-4
Across Flow : 2.00 mm	1.0 to 1.3	%	
Flow : 2.00 mm	0.80 to 1.1	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			ISO 527-2/1
23°C	6600	MPa	
60°C	5000	MPa	
90°C	4100	MPa	
120°C	3700	MPa	
150°C	2600	MPa	
Tensile Stress			ISO 527-2/5
Break, 23°C	90.0	MPa	
Break, 60°C	70.0	MPa	
Break, 90°C	45.0	MPa	
Break, 120°C	35.0	MPa	
Break, 150°C	25.0	MPa	
Tensile Strain			ISO 527-2/5
Break, 23°C	2.9	%	
Break, 60°C	3.5	%	
Break, 90°C	7.0	%	
Break, 120°C	8.0	%	
Break, 150°C	12	%	
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	3.5	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	25	kJ/m ²	ISO 179/1eU
Notched Izod Impact (23°C, 3.20 mm)	35	J/m	ASTM D256A
Thermal	Nominal Value	Unit	Test Method

Heat Deflection Temperature			
0.45 MPa, Unannealed	240	°C	ISO 75-2/B
1.8 MPa, Unannealed	180	°C	ISO 75-2/A
Continuous Use Temperature ²	125	°C	
Vicat Softening Temperature	230	°C	ISO 306/B50
CLTE - Flow (30 to 100°C)	2.0E-5	cm/cm/°C	ASTM D696
Injection	Nominal Value	Unit	
Drying Temperature	90.0 to 100	°C	
Drying Time	3.0	hr	
Processing (Melt) Temp	280 to 310	°C	
Mold Temperature	80.0 to 100	°C	
Injection Rate	Moderate		
NOTE			
1.	at 60 Mpa of cavity pressure		
2.	20,000 hr		

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