

Kelon® B FR H2 CE/25-V2HF

Polyamide 6

LATI S.p.A.

Message:

Compound based on Polyamide 6 (PA 6).

Heat stabilised. Mineral filler. UL94 V-2 classified, halogens and red phosphorous free. Product UL certified.

General Information			
UL YellowCard	E54080-517276		
Filler / Reinforcement	Mineral,25% Filler by Weight		
Additive	Heat Stabilizer		
Features	Halogen Free		
	Heat Stabilized		
	Low (to None) Phosphorus Content		

Physical	Nominal Value	Unit	Test Method
Density	1.33	g/cm ³	ISO 1183
Molding Shrinkage ¹			ISO 294-4
Across Flow : 2.00 mm	0.65 to 0.85	%	
Flow : 2.00 mm	0.55 to 0.75	%	

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			ISO 527-2/1
23°C	5200	MPa	
60°C	2200	MPa	
90°C	1300	MPa	
120°C	750	MPa	
150°C	500	MPa	
Tensile Stress			ISO 527-2/5
Break, 23°C	65.0	MPa	
Break, 60°C	45.0	MPa	
Break, 90°C	30.0	MPa	
Break, 120°C	20.0	MPa	
Break, 150°C	15.0	MPa	
Tensile Strain			ISO 527-2/5
Break, 23°C	2.5	%	
Break, 60°C	3.5	%	
Break, 90°C	7.0	%	
Break, 120°C	12	%	
Break, 150°C	20	%	

Impact	Nominal Value	Unit	Test Method
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Charpy Notched Impact Strength (23°C)	3.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	30	kJ/m ²	ISO 179/1eU
Notched Izod Impact (23°C, 3.20 mm)	30	J/m	ASTM D256A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	200	°C	ISO 75-2/B
1.8 MPa, Unannealed	120	°C	ISO 75-2/A
Continuous Use Temperature ²	80.0	°C	
Vicat Softening Temperature	205	°C	ISO 306/B50
CLTE - Flow (30 to 100°C)	3.5E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index ³ (Solution A)	550	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.750 mm	V-2		
1.50 mm	V-2		
3.00 mm	V-2		
Glow Wire Ignition Temperature			IEC 60695-2-13
1.00 mm	750	°C	
2.00 mm	750	°C	
Oxygen Index	27	%	ASTM D2863
Injection	Nominal Value	Unit	
Drying Temperature	90.0 to 100	°C	
Drying Time	3.0	hr	
Processing (Melt) Temp	240 to 260	°C	
Mold Temperature	70.0 to 100	°C	
Injection Rate	Moderate		
NOTE			
1.	at 60 Mpa of cavity pressure		
2.	20,000 hr		
3.	Without Surfactant		

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