

Technical Data sheet

Product: Kaycom PA6 102-H/GF30 LM Black 94220

Product description: Contains 75% recyclate, which comes from post-industrial sources. It is reinforced with 30% glass fiber and has increased heat stability. Improved laser marking for white markings. This grade exhibits medium impact resistance and strength. Recommended for injection moulding applications.

TYPICAL PROPERTIES ①	Standard	Unit	TYPICAL VALUE	
			Dry	
PHYSICAL:				
Density	ISO 1183	g/cm ³	1,36	
Moisture absorption (23°C /50% RH)	ISO 62	%	2,1	
Melt Volume Rate, MVR at 275 °C /5kg	ISO 1133	cm ³ /10 min	35	
Filler content		%	30	
MECHANICAL:				
Tensile Modulus (2 mm/min)	23°C ISO 527-2	MPa	8600	
Tensile Strength (5 mm/min)	23°C ISO 527-2	MPa	130	
Tensile Strain at Break (5 mm/min)	23°C ISO 527-2	%	4	
Flexural Modulus (2 mm/min)	23°C ISO 178/A	MPa	8200	
IMPACT:				
Charpy unnotched impact strength ²	23°C ISO 179/1eU	kJ/m ²	55	
Charpy notched impact strength ²	23°C ISO 179/1eA	kJ/m ²	10	
THERMAL:				
Vicat softening Temperature (B50)	ISO 306	°C	-	
Heat deflection temperature (1,8 MPa)	ISO 75	°C	-	
Flammability UL 94 (1,5 mm)	UL 94	class	HB	
ELECTRICAL:				
Volume Resistivity	IEC 60093	Ohm-cm	-	
Dielectric Strength in oil 0,8 mm	IEC 60243	KV/mm	-	
PROCESSING PARAMETERS/INJECTION MOULDING:				
Drying Temperature		°C	80	
Drying Time		Hrs	4-8	
Melt Temperature		°C	250-280	
Mould Temperature		°C	80-95	
GRANULAR MATERIAL CLASS:				
According to VW 50026	VW 50026:2020-10		GK1 (25%) GK3 (75%)	

① Typical values only. Variations within normal tolerances are possible for various colours. They are based on our general experience and given in good faith, but we are unable to accept responsibility in respect of factors which are outside our knowledge or control

² Please be informed that our Charpy values are measured with 4J hammer.

Kays Kft. Quality system is validated / certificated to ISO 9001:2015 by TÜV Rheinland InterCert Kft.

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