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KWPMI450

PA6+PP Alloy

General Information

● **Characteristic: Super Toughness, Good Surface Property, Good Elasticity**

Physical Property

Property	Test method	Test condition	Unit	Nominal Values
Mechanical Property				
Notched Izod impact	ASTM D256	23°C, 3.2mm	KJ/m ²	25
Rock well hardness	ASTM D-785	R-Scal	R-Scal	100
Tensile Strength at yield	ASTM D638	23°C, 50 mm/min	Mpa	46
Elongation at break			%	>200
Flexural modulus	ASTM D790	23°C 10mm/min	Mpa	1300
Flexural strength			Mpa	54
Flammability				
Flammability	UL94	¼ inch (3.2 mm)	HB(<76mm/min)	HB
Thermal Property				
HDT(Heat Deflection Temp)	ASTM D648	unannealed 0.46MPa	°C	120
HDT(Heat Deflection Temp)	ASTM D648	unannealed 1.8MPa	°C	50
Polymer property				
Melting Point	DSC Method	°C	220
Density	ASTMD792	23°C	g/cm ³	1.04
Mold shrinkage	ASTM D955	100*100*3.2 mm	%	1.8~2.4
Water Absorption	ASTM D570	23°C, water, 24h	%	1.2
Electrical				
Dielectric Strength	ASTM D149	Kv/mm	20
Volume Resistivity	ASTM D257	Ω.cm	3*10 ¹⁵
Dielectric Constant	ASTM D150	10 ⁶ 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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KWPMI450 PA6+PP Alloy**Processing guid (Injection molding condition)**

Processing parameters	unit	value
Drying Temperature	°C	60~80
Drying Time	hrs	2~4
Moisture content	%	<0.1
Melt Temperature	°C	220
Cylinder Temperature	Reare	°C 210~220
	Middle	°C 210~220
	Front	°C 210~220
Nozzel Temperature	°C	210~220
Mold Temperature	°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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