



# TECHNICAL DATA SHEET

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## Kimfill 4633

### Reinforced Polyamide 6 Compound

#### Product Description

Kimfill 4633 is a polyamide 6 injection-molding-grade reinforced with 30 % glass fiber. Because of its high strength and stiffness and toughness as well as excellent heat, chemical and abrasion resistance of this grade is often used for stressed parts. Additionally properties are very good process ability and good surface quality.

#### General

Material Status	• Commercial: Active
Availability	• Middle East, Europe, Asia
Additive	• 30% Filler by Weight(Glass Fiber), Heat Stabilizer
Features	• Good Surface Finish • High Heat Stability • Good Process Ability • Oil resistant
Uses	• Automotive • Electronic, Electrical Appliance • Household and Industrial Parts
Appearance & Form	• Natural, Pellet
Packaging	• 25 Kg Multi-Layer Bag
Processing Method	• Injection Molding

#### Nominal Value Unit

#### Test Method

#### Physical

Density	1.36±0.01 g/cm <sup>3</sup>	ISO 1183
Filler Content	30±2 %	ISO 3451-1

#### Mechanical

Tensile Modulus	8500 MPa	ISO 527
Tensile Strength (5mm/min)	≥ 170 MPa	ISO 527
Tensile Strain (Break)	5 %	ISO 527
Charpy Unnotched Impact Strength (23°C)	≥ 85 KJ/m <sup>2</sup>	ISO 179
Charpy notched Impact Strength (23°C)	≥ 13 KJ/m <sup>2</sup>	ISO 179

#### Processing Conditions

As a guide the following temperature profile and other condition is recommended

Zone 1	Zone 2	Zone 3	Zone 4	Die	Drying Time	Drying Temperature
220-230°C	230-240°C	240-260°C	250-265°C	260-270°C	2-4 hr.	90-100 °C

#### Shelf Life & Storage

Shelf life at proper storage is at least 18 months from production date, but in case of a long storage time, potential moisture pick-up needs to be eliminated by drying before injection. Sacks should be stored in dry/closed condition and protect from sunlight.

#### Note

This documentation is made out based on our tests and experiments in our R&D center with piled up experience and knowledge. And the values are measured on injection molded test specimens. It is suggested that this information contained in this document can be used for general indication. Therefore, you should not construe it as product specifications, and you should do appropriate test before you considering your conditions for newly applications.

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