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Kimia Javid Sepahan

Kimfill 4644

Polyamide Reinforced Compound

Product Description

Kimfill 4644 is a polyamide 6 reinforced compounds with chopped glass fiber. It has good properties such as surface hardness, tensile strength and abrasion resistance, dimension stability and exhibits superior heat resistance as well as high surface quality. Kimfill 4644 can be used to make electric/electronic appliance, automobile and mechanical industries etc.

General

Material Status	• Commercial: Active
Availability	• Middle East, Asia
Additive	• Glass Fiber Reinforcement, 40% Filler by Weight
Features	• Good Stiffness • High Heat Stability • Good Surface Finish • Good Process Ability
Uses	• Automotive • Electronic, Electrical Appliance • Household and Industrial Parts
Appearance	• Black
Forms	• Pellets
Packaging	• 25 Kg PE Bag
Processing Method	• Injection Molding

Physical	Nominal Value Unit	Test Method
Density	1.45 g/cm³	ISO 1183
Filler Content	40±2 %	ISO 3451-1

Mechanical	Nominal Value Unit	Test Method
Tensile Modulus	8000 MPa	ISO 527
Tensile Strength (5mm/min)	≥ 150 MPa	ISO 527
Tensile Strain (Break)	3.5-4%	ISO 527
Charpy Unnotched Impact Strength (23°C)	≥ 50 Kj/m^2	ISO 179

Injection

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

Zone 1	Zone 2	Zone 3	Zone 4	Die	Mold Temperature
220-230°C	230-240°C	240-260°C	250-260°C	250-265°C	50-80°C

Drying Temperature	Drying Time
80-100 °C	2-4 hr.

Storage

Sacks should be stored in dry/closed condition and protect from sunlight.

Shelf Life

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.