keyelco.com

Warehouse: 2040 Jericho Turnpike ~ *Corporate:* 55 S. Denton Avenue • New Hyde Park, NY 11040
(516) 328-7500 • (800) 221-5510 • Fax: (516) 328-1080

HIGH PREFORMANCE NYLON BLEND

General		
Agency Ratings	• ASTM D 4066 PA0161	• ASTM D 6779 PA0161
Appearance	• Black	
Forms	• Pellets	
Processing Method	• Injection Molding	

Physical	Dry	Conditioned	Unit	Test Method
Density	1.10	--	g/cm³	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow : 23°C, 2.00 mm	1.6	--	%	
Flow : 23°C, 2.00 mm	1.8	--	%	
Water Absorption (23°C, 24 hr)	1.2	--	%	ISO 62
Water Absorption (Equilibrium, 23°C, 50% RH)	2.3	--	%	ISO 62

Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	2780	1740	MPa	ISO 527-2
Tensile Stress (Yield, 23°C)	60.0	45.0	MPa	ISO 527-2
Tensile Stress (Break, 23°C)	52.0	40.0	MPa	ISO 527-2
Tensile Strain (Break, 23°C)	22	60	%	ISO 527-2
Flexural Modulus (23°C)	2300	780	MPa	ISO 178
Flexural Strength (23°C)	70.0	24.0	MPa	ISO 178

Electrical	Dry	Conditioned	Unit	Test Method
Volume Resistivity (0.750 mm)	1.0E+11	--	ohm·cm	IEC 60093
Dielectric Strength (1.00 mm)	12	--	kV/mm	IEC 60243
Arc Resistance	PLC 6	--		ASTM D495
Comparative Tracking Index (3.00 mm)	525	--	V	IEC 60112
High Amp Arc Ignition (HAI)				UL 746
0.750 mm	PLC 0	--		
1.50 mm	PLC 0	--		
3.00 mm	PLC 0	--		
High Voltage Arc Tracking Rate (HVTR)	PLC 2	--		UL 746
Hot-wire Ignition (HWI)				UL 746
0.750 mm	PLC 4	--		
1.50 mm	PLC 4	--		
3.00 mm	PLC 3	--		

Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating				UL 94
0.750 mm	HB	--		
1.50 mm	HB	--		
3.00 mm	HB	--		
Glow Wire Flammability Index				IEC 60695-2-12
0.750 mm	700	--	°C	
1.50 mm	775	--	°C	
3.00 mm	700	--	°C	
Glow Wire Ignition Temperature				IEC 60695-2-13
0.750 mm	725	--	°C	
1.50 mm	800	--	°C	
3.00 mm	725	--	°C	

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Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-40°C	11	18	kJ/m²	
-30°C	17	24	kJ/m²	
23°C	19	62	kJ/m²	
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	No Break	No Break		
23°C	No Break	No Break		
Notched Izod Impact Strength				ISO 180
-40°C	12	18	kJ/m²	
-30°C	16	24	kJ/m²	
23°C	18	44	kJ/m²	
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Heat Deflection Temperature				ISO 75-2/B
0.45 MPa, Unannealed	185	--	°C	
Heat Deflection Temperature				ISO 75-2/A
1.8 MPa, Unannealed	63.0	--	°C	
Melting Temperature	260	--	°C	ISO 11357-3
CLTE - Flow (23 to 55°C, 2.00 mm)	1.1E-4	--	cm/cm/°C	ISO 11359-2
CLTE - Transverse (23 to 55°C, 2.00 mm)	1.4E-4	--	cm/cm/°C	ISO 11359-2
RTI Elec				UL 746
0.750 mm	130	--	°C	
1.50 mm	130	--	°C	
3.00 mm	130	--	°C	
RTI Imp				UL 746
0.750 mm	75.0	--	°C	
1.50 mm	75.0	--	°C	
3.00 mm	75.0	--	°C	
RTI Str				UL 746
0.750 mm	115	--	°C	
1.50 mm	115	--	°C	
3.00 mm	115	--	°C	

Injection	Dry	Unit
Drying Temperature	80.0	°C
Drying Time	4.0	hr
Suggested Max Regrind	25	%
Rear Temperature	280 to 310	°C
Middle Temperature	280 to 310	°C
Front Temperature	280 to 310	°C
Nozzle Temperature	280 to 310	°C
Processing (Melt) Temp	285 to 305	°C
Mold Temperature	65.0 to 95.0	°C