

Technical data

KEBABLEND / WR 04/1310/2115

KEBABLEND WR 04/1310/2115 is a special compound based on PA66 that combines high strength and impact strength with good sliding properties and high wear resistance.

Polymer: PA 6.6

ISO designation: PA66-AF10-X15

Productgroup: Tribocompounds, Functionalized compounds

Brief description of the product family:

KEBABLEND is a wide range of functional compounds, often tailor-made to customer requirements. Under the trade name KEBABLEND, we market magnetizable, thermally or electrically conductive compounds, high-density injection molding materials, compounds for radiation protection applications, detectable plastics and much more.

Properties:

good chemical resistance, good gliding properties, good recovery behavior, High strength, High wear resistance, impact resistant, semi-crystalline

Typical areas of application:

Sliding elements, Plain bearing, industrial goods, Bearing bushes, Rollers, Rotors, Transport chains, Gears

Industries:

Automotive, Railroad industry, Household appliances, Industry, Agriculture, Mechanical Engineering, Furniture industry, Sports & Recreation

Physical properties

Density in kg/m ³ ISO 1183-1	1250.00
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Mechanical properties

E-modulus in MPa ISO 527-1	3200
Breaking stress in MPa ISO 527-1	70.0
Elongation at break in % ISO 527-1	9.0
Impact strength (Charpy) at 23°C in kJ/m ² ISO 179-1eU	45.0
Notched impact strength (Charpy) at 23°C in kJ/m ² ISO 179-1eA	4.0

Rheological properties

Melt flow rate MFR (test condition)	290°C / 2,16 kg
Melt flow rate MFR in g/10min ISO 1133	24.0
Shrinkage in flow direction in % ISO 294-4	1.50
Shrinkage transverse to the flow direction in % ISO 294-4	1.40

Thermal properties

Melting temperature (DSC, 10°C/min) in °C ISO 11357-1/-3	260.0
Heat deflection temperature HDT (1.80 MPa) in °C ISO 75-1/-2	140.0
Fire behavior (0.4 mm wall thickness) IEC 60695-11-10	HB
Fire behavior (0.8 mm wall thickness) IEC 60695-11-10	HB
Fire behavior (1.6 mm wall thickness) IEC 60695-11-10	HB
Fire behavior (3.2 mm wall thickness) IEC 60695-11-10	HB

Electrical properties

Contact resistance in Ohm*m IEC 60093	1e+16
Surface resistivity in ohms IEC 60093	1e+14

Processing instructions:**Pre-drying:**

Dryer type: dry air dryer

Drying temperature: 80°C

Typical drying time: 4 – 8 hours

Residual moisture content: < 0.1%

Recommended basic settings:

Melt temperature: 280 – 300°C

Mold temperature: 80 – 120°C

Injection speed: medium – high

Injection unit: The selected barrel capacity should not exceed 2-3 shots to avoid thermal material damage.

Screw: 3-zone screw with non-return valve

Nozzle: Open nozzle or shut-off nozzle

Legal notices:

The information in this data sheet is based on our current knowledge and experience. Due to the wide range of possible influences during processing and application of our products, they do not exempt the processor from carrying out his own tests and trials. A legally binding assurance of certain properties or suitability for a specific application cannot be derived from our information.

* FE products are development products which are still in the trial phase. Technical data may still change in the course of product and process development. No final decision has yet been made on the commercialization of FE products. We reserve the right to discontinue the manufacture of FE products without giving further reasons.

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