Kalix® 2930 HFFR

High Performance Polyamide

Solvay Specialty Polymers

Message:

Kalix® 2930 HFFR is a bio-sourced polyamide-based material specifically formulated to meet UL 94V2 @ 0.4 mm requirements for electronic devices. The material uses an advanced halogen-free flame retardant package expressly designed to minimize blooming, plate out, and other process related issues commonly associated with flame retardant materials.
Black: Kalix® 2930 HFFR BK 000

General Information	
Filler / Reinforcement	Glass fiber reinforced material
Features	Good dimensional stability Low warpage Rigidity, high High strength Impact resistance, good Electroplateable Sprayable Fast molding cycle High liquidity Hot water formability Excellent appearance Flame retardancy
Uses	Thin wall parts Electrical/Electronic Applications Electrical components Mobile phone
RoHS Compliance	Contact manufacturer
Appearance	Black
Forms	Particle
Processing Method	Water temperature mold injection molding Injection molding
Part Marking Code (ISO 11469)	>PA610-GF30

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.41		
Flexural Strain at Break	2.6	%	ISO 178
UL Rating - V2 @ 0.4 mm			
Molding Shrinkage [1]			Internal method

Vertical flow direction	0.70	%	Internal method
Flow direction	0.20	%	Internal method
Water Absorption (23°C, 24 hr)	0.17	%	ISO 62

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	10600	MPa	ISO 527-2
Tensile Stress	130	MPa	ISO 527-2
Tensile Strain (Break)	2.4	%	ISO 527-2
Flexural Modulus	10000	MPa	ISO 178
Flexural Stress	200	MPa	ISO 178

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	9.0	kJ/m^2	ISO 180/1A
Unnotched Izod Impact Strength	55	kJ/m^2	ISO 180

Thermal	Nominal Value	Unit	Test Method
Glass Transition Temperature	65.0	°C	DMA
Melting Temperature	223	°C	

Additional Information	Nominal Value

Typical values shown tested on Dry as Molded samples.
Standard Packaging and Labeling: Kalix® 2930 HFFR resin is packaged in foil lined, multiwall paper bags containing 25 kg (55 pounds) of material. Individual packages will be plainly marked with the product number, the color, the lot number, and the net weight.

Injection	Nominal Value	Unit
Drying Temperature	80.0	°C
Drying Time	4.0 - 12	hr
Suggested Max Moisture	< 0.090	%
Rear Temperature	265 - 275	°C
Front Temperature	280 - 295	°C
Processing (Melt) Temp	260 - 300	°C
Mold Temperature	80.0 - 120	°C

Injection instructions

Storage:
Kalix® compounds are shipped in moisture-resistant packages at moisture levels according to specifications. Sealed, undamaged bags should be preferably stored in a dry room at a maximum temperature of 50°C (122°F) and should be protected from possible damage. If only a portion of a package is used, the remaining material should be transferred into a sealable container. It is recommended that Kalix® resins be dried prior to molding following the recommendations found in this datasheet and/or in the Kalix® processing guide.
Drying:
Kalix® 2930 HFFR is supplied in sealed bags. It should be dried before molding because excessive moisture content will result in reduced mechanical properties and processing issues, such as excessive nozzle drooling, foaming and splay visible on the molded parts.
Polyamides oxidize in the presence of oxygen at high temperatures. Therefore drying temperatures above 80°C (176°F) should be avoided, particularly for light colors or color-controlled parts.
Injection Molding:
Set injection pressure to give rapid injection. Adjust holding pressure to one-half injection pressure. Set hold time to maximize part weight. Transfer from injection to hold pressure at the screw position just before the part is completely filled.

NOTE		
1.	Solvay Test Method. Shrink rates can vary with part design and processing conditions. Please consult a Solvay Technical Representative for more information.	

Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China