

Akulon® Ultraflow K-FHGM35

Polyamide 6
DSM Engineering Plastics

Message:

Akulon® Ultraflow K-FHGM35 is a Polyamide 6 (Nylon 6) material filled with 15% glass fiber and 25% mineral. It is available in North America. Important attributes of Akulon® Ultraflow K-FHGM35 are:
Heat Stabilizer
High Flow

General Information				
Filler / Reinforcement		Glass Fiber,15% Filler by Weight Mineral,25% Filler by Weight		
Additive		Heat Stabilizer		
Features		Heat Stabilized High Flow		
Forms		Pellets		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.50	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow	0.90	--	%	
Flow	0.30	--	%	
Water Absorption				ISO 62
Saturation, 23°C	5.5	--	%	
Equilibrium, 23°C, 50% RH	1.7	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	9000	6000	MPa	ISO 527-2
Tensile Stress (Break)	120	65.0	MPa	ISO 527-2
Tensile Strain (Break)	2.5	5.0	%	ISO 527-2
Flexural Modulus	7700	--	MPa	ISO 178
Flexural Stress	165	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	4.0	4.0	kJ/m ²	
23°C	5.0	6.0	kJ/m ²	
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	30	30	kJ/m ²	
23°C	35	45	kJ/m ²	

Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	215	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	205	--	°C	ISO 75-2/A
Melting Temperature ¹	220	--	°C	ISO 11357-3
CLTE				ISO 11359-2
Flow	3.5E-5	--	cm/cm/°C	
Transverse	5.0E-5	--	cm/cm/°C	
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	--	1.0E+13	ohms	IEC 60093
Volume Resistivity	1.0E+14	1.0E+12	ohms·cm	IEC 60093
Electric Strength	35	30	kV/mm	IEC 60243-1
Relative Permittivity				IEC 60250
100 Hz	3.50	14.0		
1 MHz	3.30	4.50		
Dissipation Factor				IEC 60250
100 Hz	5.0E-3	0.32		
1 MHz	0.014	0.12		
Injection	Dry	Unit		
Drying Temperature	80.0		°C	
Drying Time	4.0 to 8.0		hr	
Rear Temperature	230 to 250		°C	
Middle Temperature	230 to 260		°C	
Front Temperature	230 to 260		°C	
Nozzle Temperature	250 to 280		°C	
Processing (Melt) Temp	250 to 280		°C	
Mold Temperature	40.0 to 80.0		°C	
Injection Rate	Moderate-Fast			
Back Pressure	3.00 to 10.0		MPa	
Screw Compression Ratio	2.5:1.0			
NOTE				
1.	10°C/min			

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