

Akulon® Ultraflow K-FHGR24

Polyamide 6
DSM Engineering Plastics

Message:

Akulon® Ultraflow K-FHGR24 is a Polyamide 6 (Nylon 6) material filled with 20% glass bead and 10% glass fiber. It is available in Europe.
Important attributes of Akulon® Ultraflow K-FHGR24 are:

- Flame Rated
- Heat Stabilizer
- High Flow

General Information				
Filler / Reinforcement		Glass Bead,20% Filler by Weight Glass Fiber,10% Filler by Weight		
Additive		Heat Stabilizer		
Features		Heat Stabilized High Flow		
Forms		Pellets		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.35	--	g/cm ³	ISO 1183
Water Absorption				ISO 62
Saturation, 23°C	6.5	--	%	
Equilibrium, 23°C, 50% RH	1.9	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	6000	3500	MPa	ISO 527-2
Tensile Stress (Break)	85.0	55.0	MPa	ISO 527-2
Tensile Strain (Break)	2.5	5.0	%	ISO 527-2
Flexural Modulus	4900	2300	MPa	ISO 178
Flexural Stress	124	63.0	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	4.0	6.0	kJ/m ²	
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	21	--	kJ/m ²	
23°C	21	--	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	190	--	°C	ISO 75-2/A
Melting Temperature ¹	220	--	°C	ISO 11357-3
CLTE - Flow	3.5E-5	--	cm/cm/°C	ISO 11359-2
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	25	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	0.30		
1 MHz	0.015	0.12		
Comparative Tracking Index	350	350	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flammability Classification				IEC 60695-11-10, -20
0.750 mm	HB	--		
1.50 mm	HB	--		
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	245 to 270		°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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