

Akulon® F249-HG4

Polyamide 6
DSM Engineering Plastics

Message:

Akulon® F249-HG4 is a Polyamide 6 (Nylon 6) material filled with 20% glass fiber. It is available in Europe for extrusion blow molding. Primary attribute of Akulon® F249-HG4: Heat Stabilizer.

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Additive	Heat Stabilizer		
Features	Heat Stabilized		
Forms	Pellets		
Processing Method	Extrusion Blow Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.27	g/cm³	ISO 1183
Water Absorption			ISO 62
Saturation, 23°C	8.0	%	
Equilibrium, 23°C, 50% RH	2.4	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	7500	MPa	ISO 527-2
Tensile Stress (Break)	140	MPa	ISO 527-2
Tensile Strain (Break)	4.5	%	ISO 527-2
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	8.0	kJ/m²	
23°C	15	kJ/m²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	70	kJ/m²	
23°C	No Break		
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	215	°C	ISO 75-2/B
1.8 MPa, Unannealed	195	°C	ISO 75-2/A
Melting Temperature ¹	220	°C	ISO 11357-3
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	4.0 to 8.0	hr	
Rear Temperature	255 to 265	°C	
Middle Temperature	265 to 275	°C	
Front Temperature	265 to 280	°C	

Nozzle Temperature	260 to 280	°C
Processing (Melt) Temp	250 to 285	°C
Mold Temperature	50.0 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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Recommended distributors for this material

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