Akulon® K224-PG6

Polyamide 6

DSM Engineering Plastics

Message:

Akulon® K224-PG6 is a Polyamide 6 (Nylon 6) material filled with 30% glass fiber. It is available in Asia Pacific, Europe, or North America.
Important attributes of Akulon® K224-PG6 are:
Flame Rated
Impact Modified

General Information				
UL YellowCard	E47960-537593			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight			
Additive	Impact Modifier			
Features	Impact Modified			
Forms	Pellets			
Multi-Point Data	Shear Modulus vs. Temperature (ISO 11403-1)			
Physical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Density	1.32	--	g/cm³	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow	1.0	--	%	
Flow	0.39	--	%	
Water Absorption				ISO 62
Saturation, 23°C	5.7	--	%	
Equilibrium, 23°C, 50% RH	1.7	--	%	
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	8500	5500	MPa	ISO 527-2
Tensile Stress (Break)	145	100	MPa	ISO 527-2
Tensile Strain (Break)	4.5	9.0	%	ISO 527-2
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	15	15	kJ/m²	
23°C	23	43	kJ/m²	
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	100	100	kJ/m²	
23°C	95	110	kJ/m²	
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Heat Deflection Temperature				
0.45 MPa, Unannealed	215	--	°C	ISO 75-2/B

1.8 MPa, Unannealed	200	--	°C	ISO 75-2/A
CLTE				ISO 11359-2
Flow	2.0E-5	--	cm/cm/°C	
Transverse	9.0E-5	--	cm/cm/°C	
Electrical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Surface Resistivity	--	1.0E+14	ohms	IEC 60093
Volume Resistivity	1.0E+15	1.0E+13	ohms·cm	IEC 60093
Electric Strength	25	20	kV/mm	IEC 60243-1
Relative Permittivity				IEC 60250
100 Hz	3.80	14.0		
1 MHz	3.50	4.50		
Dissipation Factor				IEC 60250
100 Hz	9.0E-3	0.30		
1 MHz	0.015	0.12		
Comparative Tracking Index	--	600	V	IEC 60112
Flammability	**Dry**	**Conditioned**	**Unit**	**Test Method**
Flammability Classification (1.60 mm)	HB	--		IEC 60695-11-10, -20
Injection	**Dry**	**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			

Recommended distributors for this material

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