

Akulon® S223-GM35

Polyamide 66
DSM Engineering Plastics

Message:

Akulon® S223-GM35 is a Polyamide 66 (Nylon 66) material filled with 15% glass fiber and 25% mineral. It is available in North America.

General Information				
Filler / Reinforcement		Glass Fiber,15% Filler by Weight Mineral,25% Filler by Weight		
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	0.40	--	%	
Water Absorption				ISO 62
Saturation, 23°C	5.0	--	%	
Equilibrium, 23°C, 50% RH	1.1	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	9000	5000	MPa	ISO 527-2
Tensile Stress (Break)	120	76.0	MPa	ISO 527-2
Tensile Strain (Break)	3.0	6.0	%	ISO 527-2
Flexural Modulus	7700	--	MPa	ISO 178
Flexural Stress	175	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	3.7	2.9	kJ/m ²	
23°C	4.3	6.2	kJ/m ²	
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	250	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	240	--	°C	ISO 75-2/A
Melting Temperature ¹	260	--	°C	ISO 11357-3
CLTE				ISO 11359-2
Flow	1.8E-5	--	cm/cm/°C	
Transverse	1.0E-4	--	cm/cm/°C	
Injection	Dry	Unit		

Drying Temperature	80.0	°C
Drying Time	4.0 to 8.0	hr
Rear Temperature	275 to 295	°C
Middle Temperature	275 to 295	°C
Front Temperature	275 to 290	°C
Nozzle Temperature	280 to 290	°C
Processing (Melt) Temp	280 to 305	°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

- 10°C/min

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