

Akulon® Ultraflow K-FKMV5 /C

Polyamide 6
DSM Engineering Plastics

Message:

Akulon® Ultraflow K-FKMV5 /C is a Polyamide 6 (Nylon 6) material filled with 25% mineral. It is available in Europe.
Important attributes of Akulon® Ultraflow K-FKMV5 /C are:
Flame Rated
Flame Retardant
Halogen Free
High Flow

General Information				
Filler / Reinforcement	Mineral,25% Filler by Weight			
Additive	Flame Retardant			
Features	Flame Retardant			
	Halogen Free			
	High Flow			
Physical	Dry	Conditioned	Unit	Test Method
Density	1.38	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow	0.80	--	%	
Flow	0.60	--	%	
Water Absorption				ISO 62
23°C, 24 hr	6.2	--	%	
Equilibrium, 23°C, 50% RH	1.8	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	6200	--	MPa	ISO 527-2
Tensile Stress (Break)	65.0	--	MPa	ISO 527-2
Tensile Strain (Break)	1.8	--	%	ISO 527-2
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	2.0	--	kJ/m ²	
23°C	2.0	2.0	kJ/m ²	
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	25	--	kJ/m ²	
23°C	25	20	kJ/m ²	
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				

0.45 MPa, Unannealed	205	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	110	--	°C	ISO 75-2/A
Melting Temperature ¹	220	--	°C	ISO 11357-3
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	--	> 1.0E+15	ohms	IEC 60093
Volume Resistivity	> 1.0E+15	--	ohms·cm	IEC 60093
Comparative Tracking Index	--	600	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flammability Classification				IEC 60695-11-10, -20
0.750 mm	V-2	--		
1.50 mm	V-2	--		
Glow Wire Flammability Index				IEC 60695-2-12
1.50 mm	960	--	°C	
3.00 mm	960	--	°C	
Glow Wire Ignition Temperature (1.50 mm)	725	--	°C	IEC 60695-2-13
Injection	Dry	Unit		
Drying Temperature	80.0		°C	
Drying Time	4.0 to 8.0		hr	
Rear Temperature	225 to 235		°C	
Middle Temperature	230 to 240		°C	
Front Temperature	235 to 250		°C	
Nozzle Temperature	235 to 255		°C	
Processing (Melt) Temp	235 to 260		°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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