

Akulon® Ultraflow K-FG12

Polyamide 6
DSM Engineering Plastics

Message:

Akulon® Ultraflow K-FG12 is a Polyamide 6 (Nylon 6) material filled with 60% glass fiber. It is available in Europe.
Important attributes of Akulon® Ultraflow K-FG12 are:
Flame Rated
High Flow

General Information				
Filler / Reinforcement		Glass Fiber,60% Filler by Weight		
Features		High Flow		
Forms		Pellets		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.66	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow	0.80	--	%	
Flow	0.20	--	%	
Water Absorption				ISO 62
Saturation, 23°C	3.6	--	%	
Equilibrium, 23°C, 50% RH	1.0	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	20000	14000	MPa	ISO 527-2
Tensile Stress (Break)	235	160	MPa	ISO 527-2
Tensile Strain (Break)	2.2	4.0	%	ISO 527-2
Flexural Modulus	19500	--	MPa	ISO 178
Flexural Stress	365	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	12	12	kJ/m ²	
23°C	15	25	kJ/m ²	
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	85	85	kJ/m ²	
23°C	90	100	kJ/m ²	
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	220	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	210	--	°C	ISO 75-2/A

Melting Temperature ¹	220	--	°C	ISO 11357-3
CLTE				ISO 11359-2
Flow	1.0E-5	--	cm/cm/°C	
Transverse	4.0E-5	--	cm/cm/°C	
Flammability	Dry	Conditioned		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	230 to 250		°C	
Middle Temperature	240 to 260		°C	
Front Temperature	250 to 270		°C	
Nozzle Temperature	270 to 285		°C	
Processing (Melt) Temp	250 to 280		°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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