

Akulon® K224-PG3

Polyamide 6
DSM Engineering Plastics

Message:

Akulon® K224-PG3 is a Polyamide 6 (Nylon 6) material filled with 15% glass fiber. It is available in Europe.
Important attributes of Akulon® K224-PG3 are:
Flame Rated
Impact Modified

General Information				
UL YellowCard		E43392-101993571		
Filler / Reinforcement		Glass Fiber,15% Filler by Weight		
Additive		Impact Modifier		
Features		Impact Modified		
Forms		Pellets		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.20	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow	1.0	--	%	
Flow	0.40	--	%	
Water Absorption				ISO 62
Saturation, 23°C	6.8	--	%	
Equilibrium, 23°C, 50% RH	2.0	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	5400	2600	MPa	ISO 527-2
Tensile Stress (Break)	105	60.0	MPa	ISO 527-2
Tensile Strain (Break)	4.0	15	%	ISO 527-2
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	9.0	9.0	kJ/m ²	
23°C	16	25	kJ/m ²	
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	70	70	kJ/m ²	
23°C	70	90	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	185	--	°C	ISO 75-2/A

CLTE			ISO 11359-2	
Flow	3.0E-5	--	cm/cm/°C	
Transverse	8.0E-5	--	cm/cm/°C	
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	--	> 1.0E+15	ohms	IEC 60093
Volume Resistivity	> 1.0E+15	> 1.0E+15	ohms·cm	IEC 60093
Electric Strength	25	20	kV/mm	IEC 60243-1
Relative Permittivity				IEC 60250
100 Hz	3.60	14.0		
1 MHz	3.30	4.50		
Dissipation Factor				IEC 60250
100 Hz	0.010	0.15		
1 MHz	0.018	0.12		
Comparative Tracking Index	--	500	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			

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