

Akulon® K224-PG8

Polyamide 6
DSM Engineering Plastics

Message:

Akulon® K224-PG8 is a Polyamide 6 (Nylon 6) material filled with 40% glass fiber. It is available in Asia Pacific, Europe, or North America. Primary attribute of Akulon® K224-PG8: Impact Modified.

General Information	
Filler / Reinforcement	Glass Fiber,40% Filler by Weight
Additive	Impact Modifier
Features	Impact Modified
Forms	Pellets
Multi-Point Data	Isothermal Stress vs. Strain (ISO 11403-1)
	Secant Modulus vs. Strain (ISO 11403-1)
	Shear Modulus vs. Temperature (ISO 11403-1)
	Viscosity vs. Shear Rate (ISO 11403-2)

Physical	Dry	Conditioned	Unit	Test Method
Density	1.43	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow	0.81	--	%	
Flow	0.35	--	%	
Water Absorption				ISO 62
Saturation, 23°C	4.9	--	%	
Equilibrium, 23°C, 50% RH	1.5	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	11500	7000	MPa	ISO 527-2
Tensile Stress (Break)	170	115	MPa	ISO 527-2
Tensile Strain (Break)	4.5	7.0	%	ISO 527-2
Flexural Modulus	10000	--	MPa	ISO 178
Flexural Stress	260	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	16	16	kJ/m ²	
23°C	25	35	kJ/m ²	
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	110	110	kJ/m ²	
23°C	110	110	kJ/m ²	

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	6.5E-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	3.50	14.0		
1 MHz	3.30	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
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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