

Akulon® K240-HPG3

Polyamide 6
DSM Engineering Plastics

Message:

Akulon® K240-HPG3 is a Polyamide 6 (Nylon 6) material filled with 15% glass fiber. It is available in Europe for extrusion blow molding. Primary attribute of Akulon® K240-HPG3: Heat Stabilizer.

General Information				
Filler / Reinforcement		Glass Fiber,15% Filler by Weight		
Additive		Heat Stabilizer		
Features		Heat Stabilized		
Forms		Pellets		
Processing Method		Extrusion Blow Molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.20	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow	1.2	--	%	
Flow	0.25	--	%	
Water Absorption				ISO 62
Saturation, 23°C	6.8	--	%	
Equilibrium, 23°C, 50% RH	2.0	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	5600	3000	MPa	ISO 527-2
Tensile Stress (Break)	110	60.0	MPa	ISO 527-2
Tensile Strain (Break)	5.0	15	%	ISO 527-2
Flexural Modulus	5000	--	MPa	ISO 178
Flexural Stress	180	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	10	10	kJ/m ²	
23°C	20	30	kJ/m ²	
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	90	90	kJ/m ²	
23°C	80 kJ/m ²	No Break		
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	210	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	185	--	°C	ISO 75-2/A

Melting Temperature ¹	220	--	°C	ISO 11357-3
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			
NOTE				
1.	10°C/min			

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