

Akulon® Diablo HT-HG6 (K-X07031)

Polyamide 66/6 Copolymer

DSM Engineering Plastics

Message:

Akulon® Diablo HT-HG6 (K-X07031) is a Polyamide 66/6 Copolymer (Nylon 66/6) material filled with 30% glass fiber. It is available in Asia Pacific, Europe, or North America. Primary attribute of Akulon® Diablo HT-HG6 (K-X07031): Heat Stabilizer.

General Information				
Filler / Reinforcement		Glass Fiber,30% Filler by Weight		
Additive		Heat Stabilizer		
Features		Heat Stabilized		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.37	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow	0.75	--	%	
Flow	0.20	--	%	
Water Absorption				ISO 62
Saturation, 23°C	6.9	--	%	
Equilibrium, 23°C, 50% RH	2.4	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	9850	5500	MPa	ISO 527-2
Tensile Stress (Break)	180	95.0	MPa	ISO 527-2
Tensile Strain (Break)	3.3	6.5	%	ISO 527-2
Impact	Dry	Conditioned	Unit	Test Method
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	55	55	kJ/m ²	
23°C	60	85	kJ/m ²	
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	255	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	235	--	°C	ISO 75-2/A
Melting Temperature ¹	260	--	°C	ISO 11357-3
Injection	Dry	Unit		
Drying Temperature	80.0		°C	
Drying Time	4.0 to 8.0		hr	
Rear Temperature	275 to 295		°C	
Middle Temperature	275 to 295		°C	
Front Temperature	275 to 290		°C	

Nozzle Temperature	280 to 290	°C
Processing (Melt) Temp	280 to 305	°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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