

Akulon® K224-G4U

Polyamide 6
DSM Engineering Plastics

Message:

Akulon® K224-G4U is a polyamide 6 (nylon 6) material, which contains a 23% glass fiber reinforced material. This product is available in North America. Akulon® The main characteristics of the K224-G4U are: flame retardant/rated flame.

General Information				
Filler / Reinforcement		Glass fiber reinforced material, 23% filler by weight		
Forms		Particle		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.30	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Vertical flow direction	1.1	--	%	ISO 294-4
Flow direction	0.70	--	%	ISO 294-4
Water Absorption				ISO 62
Saturated, 23°C	7.0	--	%	ISO 62
Equilibrium, 23°C, 50% RH	2.1	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	7500	4400	MPa	ISO 527-2
Tensile Stress (Break)	130	52.0	MPa	ISO 527-2
Tensile Strain (Break)	3.5	6.0	%	ISO 527-2
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	3.5	11	kJ/m ²	ISO 179/1eA
23°C	6.0	11	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	55	55	kJ/m ²	ISO 179/1eU
23°C	60	110	kJ/m ²	ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	215	--	°C	ISO 75-2/B
1.8 MPa, not annealed	200	--	°C	ISO 75-2/A
Melting Temperature ¹	220	--	°C	ISO 11357-3
Linear thermal expansion coefficient				ISO 11359-2
Flow	2.5E-5	--	cm/cm/°C	ISO 11359-2
Lateral	1.1E-4	--	cm/cm/°C	ISO 11359-2

Flammability	Dry	Conditioned	Test Method
Flammability Classification			IEC 60695-11-10, -20
0.710 mm	HB	--	IEC 60695-11-10, -20
1.50 mm	HB	--	IEC 60695-11-10, -20
Injection	Dry	Unit	
Drying Temperature	80.0		°C
Drying Time	4.0 - 8.0		hr
Rear Temperature	255 - 265		°C
Middle Temperature	265 - 275		°C
Front Temperature	265 - 280		°C
Nozzle Temperature	260 - 280		°C
Processing (Melt) Temp	250 - 285		°C
Mold Temperature	50.0 - 80.0		°C
Injection Rate	Moderate-Fast		
Back Pressure	3.00 - 10.0		MPa
Screw Compression Ratio	2.5:1.0		
NOTE			
1.	10°C/min		

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