

Akulon® K222-KMV5

Polyamide 6
DSM Engineering Plastics

Message:

Akulon® K222-KMV5 is a Polyamide 6 (Nylon 6) material filled with 25% mineral. It is available in Asia Pacific or Europe for injection molding. Important attributes of Akulon® K222-KMV5 are:
Flame Rated
Flame Retardant
Halogen Free
Heat Stabilizer

General Information				
UL YellowCard		E47960-257448		
Filler / Reinforcement		Mineral,25% Filler by Weight		
Additive		Flame Retardant		
		Heat Stabilizer		
Features		Flame Retardant		
		Halogen Free		
		Heat Stabilized		
Forms		Pellets		
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.38	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow	0.82	--	%	
Flow	0.91	--	%	
Water Absorption				ISO 62
Saturation, 23°C	6.2	--	%	
Equilibrium, 23°C, 50% RH	1.8	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	6000	2500	MPa	ISO 527-2
Tensile Stress (Break)	65.0	35.0	MPa	ISO 527-2
Tensile Strain (Break)	2.5	30	%	ISO 527-2
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	2.0	--	kJ/m ²	
23°C	2.0	--	kJ/m ²	
Charpy Unnotched Impact Strength				ISO 179/1eU

-30°C	25	--	kJ/m ²	
23°C	29	--	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	110	--	°C	ISO 75-2/A
Melting Temperature	220	--	°C	ISO 11357-3
CLTE				ISO 11359-2
Flow	5.0E-5	--	cm/cm/°C	
Transverse	5.0E-5	--	cm/cm/°C	
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	--	> 1.0E+15	ohms	IEC 60093
Volume Resistivity	> 1.0E+15	--	ohms·cm	IEC 60093
Comparative Tracking Index	--	600	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flammability Classification				IEC 60695-11-10, -20
0.750 mm	V-2	--		
1.50 mm	V-2	--		
Glow Wire Flammability Index				IEC 60695-2-12
0.750 mm	960	--	°C	
3.00 mm	960	--	°C	
Glow Wire Ignition Temperature				IEC 60695-2-13
0.750 mm	700	--	°C	
3.00 mm	725	--	°C	
Injection	Dry	Unit		
Drying Temperature	80.0		°C	
Drying Time	4.0 to 8.0		hr	
Rear Temperature	225 to 235		°C	
Middle Temperature	230 to 240		°C	
Front Temperature	235 to 250		°C	
Nozzle Temperature	235 to 255		°C	
Processing (Melt) Temp	245 to 265		°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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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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