

Akulon® N24-G6

Polyamide 6
DSM Engineering Plastics

Message:

Akulon® N24-G6 is a Polyamide 6 (Nylon 6) material filled with 30% glass fiber. It is available in Asia Pacific.

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Physical	Nominal Value	Unit	Test Method
Density	1.35	g/cm ³	ISO 1183
Water Absorption			ISO 62
Saturation, 23°C	6.3	%	
Equilibrium, 23°C, 50% RH	1.9	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	9300	MPa	ISO 527-2
Tensile Stress (Break)	150	MPa	ISO 527-2
Tensile Strain (Break)	2.5	%	ISO 527-2
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	9.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	62	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	220	°C	ISO 75-2/B
1.8 MPa, Unannealed	200	°C	ISO 75-2/A
Melting Temperature	220	°C	ISO 11357-3
Injection	Nominal Value	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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