Akulon® K224-G4

PA6-GF20 — Envalior

Product Texts

20% Glass Reinforced

ISO 1043 PA6-GF20

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
[C] Molding shrinkage, parallel	**0.2 / ***	%	ISO 294-4, 2577
[C] Molding shrinkage, normal	**1.1 / ***	%	ISO 294-4, 2577
[C] Density of melt	**1090**	kg/m³	-
[C] Thermal conductivity of melt	**0.25**	W/(m K)	-
[C] Spec. heat capacity of melt	**2340**	J/(kg K)	-
[C] Eff. thermal diffusivity	**9.83E-8**	m²/s	-

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
[C] Tensile Modulus	**7300 / 4300**	MPa	ISO 527
[C] Stress at break	**145 / 85**	MPa	ISO 527
[C] Strain at break	**3.5 / 10**	%	ISO 527
[C] Charpy impact strength, +23°C	**65 / -**	kJ/m²	ISO 179/1eU
[C] Charpy impact strength, -30°C	**55 / -**	kJ/m²	ISO 179/1eU
[C] Charpy notched impact strength, +23°C	**10 / -**	kJ/m²	ISO 179/1eA
[C] Charpy notched impact strength, -30°C	**8 / -**	kJ/m²	ISO 179/1eA

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
[C] Melting temperature, 10°C/min	**220 / ***	°C	ISO 11357-1/-3
[C] Temp. of deflection under load, 1.80 MPa	**195 / ***	°C	ISO 75-1/-2
[C] Temp. of deflection under load, 0.45 MPa	**215 / ***	°C	ISO 75-1/-2
[C] Coeff. of linear therm. expansion, parallel	**30 / ***	E-6/K	ISO 11359-1/-2
[C] Coeff. of linear therm. expansion, normal	**90 / ***	E-6/K	ISO 11359-1/-2
[C] Burning Behav. at 1.5 mm nom. thickn.	**HB / ***	class	IEC 60695-11-10
Thickness tested	**1.5 / ***	mm	-
Yellow Card available	**yes / ***	-	-
[C] Burning Behav. at thickness h	**HB / ***	class	IEC 60695-11-10
Thickness tested	**3.0 / ***	mm	-
Yellow Card available	**yes / ***	-	-

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
[C] Water absorption	**7.2 / ***	%	Sim. to ISO 62
[C] Humidity absorption	**2.15 / ***	%	Sim. to ISO 62
[C] Density	**1270 / -**	kg/m³	ISO 1183

[C]: CAMPUS

Characteristics

Processing

Injection Molding

Regional Availability

North America, Europe, Asia Pacific

Delivery form

Pellets

Other text information

Injection molding

Injection Molding Recommendations
Steel recommendations for molds screws and barrels
Trouble shooting guideline for injection molding