

**Product Texts**

33% Glass Reinforced, Heat Stabilized

ISO 1043 PA6-GF33

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Molding shrinkage, parallel	0.4 / *	%	ISO 294-4, 2577
<sup>[C]</sup> Molding shrinkage, normal	0.9 / *	%	ISO 294-4, 2577
<sup>[C]</sup> Density of melt	1200	kg/m <sup>3</sup>	-
<sup>[C]</sup> Thermal conductivity of melt	0.29	W/(m K)	-
<sup>[C]</sup> Spec. heat capacity of melt	2140	J/(kg K)	-
<sup>[C]</sup> Eff. thermal diffusivity	1.13E-7	m <sup>2</sup> /s	-

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Tensile Modulus	10500 / 6600	MPa	ISO 527
<sup>[C]</sup> Stress at break	185 / 110	MPa	ISO 527
<sup>[C]</sup> Strain at break	3.5 / 5	%	ISO 527
<sup>[C]</sup> Charpy impact strength, +23°C	95 / 110	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy impact strength, -30°C	75 / 70	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy notched impact strength, +23°C	13 / 30	kJ/m <sup>2</sup>	ISO 179/1eA
<sup>[C]</sup> Charpy notched impact strength, -30°C	12 / 11	kJ/m <sup>2</sup>	ISO 179/1eA

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Melting temperature, 10°C/min	220 / *	°C	ISO 11357-1/-3
<sup>[C]</sup> Temp. of deflection under load, 1.80 MPa	210 / *	°C	ISO 75-1/-2
<sup>[C]</sup> Temp. of deflection under load, 0.45 MPa	220 / *	°C	ISO 75-1/-2
<sup>[C]</sup> Coeff. of linear therm. expansion, parallel	20 / *	E-6/K	ISO 11359-1/-2
<sup>[C]</sup> Coeff. of linear therm. expansion, normal	70 / *	E-6/K	ISO 11359-1/-2

[C]: CAMPUS

Electrical properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Relative permittivity, 100Hz	3.5 / 20	-	IEC 62631-2-1
<sup>[C]</sup> Relative permittivity, 1MHz	3.3 / 5	-	IEC 62631-2-1
<sup>[C]</sup> Dissipation factor, 100Hz	50 / 3000	E-4	IEC 62631-2-1
<sup>[C]</sup> Dissipation factor, 1MHz	150 / 1200	E-4	IEC 62631-2-1
<sup>[C]</sup> Volume resistivity	1E12 / 1E10	Ohm*m	IEC 62631-3-1
<sup>[C]</sup> Surface resistivity	* / 1E13	Ohm	IEC 62631-3-2
<sup>[C]</sup> Electric strength	30 / 25	kV/mm	IEC 60243-1

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
<sup>[C]</sup> Water absorption	6.3 / *	%	Sim. to ISO 62
<sup>[C]</sup> Humidity absorption	1.9 / *	%	Sim. to ISO 62
<sup>[C]</sup> Density	1390 / *	kg/m <sup>3</sup>	ISO 1183

[C]: CAMPUS

**Characteristics****Processing**

Injection Molding

**Special Characteristics**

Heat stabilized or stable to heat

## Akulon® K224-HG6U

PA6-GF33

Envalior

### Delivery form

Pellets

### Regional Availability

North America

### Additives

Lubricants, Release agent

### Other text information

#### Injection molding

[Injection Molding Recommendations](#)

[Steel recommendations for molds screws and barrels](#)

[Trouble shooting guideline for injection molding](#)