Akulon® S223-XKG5

PA66-GF25 — Envalior

Product Texts

25% Glass Reinforced, Heat Stabilized

ISO 1043 PA66-GF25

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
[C] Tensile Modulus	**8600 / -**	MPa	ISO 527
[C] Stress at break	**180 / -**	MPa	ISO 527
[C] Strain at break	**4 / -**	%	ISO 527
[C] Charpy impact strength, +23°C	**75 / -**	kJ/m²	ISO 179/1eU
[C] Charpy notched impact strength, +23°C	**10 / -**	kJ/m²	ISO 179/1eA

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
[C] Melting temperature, 10°C/min	**260 / ***	°C	ISO 11357-1/-3

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
[C] Water absorption	**6.5 / ***	%	Sim. to ISO 62
[C] Humidity absorption	**1.8 / ***	%	Sim. to ISO 62
[C] Density	**1320 / -**	kg/m³	ISO 1183

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**90**	°C	-
Pre-drying - Time	**2 - 20**	h	-
Processing humidity	**≤0.2**	%	-
Melt temperature	**280 - 290**	°C	-
Mold temperature	**80 - 90**	°C	-

Characteristics

Processing
Injection Molding

Special Characteristics
Heat stabilized or stable to heat

Delivery form
Pellets

Regional Availability
Asia Pacific

Other text information

Injection molding

#0 0;Injection moulding
PREPROCESSING
Max. moisture content: 0,2 %
Drying temperature: 90 [°C]
Drying time:
Dehumidifying air dryer: 2 - 20 h (depending on the initial moisture content)

PROCESSING
Melt temperature: 280 - 290 [°C]
Mould temperature: 80 - 90 [°C]

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