

Akulon[®] K224–HGM24

PA6—(GF+MD)30

10% Glass Reinforced, 20% Mineral Reinforced, Heat Stabilized

PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
RHEOLOGICAL PROPERTIES			
	DRY / COND		
Molding shrinkage (parallel)	0.3 / *	%	ISO 294–4
Molding shrinkage (normal)	0.9 / *	%	ISO 294–4
MECHANICAL PROPERTIES			
	DRY / COND		
Tensile modulus	7800 / 3500	MPa	ISO 527–1/–2
Stress at break	105 / 55	MPa	ISO 527–1/–2
Strain at break	3.5 / 6	%	ISO 527–1/–2
Flexural modulus	6600 / –	MPa	ISO 178
Flexural strength	175 / –	MPa	ISO 178
Charpy impact strength (+23°C)	40 / –	kJ/m ²	ISO 179/1eU
Charpy impact strength (–30°C)	35 / –	kJ/m ²	ISO 179/1eU
Charpy notched impact strength (+23°C)	4.4 / 10	kJ/m ²	ISO 179/1eA
Charpy notched impact strength (–30°C)	4 / 5	kJ/m ²	ISO 179/1eA
Izod notched impact strength (+23°C)	5.3 / –	kJ/m ²	ISO 180/1A
THERMAL PROPERTIES			
	DRY / COND		
Melting temperature (10°C/min)	220 / *	°C	ISO 11357–1/–3
Temp. of deflection under load (1.80 MPa)	190 / *	°C	ISO 75–1/–2
Temp. of deflection under load (0.45 MPa)	210 / *	°C	ISO 75–1/–2
Coeff. of linear therm. expansion (parallel)	0.35 / *	E–4/°C	ISO 11359–1/–2
Coeff. of linear therm. expansion (normal)	0.6 / *	E–4/°C	ISO 11359–1/–2

OTHER PROPERTIES

DRY / COND

Property Data

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PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
Water absorption	6.5 / *	%	Sim. to ISO 62
Humidity absorption	1.9 / *	%	Sim. to ISO 62
Density	1380 / *	kg/m³	ISO 1183