

Akulon® K224-HGM35

PA6-(GF+MD)40

DSM Engineering Plastics

Product Texts

15% Glass Reinforced, 25% Mineral Reinforced, Heat Stabilized

ISO 1043 PA6-(GF+MD)40

[Akulon website](#)

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	9000 / 4800	MPa	ISO 527-1/-2
Stress at break	120 / 67	MPa	ISO 527-1/-2
Strain at break	3 / 6	%	ISO 527-1/-2
Charpy impact strength (+23°C)	30 / -	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	25 / -	kJ/m ²	ISO 179/1eU
Charpy notched impact strength (+23°C)	5 / 6	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	6 / 3	kJ/m ²	ISO 179/1eA

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
Melting temperature (10°C/min)	220 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	205 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	215 / *	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	35 / *	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	50 / *	E-6/K	ISO 11359-1/-2
Burning behav. at 1.5 mm nom. thickn.	HB / *	class	IEC 60695-11-10
Thickness tested	1.5 / *	mm	IEC 60695-11-10
UL recognition	UL / *	-	-
Burning behav. at thickness h	HB / *	class	IEC 60695-11-10
Thickness tested	1.5 / *	mm	IEC 60695-11-10
UL recognition	UL / *	-	-

Electrical properties	dry / cond	Unit	Test Standard
ISO Data			
Relative permittivity, 100Hz	3.5 / 14	-	IEC 60250
Relative permittivity, 1MHz	3.3 / 4.5	-	IEC 60250
Dissipation factor, 100Hz	50 / 3200	E-4	IEC 60250
Dissipation factor, 1MHz	140 / 1200	E-4	IEC 60250
Volume resistivity	1E12 / 1E10	Ohm*m	IEC 60093
Surface resistivity	* / 1E13	Ohm	IEC 60093
Electric strength	35 / 30	kV/mm	IEC 60243-1

Other properties	dry / cond	Unit	Test Standard
ISO Data			
Humidity absorption	1.7 / *	%	Sim. to ISO 62
Density	1490 / -	kg/m ³	ISO 1183

Characteristics**Processing**

Injection Molding

Additives

Lubricants, Release agent

Delivery form

Pellets

Special Characteristics

Heat stabilized or stable to heat

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Other text information

Injection Molding

[Injection Molding Recommendations](#)