

<b>Akulon® K224-PG8</b>						
PA6-I-GF40	DSM Engineering Plastics					
<b>Product Texts</b>						
40% Glass Reinforced, Impact Modified						
ISO 1043 PA6-I-GF40						
<a href="#">Akulon website</a>						
<b>Rheological properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>			
<b>ISO Data</b>						
Melt volume-flow rate, MVR	14 / *	cm <sup>3</sup> /10min	ISO 1133			
Temperature	275 / *	°C	ISO 1133			
Load	5 / *	kg	ISO 1133			
Molding shrinkage, parallel	0.3 / *	%	ISO 294-4, 2577			
Molding shrinkage, normal	0.8 / *	%	ISO 294-4, 2577			
<b>Mechanical properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>			
<b>ISO Data</b>						
Tensile Modulus	11500 / 7000	MPa	ISO 527-1/-2			
Stress at break	170 / 115	MPa	ISO 527-1/-2			
Strain at break	4.5 / 7	%	ISO 527-1/-2			
Charpy impact strength (+23°C)	105 / 110	kJ/m <sup>2</sup>	ISO 179/1eU			
Charpy impact strength, -30°C	110 / 110	kJ/m <sup>2</sup>	ISO 179/1eU			
Charpy notched impact strength (+23°C)	25 / 35	kJ/m <sup>2</sup>	ISO 179/1eA			
Charpy notched impact strength, -30°C	16 / 16	kJ/m <sup>2</sup>	ISO 179/1eA			
<b>Thermal properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>			
<b>ISO Data</b>						
Temp. of deflection under load (1.80 MPa)	200 / *	°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	20 / *	E-6/K	ISO 11359-1/-2			
Coeff. of linear therm. expansion, normal	65 / *	E-6/K	ISO 11359-1/-2			
<b>Electrical properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>			
<b>ISO Data</b>						
Relative permittivity, 100Hz	3.5 / 14	-	IEC 60250			
Relative permittivity, 1MHz	3.3 / 4.5	-	IEC 60250			
Dissipation factor, 100Hz	90 / 3000	E-4	IEC 60250			
Dissipation factor, 1MHz	150 / 1200	E-4	IEC 60250			
Volume resistivity	1E13 / 1E11	Ohm*m	IEC 60093			
Surface resistivity	* / 1E14	Ohm	IEC 60093			
Electric strength	25 / 20	kV/mm	IEC 60243-1			
Comparative tracking index	- / 600	-	IEC 60112			
<b>Other properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>			
<b>ISO Data</b>						
Water absorption	4.9 / *	%	Sim. to ISO 62			
Humidity absorption	1.5 / *	%	Sim. to ISO 62			
Density	1430 / -	kg/m <sup>3</sup>	ISO 1183			
<b>Rheological calculation properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>			
<b>ISO Data</b>						
Density of melt	1280	kg/m <sup>3</sup>	-			
Thermal conductivity of melt	0.3	W/(m K)	-			
Spec. heat capacity of melt	2010	J/(kg K)	-			

**Akulon® K224-PG8**

PA6-I-GF40

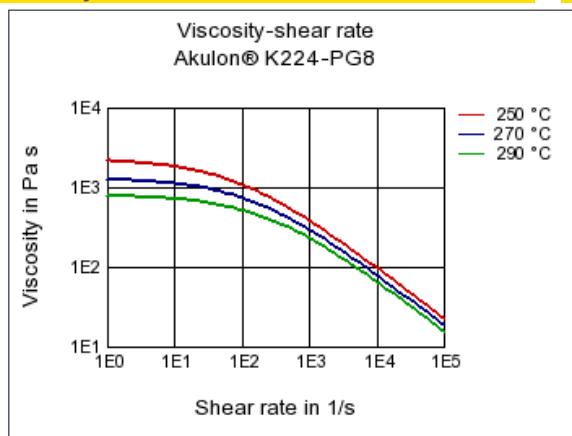
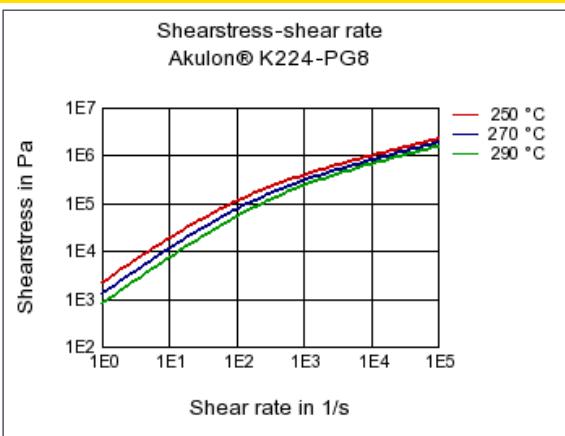
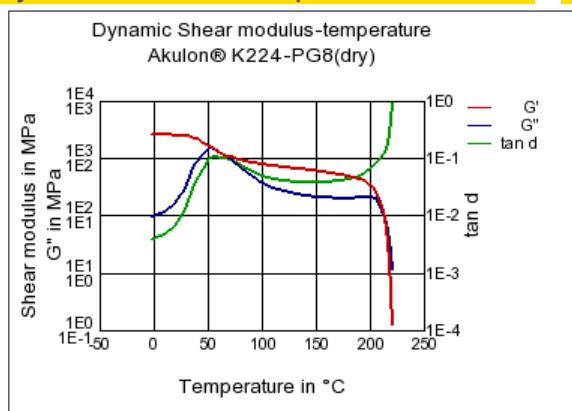
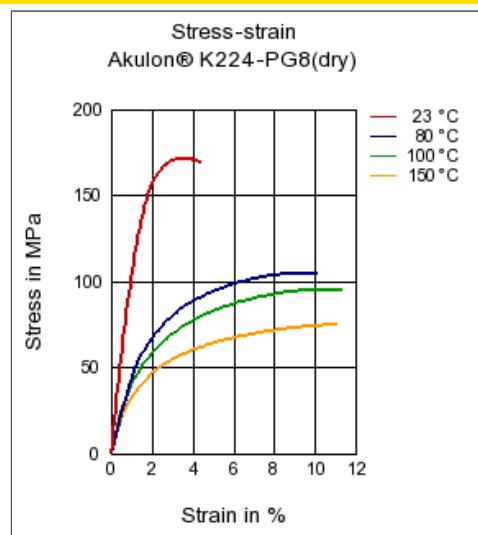
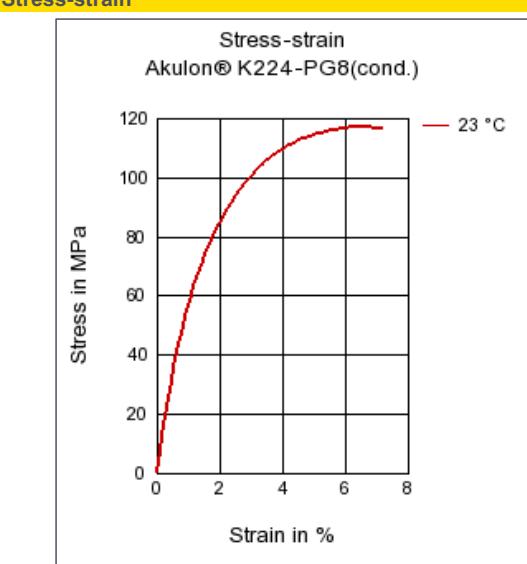
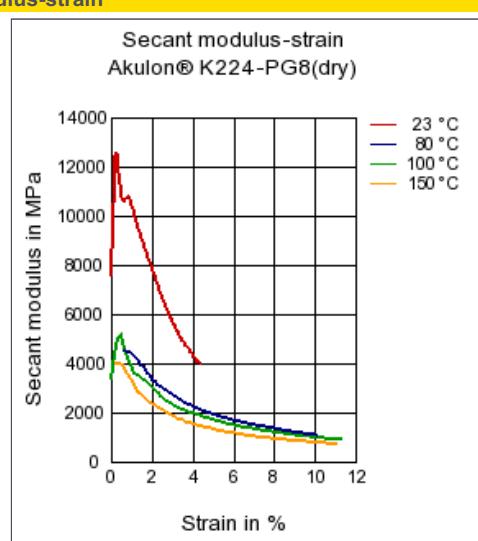
DSM Engineering Plastics

Eff. thermal diffusivity

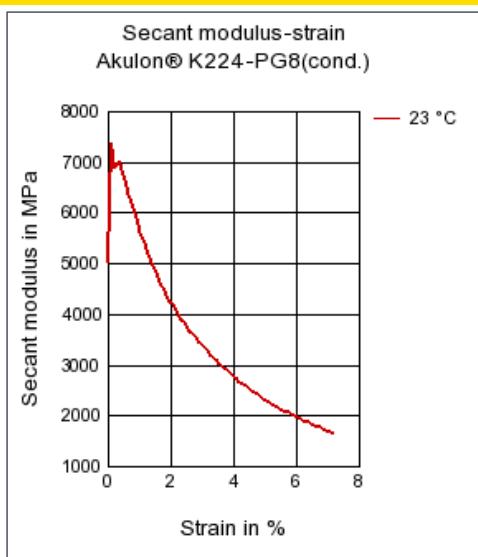
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m<sup>2</sup>/s

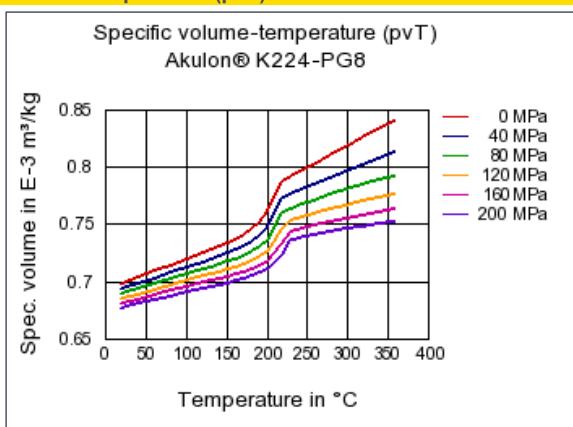
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**Diagrams****Viscosity-shear rate****Shearstress-shear rate****Dynamic Shear modulus-temperature****Stress-strain****Stress-strain****Secant modulus-strain**

## Secant modulus-strain



## Specific volume-temperature (pvT)



## Characteristics

## Processing

Injection Molding

## Additives

Release agent

## Delivery form

Pellets

## Special Characteristics

High impact or impact modified

## Other text information

## Injection Molding

[Injection Molding Recommendations](#)