Akulon® Ultraflow K-FKMV5

PA6-MD25 FR(30) DSM Engineering Plastics

Product Texts

25% Mineral Reinforced, Flame Retardant (halogen free), High Flow

ISO 1043 PA6-MD25 FR(30)

Akulon website

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	25 / *	cm³/10min	ISO 1133
Temperature	250 / *	°C	ISO 1133
Load	2.16 / *	kg	ISO 1133
Molding shrinkage, parallel	0.6 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.8 / *	%	ISO 294-4, 2577

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	6200 / -	MPa	ISO 527-1/-2
Stress at break	65 / -	MPa	ISO 527-1/-2
Strain at break	2 / -	%	ISO 527-1/-2
Charpy impact strength (+23°C)	25 / 30	kJ/m²	ISO 179/1eU
Charpy impact strength, -30°C	25 / -	kJ/m²	ISO 179/1eU
Charpy notched impact strength (+23°C)	2 / 2	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	2 / -	kJ/m²	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)	110 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	205 / *	°C	ISO 75-1/-2
Burning behav. at 1.5 mm nom. thickn.	V-2 / *	class	IEC 60695-11-10
Thickness tested	1.5 / *	mm	IEC 60695-11-10
Burning behav. at thickness h	V-2 / *	class	IEC 60695-11-10
Thickness tested	0.8 / *	mm	IEC 60695-11-10

Electrical properties	dry / cond	Unit	Test Standard
ISO Data			
Volume resistivity	>1E13 / -	Ohm*m	IEC 60093
Surface resistivity	* / >1E15	Ohm	IEC 60093
Comparative tracking index	- / 600	-	IEC 60112

Other properties	dry / cond	Unit	Test Standard
ISO Data			
Water absorption	6.2 / *	%	Sim. to ISO 62
Humidity absorption	1.8 / *	%	Sim. to ISO 62
Density	1380 / -	kg/m³	ISO 1183

Rheological calculation properties	Value	Unit	Test Standard
ISO Data			
Density of melt	1170	kg/m³	-
Thermal conductivity of melt	0.201	W/(m K)	-
Spec. heat capacity of melt	2250	J/(kg K)	-
Eff. thermal diffusivity	7.63E-8	m²/s	-

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Characteristics

Processing
Injection Molding

Additives
Release agent

Delivery form
Pellets

Special Characteristics
Flame retardant, Heat stabilized or stable to heat

Other text information

Injection Molding
Injection Molding Recommendations