

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	7000 / 3500	MPa	ISO 527-1/-2
Stress at break	100 / 55	MPa	ISO 527-1/-2
Strain at break	3.5 / 6	%	ISO 527-1/-2
Flexural modulus	5600 / -	MPa	ISO 178
Flexural strength	160 / -	MPa	ISO 178
Charpy impact strength (+23°C)	45 / -	kJ/m ²	ISO 179/1eU
Charpy impact strength (-30°C)	40 / -	kJ/m ²	ISO 179/1eU
Charpy notched impact strength (+23°C)	5 / 10	kJ/m ²	ISO 179/1eA
Charpy notched impact strength (-30°C)	5 / 5	kJ/m ²	ISO 179/1eA
Izod notched impact strength (+23°C)	5.5 / -	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/m ³	ISO 1183

