



Akulon® K224-HPG3		DSM Engineering Plastics	
PA6-I-GF15			
Product Texts			
15% Glass Reinforced, Heat Stabilized, Impact Modified			
ISO 1043 PA6-I-GF15			
Mechanical properties		dry / cond	Unit
ISO Data			
Tensile Modulus	5400 / 2600	MPa	ISO 527-1/-2
Stress at break	105 / 60	MPa	ISO 527-1/-2
Strain at break	4 / 15	%	ISO 527-1/-2
Charpy impact strength (+23°C)	70 / 90	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	70 / 70	kJ/m ²	ISO 179/1eU
Charpy notched impact strength (+23°C)	16 / 25	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	9 / 9	kJ/m ²	ISO 179/1eA
Thermal properties		dry / cond	Unit
ISO Data			
Temp. of deflection under load (1.80 MPa)	185 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	205 / *	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	30 / *	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	80 / *	E-6/K	ISO 11359-1/-2
Burning behav. at 1.5 mm nom. thickn.	HB / *	class	IEC 60695-11-10
Thickness tested	1.6 / *	mm	IEC 60695-11-10
Electrical properties		dry / cond	Unit
ISO Data			
Relative permittivity, 100Hz	3.6 / 14	-	IEC 60250
Relative permittivity, 1MHz	3.3 / 4.5	-	IEC 60250
Dissipation factor, 100Hz	100 / 1500	E-4	IEC 60250
Dissipation factor, 1MHz	180 / 1200	E-4	IEC 60250
Volume resistivity	1E12 / 1E10	Ohm*m	IEC 60093
Surface resistivity	* / 1E13	Ohm	IEC 60093
Electric strength	25 / 20	kV/mm	IEC 60243-1
Comparative tracking index	- / 500	-	IEC 60112
Other properties		dry / cond	Unit
ISO Data			
Water absorption	6.8 / *	%	Sim. to ISO 62
Humidity absorption	2 / *	%	Sim. to ISO 62
Density	1200 / -	kg/m ³	ISO 1183
Characteristics			
Processing		Additives	
Injection Molding		Release agent	
Delivery form		Special Characteristics	
Pellets		High impact or impact modified, Heat stabilized or stable to heat	
Other text information			
Injection Molding			
Injection Molding Recommendations			