

TECHNICAL DATA SHEET

# Akulon® K224-HG7

Envalior  
PA6-GF35

**Processing**

Injection molding

**Delivery Form**

Pellets

**Additives**

Release agent

**Special Characteristics**

Heat stabilized or stable to heat

## Product Text

**Product Information**

35% Glass Reinforced, Heat Stabilized

ISO 1043 PA6-GF35

Processing/Physical Characteristics	Value	Unit	Standard
Melt volume-flow rate, MVR	40	cm <sup>3</sup> /10min	ISO 1133
Temperature	275	°C	
Load	5	kg	
Molding shrinkage, parallel	0.3	%	ISO 294-4, 2577
Molding shrinkage, normal	0.9	%	ISO 294-4, 2577
Density of melt	1150	kg/m <sup>3</sup>	
Thermal conductivity of melt	0.27	W/(m K)	
Spec. heat capacity of melt	2110	J/(kg K)	
Eff. thermal diffusivity	1.4E-7	m <sup>2</sup> /s	
Mechanical Properties	Value	Unit	Standard
Tensile modulus	11000	MPa	ISO 527
Stress at break	195	MPa	ISO 527
Strain at break	3.5	%	ISO 527
Poisson's ratio	0.35		ISO 527
Charpy impact strength, +23°C	90	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength, -30°C	75	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	14	kJ/m <sup>2</sup>	ISO 179/1eA

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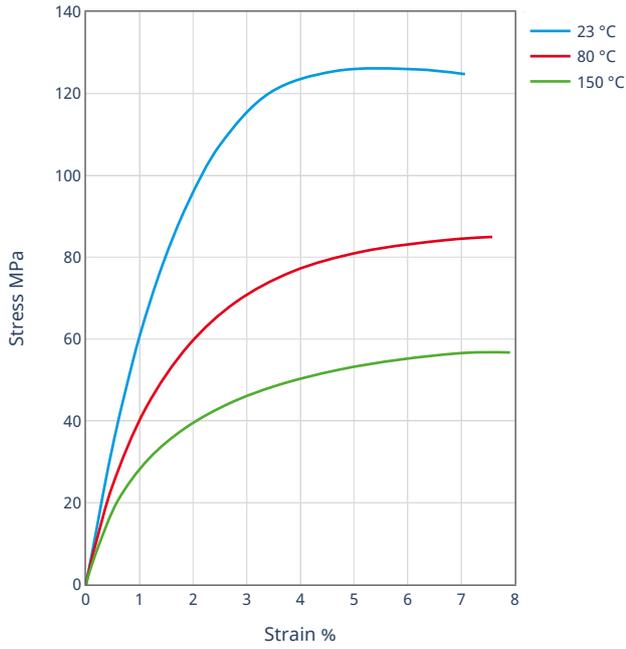
Mechanical Properties	Value	Unit	Standard
Charpy notched impact strength, -30°C	12	kJ/m <sup>2</sup>	ISO 179/1eA
Thermal Properties	Value	Unit	Standard
Melting temperature, 10°C/min	220	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	210	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	220	°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	60	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	
Yellow card available	yes		
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	3	mm	
Yellow card available	yes		
Electrical Properties	Value	Unit	Standard
Relative permittivity, 100Hz	4.8		IEC 62631-2-1
Relative permittivity, 1MHz	4.3		IEC 62631-2-1
Dissipation factor, 100Hz	170	E-4	IEC 62631-2-1
Dissipation factor, 1MHz	220	E-4	IEC 62631-2-1
Volume resistivity	1E12	Ohm*m	IEC 62631-3-1
Surface resistivity	1E13	Ohm	IEC 62631-3-2
Electric strength	35	kV/mm	IEC 60243-1
Comparative tracking index	500		IEC 60112
Other Properties	Value	Unit	Standard
Water absorption	5.9	%	Sim. to ISO 62
Humidity absorption	1.8	%	Sim. to ISO 62
Density	1400	kg/m <sup>3</sup>	ISO 1183

## Diagrams

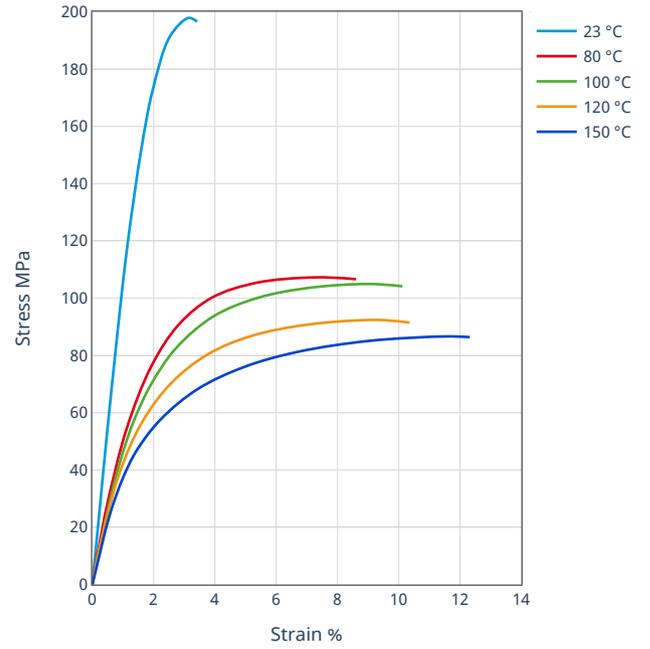
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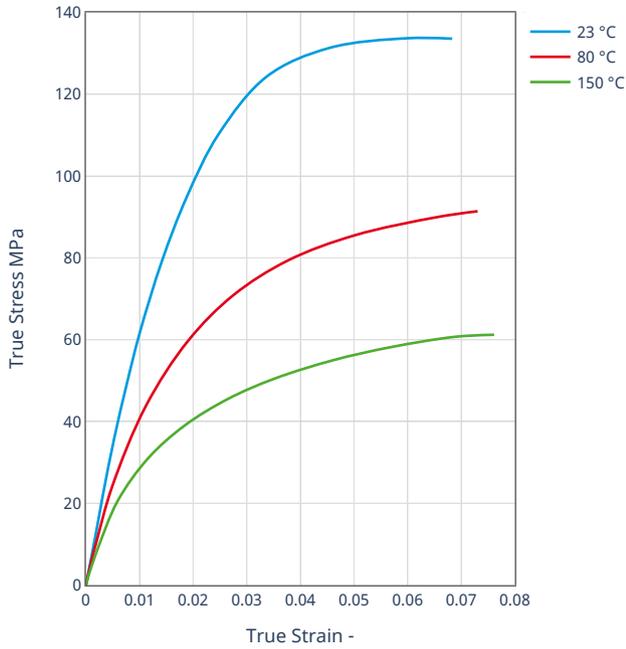
Stress-strain



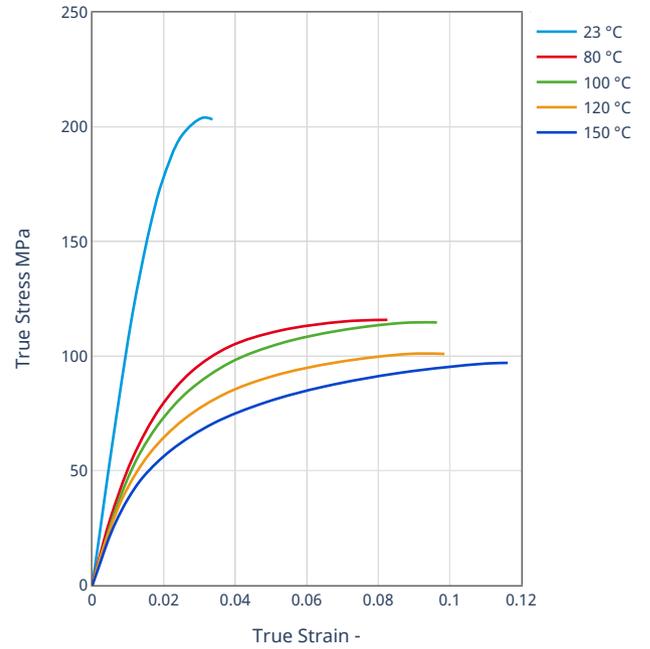
Stress-strain



True stress-true strain



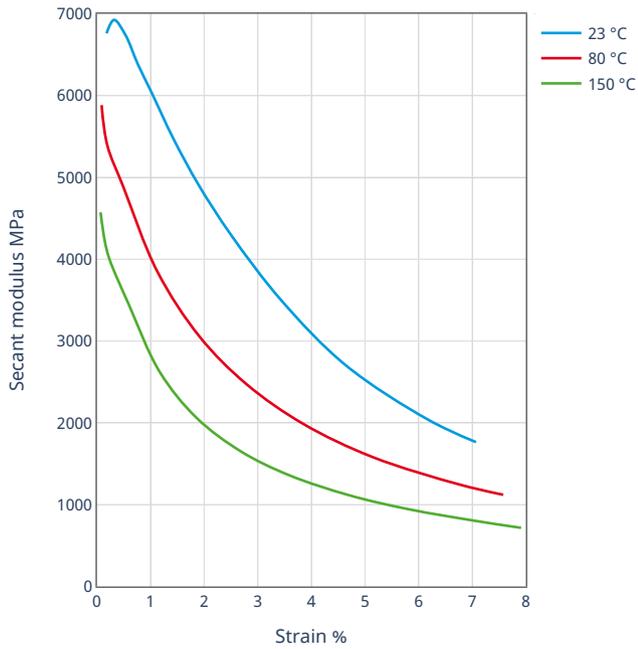
True stress-true strain



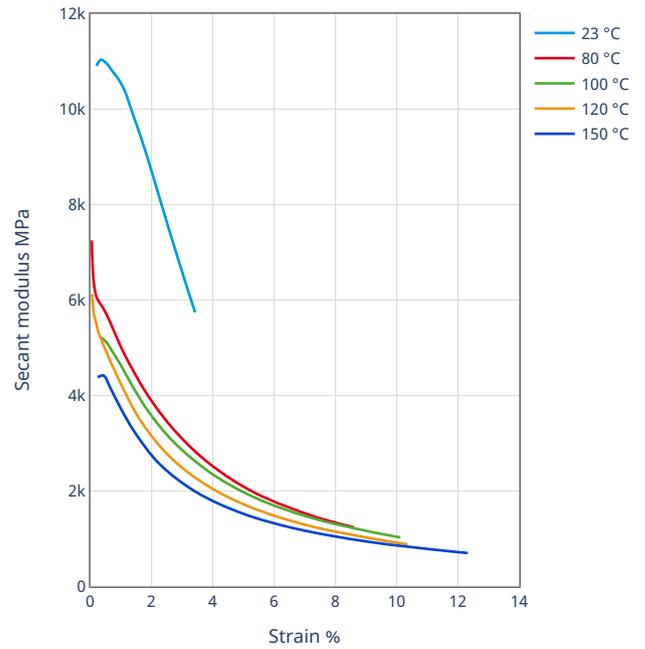
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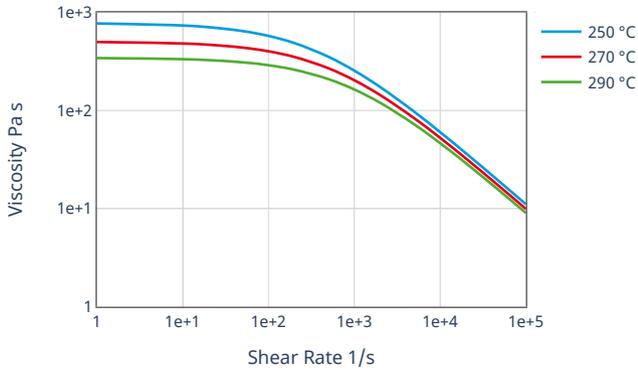
Secant modulus-strain



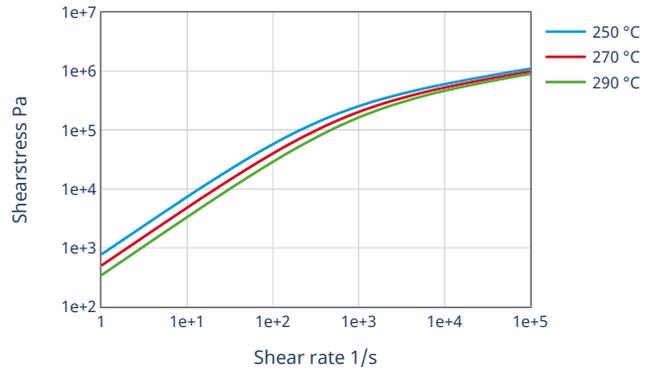
Secant modulus-strain



Viscosity-shear rate

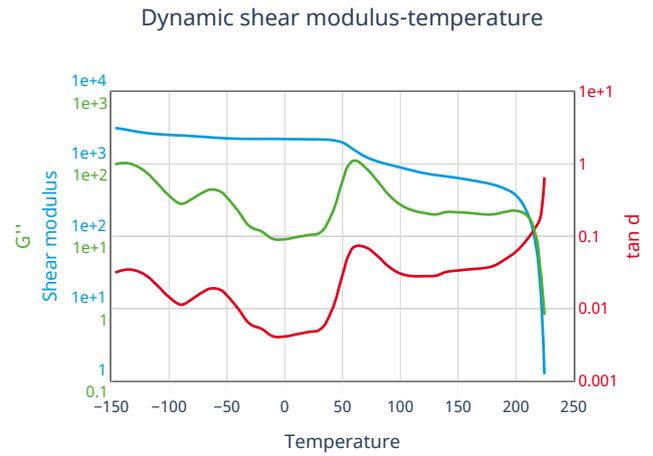
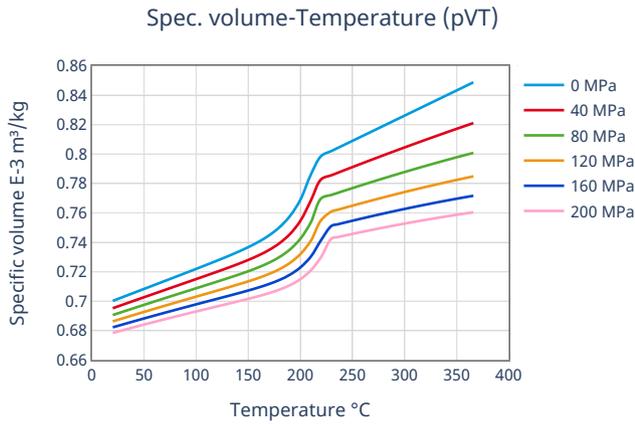


Shearstress-shear rate



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## Processing Information

### Injection molding

Injection Molding Recommendations

Steel recommendations for molds screws and barrels

Trouble shooting guideline for injection molding