



| Akulon® K224-HGM35 | | DSM Engineering Plastics | |
|---|-----------------------------------|--------------------------|----------------------|
| Product Texts | | | |
| 15% Glass Reinforced, 25% Mineral Reinforced, Heat Stabilized | | | |
| ISO 1043 PA6-(GF+MD)40 | | | |
| Mechanical properties | dry / cond | Unit | Test Standard |
| ISO Data | | | |
| Tensile Modulus | 9000 / 4800 | MPa | ISO 527-1/-2 |
| Stress at break | 120 / 67 | MPa | ISO 527-1/-2 |
| Strain at break | 3 / 6 | % | ISO 527-1/-2 |
| Charpy impact strength (+23°C) | 30 / - | kJ/m ² | ISO 179/1eU |
| Charpy impact strength, -30°C | 25 / - | kJ/m ² | ISO 179/1eU |
| Charpy notched impact strength (+23°C) | 5 / 6 | kJ/m ² | ISO 179/1eA |
| Charpy notched impact strength, -30°C | 6 / 3 | kJ/m ² | 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) | 205 / * | °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 | 35 / * | E-6/K | ISO 11359-1/-2 |
| Coeff. of linear therm. expansion, normal | 50 / * | 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 | IEC 60695-11-10 |
| UL recognition | UL / * | - | - |
| Burning behav. at thickness h | HB / * | class | IEC 60695-11-10 |
| Thickness tested | 1.5 / * | mm | IEC 60695-11-10 |
| UL recognition | UL / * | - | - |
| Electrical properties | dry / cond | Unit | Test Standard |
| ISO Data | | | |
| Relative permittivity, 100Hz | 3.5 / 14 | - | IEC 60250 |
| Relative permittivity, 1MHz | 3.3 / 4.5 | - | IEC 60250 |
| Dissipation factor, 100Hz | 50 / 3200 | E-4 | IEC 60250 |
| Dissipation factor, 1MHz | 140 / 1200 | E-4 | IEC 60250 |
| Volume resistivity | 1E12 / 1E10 | Ohm*m | IEC 60093 |
| Surface resistivity | * / 1E13 | Ohm | IEC 60093 |
| Electric strength | 35 / 30 | kV/mm | IEC 60243-1 |
| Other properties | dry / cond | Unit | Test Standard |
| ISO Data | | | |
| Humidity absorption | 1.7 / * | % | Sim. to ISO 62 |
| Density | 1490 / - | kg/m ³ | ISO 1183 |
| Characteristics | | | |
| Processing | Additives | | |
| Injection Molding | Lubricants, Release agent | | |
| Delivery form | Special Characteristics | | |
| Pellets | Heat stabilized or stable to heat | | |

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PA6-(GF+MD)40

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Other text information

Injection Molding

[Injection Molding Recommendations](#)