

PARA – Polyaramide PARA GF60

AKROLOY® PARA GF 60 1 natural (6165)

Tensile modulus

24000 MPa

1 mm/min

ISO 527-2

Stress at break

320 MPa

5 mm/min

ISO 527-2

Charpy impact strength

80 kJ/m²

23°C

ISO 179-1/1eU

AKROLOY® PARA GF 60 1 natural (6165) is a 60% glass fibre reinforced polyarylamid with very high stiffness and strength, even in conditioned state.

Typical applications

Components with high dimensional stability, independent from moisture content. AKROLOY® PARA GF 60 is an alternative for aluminium- and zinc diecast alloys.



Mechanical Properties

Tensile modulus (1 mm/min | ISO 527-2)

d.a.m.

24000 MPa

conditioned

24000 MPa

Stress at break (5 mm/min | ISO 527-2)

d.a.m.

320 MPa

conditioned

290 MPa

Strain at break (5 mm/min | ISO 527-2)

d.a.m.

2,0 %

conditioned

2,0 %

Charpy impact strength (23°C | ISO 179-1/1eU)

d.a.m.

80 kJ/m²

conditioned

85 kJ/m²



Thermal Properties

Temperature of deflection under load HDT/C (8 MPa | ISO 75)

205 °C

Melt temperature (DSC, 10K/min | DIN EN 11357-1)

238 °C



Flammability

Burning rate (UL 94)

1,6mm Wall thickness

HB Class

Burning rate (<100 mm/min) (> 1 mm Thickness | FMVSS 302)

+



General properties

Density (23°C | ISO 1183)

1,76 g/cm³

Humidity absorption (70°C, 62% r.H. | ISO 1110)

0,7 %

Molding shrinkage (flow | ISO 294-4)

0,1-0,2 %

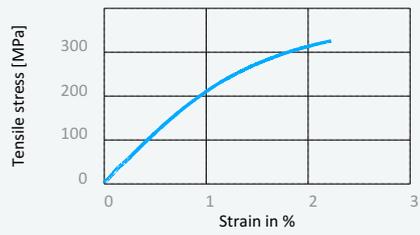
Molding shrinkage (transverse | ISO 294-4)

0,2-0,4 %

Disclaimer:

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Stress strain chart at 23°C



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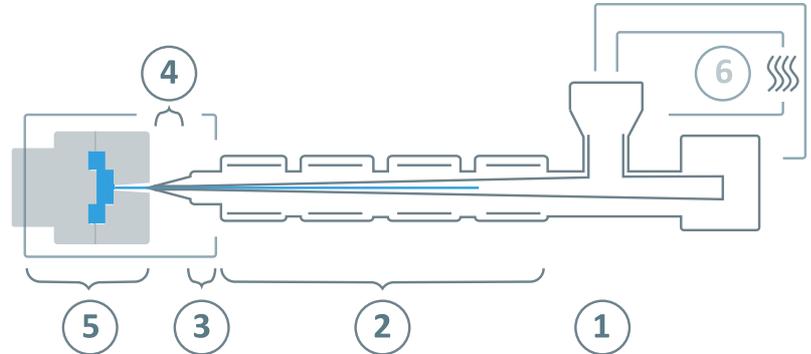
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Processing information

The listed values are recommendations. Higher values should be used for higher glass loadings. We recommend only dehumidifying or vacuum dryers. Extensive drying can cause filling problems and surface defects.



⑥	Drying time	4 - 12 h
	Drying temperature ($\tau \leq -30^\circ\text{C}$)	80 - 90°C
	Processing moisture	0,02 - 0,1%
①	Feed section	60 - 80°C
②	Temperature zone 1 - Zone 4	250 - 300°C
③	Nozzle temperature	270 - 300°C
④	Melt temperature	270 - 300°C
⑤	Mold temperature	120 - 160°C
→	Holding pressure, spec.	300 - 1500 bar
←	Back pressure, spec.	50 - 150 bar
	Injection speed	high
	Screw speed	8 - 10 m/min

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