

PA6 X GF50

## AKROMID® B+ GF 50 1 (7281)

Tensile modulus

**16500 MPa**

1 mm/min

ISO 527-2

Stress at break

**231 MPa**

5 mm/min

ISO 527-2

Charpy impact strength

**100 kJ/m<sup>2</sup>**

23°C

ISO 179-1/1eU

PA6 compound with enhanced mechanical properties in conditioned state to substitute PA 66 compounds

### Typical applications

Components in mechanical engineering and in the automotive industry



### Mechanical Properties

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

d.a.m.

16500 MPa

conditioned

10100 MPa

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

d.a.m.

231 MPa

conditioned

164 MPa

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

d.a.m.

3,4 %

conditioned

5,1 %

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

d.a.m.

100 kJ/m<sup>2</sup>

conditioned

110 kJ/m<sup>2</sup>

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

d.a.m.

22 kJ/m<sup>2</sup>

conditioned

28 kJ/m<sup>2</sup>

Charpy notched impact strength (-30°C | ISO 179-1/1eA)

d.a.m.

18 kJ/m<sup>2</sup>

conditioned

22 kJ/m<sup>2</sup>



### Thermal Properties

Temperature of deflection under load HDT/A (1,8 MPa | ISO 75)

218 °C

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

230 °C



### Flammability

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

+



### General properties

Density (23°C | ISO 1183)

1,56 g/cm<sup>3</sup>

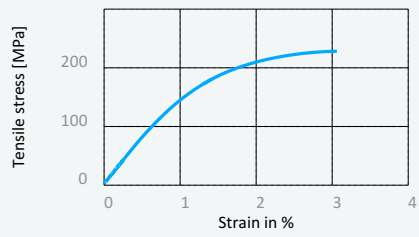
Humidity absorption (70°C, 62% r.H. | ISO 1110)

1,3-1,5 %

#### Disclaimer:

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Stress strain chart at 23°C



**Disclaimer:**

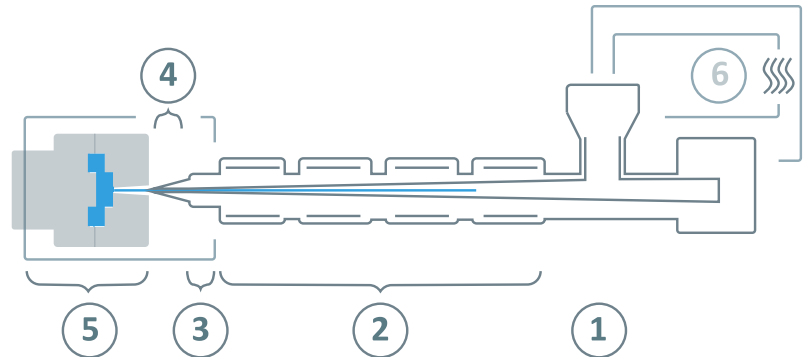
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### Processing information

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	0 - 4 h
	Drying temperature ( $\tau \leq -30^{\circ}\text{C}$ )	80°C
	Processing moisture	0,02 - 0,1%
①	Feed section	60 - 80°C
②	Temperature zone 1 - Zone 4	240 - 290°C
③	Nozzle temperature	260 - 300°C
④	Melt temperature	270 - 290°C
⑤	Mold temperature	80 - 100°C
→	Holding pressure, spec.	300 - 800 bar
←	Back pressure, spec.	50 - 150 bar
	Injection speed	medium to high
	Screw speed	8 - 15 m/min

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