

PA6 GF20

AKROMID® B+ GF 20 1 (7377)

Tensile modulus

6800 MPa

1 mm/min

ISO 527-2

Stress at break

145 MPa

5 mm/min

ISO 527-2

Charpy impact strength

23° C

ISO 179-1/1eU

Heat stabilized 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.

6800 MPa

conditioned

4400 MPa

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

d.a.m.

145 MPa

conditioned

95 MPa

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

d.a.m.

3 %

conditioned

8 %

Flexural modulus (2 mm/min | ISO 178)

d.a.m.

6500 MPa

Flexural strength (2 mm/min | ISO 178)

d.a.m.

225 MPa

Flexural strain at break (2 mm/min | ISO 178)

d.a.m.

5 %

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

d.a.m.

9 kJ/m²

conditioned

15 kJ/m²

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

d.a.m.

8 kJ/m²

Thermal Properties

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

210 °C

Temperature of deflection under load HDT/B (0,45 MPa | ISO 75)

218 °C

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

220 °C



General properties

Density (23° C | ISO 1183)

1,35 g/cm³

Molding shrinkage (flow | ISO 294-4)

0,1-0,3 %

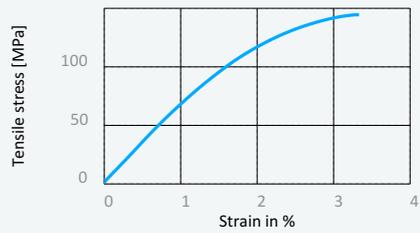
Molding shrinkage (transverse | ISO 294-4)

0,6-0,8 %

Disclaimer:

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Stress strain chart at 23°C



Rheological Properties

Flowability (2mm Thickness | AKRO)

620 mm

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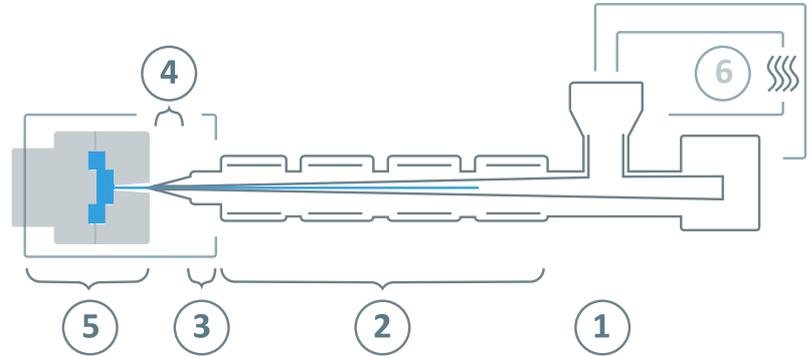
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Processing information

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	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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