

PA6 – Polyamide 6 PA6 GF30

## AKROMID® B+ GF 30 1 black (7378)

Tensile modulus

**9400 MPa**

1 mm/min

ISO 527-2

Stress at break

**170 MPa**

5 mm/min

ISO 527-2

Charpy impact strength

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

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.

9400 MPa

conditioned

6000 MPa

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

d.a.m.

170 MPa

conditioned

118 MPa

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

d.a.m.

3,8 %

conditioned

9 %

Flexural modulus (2 mm/min | ISO 178)

d.a.m.

9200 MPa

Flexural strength (2 mm/min | ISO 178)

d.a.m.

270 MPa

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

d.a.m.

4,3 %

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

d.a.m.

85 kJ/m<sup>2</sup>

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

d.a.m.

76 kJ/m<sup>2</sup>

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

d.a.m.

12 kJ/m<sup>2</sup>

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

d.a.m.

10 kJ/m<sup>2</sup>

### 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

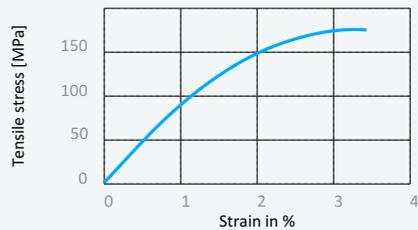
Melt temperature (DSC, 10K/min | DIN EN 11357-1)

220 °C

#### Disclaimer:

All specifications and information given on this website are based on our current knowledge and experience. A legally binding promise of certain characteristics or suitability for a concrete individual case cannot be derived from this information. The information supplied here is not intended to release processors and users from the responsibility of carrying out their own tests and inspections in each concrete individual case. AKRO®, AKROMID®, AKROLEN®, AKROLOY®, AKROTEK®, ICX® and PRECITE® are registered trademarks of the Feddersen Group.

Stress strain chart at 23°C



### General properties

Density (23°C   ISO 1183)	1,35 g/cm <sup>3</sup>
Humidity absorption (70°C, 62% r.H.   ISO 1110)	1,9-2,1 %
Molding shrinkage (flow   ISO 294-4)	0,1-0,3 %
Molding shrinkage (transverse   ISO 294-4)	0,6-0,8 %

#### Disclaimer:

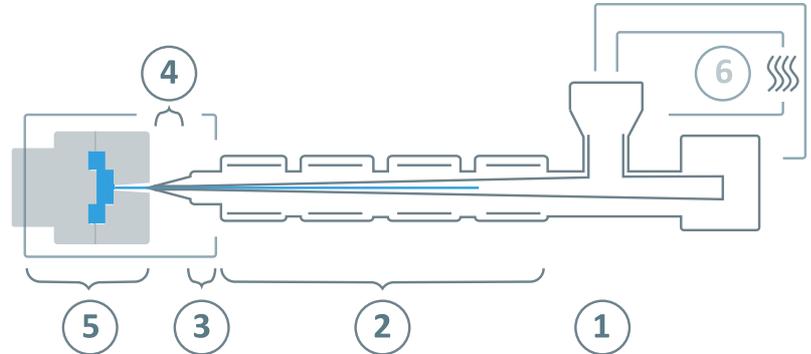
All specifications and information given on this website are based on our current knowledge and experience. A legally binding promise of certain characteristics or suitability for a concrete individual case cannot be derived from this information. The information supplied here is not intended to release processors and users from the responsibility of carrying out their own tests and inspections in each concrete individual case. AKRO®, AKROMID®, AKROLEN®, AKROLOY®, AKROTEK®, ICX® and PRECITE® are registered trademarks of the Feddersen Group.

PA6 – Polyamide 6 PA6 GF30

## AKROMID® B+ GF 30 1 black (7378)

### 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

#### Disclaimer:

All specifications and information given on this website are based on our current knowledge and experience. A legally binding promise of certain characteristics or suitability for a concrete individual case cannot be derived from this information. The information supplied here is not intended to release processors and users from the responsibility of carrying out their own tests and inspections in each concrete individual case. AKRO®, AKROMID®, AKROLEN®, AKROLOY®, AKROTEK®, ICX® and PRECITE® are registered trademarks of the Feddersen Group.