

PA6.6 – Polyamide 6.6 PA6 GF50

## AKROMID® B+ GF 50 1 black (7380)

Tensile modulus

**16500 MPa**

 1 mm/min  
ISO 527-2

Stress at break

**225 MPa**

 5 mm/min  
ISO 527-2

Charpy impact strength

**106 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.	16500 MPa
conditioned	9800 MPa
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Stress at break (5 mm/min   ISO 527-2)	
d.a.m.	225 MPa
conditioned	162 MPa
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Strain at break (5 mm/min   ISO 527-2)	
d.a.m.	3,5 %
conditioned	5 %
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Flexural modulus (2 mm/min   ISO 178)	
d.a.m.	16500 MPa
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Flexural strength (2 mm/min   ISO 178)	
d.a.m.	363 MPa
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Standard bending strength RP 3,5 (2 mm/min   ISO 178)	
d.a.m.	3,4 MPa
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Charpy impact strength (23°C   ISO 179-1/1eU)	
d.a.m.	106 kJ/m <sup>2</sup>
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Charpy impact strength (-30°C   ISO 179-1/1eU)	
d.a.m.	105 kJ/m <sup>2</sup>
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Charpy notched impact strength (23°C   ISO 179-1/1eA)	
d.a.m.	22 kJ/m <sup>2</sup>
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Charpy notched impact strength (-30°C   ISO 179-1/1eA)	
d.a.m.	17 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



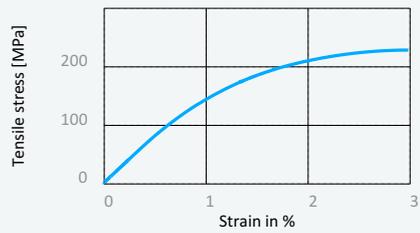
### General properties

Density (23°C   ISO 1183)	1,57 g/cm <sup>3</sup>
Molding shrinkage (flow   ISO 294-4)	0,1-0,2 %
Molding shrinkage (transverse   ISO 294-4)	0,5-0,7 %

#### Disclaimer:

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Stress strain chart at 23°C



**Disclaimer:**

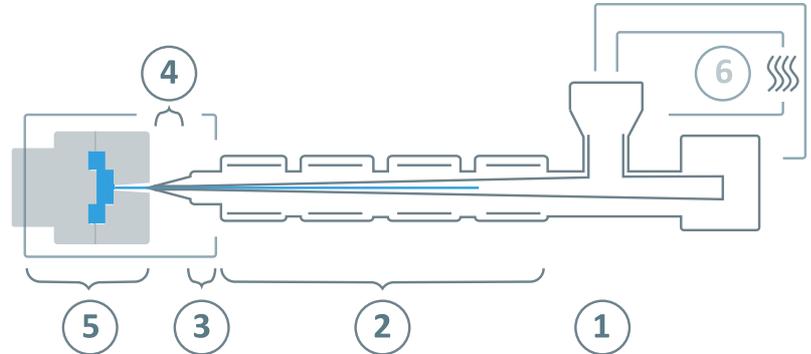
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### Processing information

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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