

PA6 – Polyamide 6 PA6 GF30

AKROMID® B+ GF 30 6 black (7387)

Tensile modulus

9500 MPa

1 mm/min

ISO 527-2

Stress at break

180 MPa

5 mm/min

ISO 527-2

Charpy impact strength

86 kJ/m²

23°C

ISO 179-1/1eU

High-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.

9500 MPa

conditioned

6000 MPa

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

d.a.m.

180 MPa

conditioned

118 MPa

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

d.a.m.

3,6 %

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

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

d.a.m.

86 kJ/m²

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

d.a.m.

72 kJ/m²

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

d.a.m.

14 kJ/m²

conditioned

19 kJ/m²

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

d.a.m.

11 kJ/m²

conditioned

11 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

Coefficient of linear thermal expansion, parallel

0,19 1,0E-4/K

(23°C bis 80°C | ISO 11359-1/2)

Coefficient of linear thermal expansion, transverse

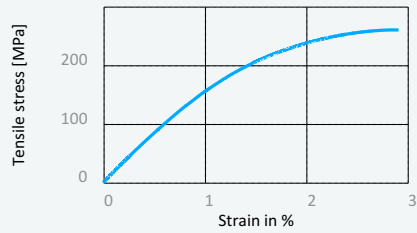
1,14 1,0E-4/K

(23°C bis 80°C | ISO 11359-1/2)

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Stress strain chart at 23°C



General properties

Density (23°C ISO 1183)	1,35 g/cm ³
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)	0,5-0,7 %



Rheological Properties

Flowability (2mm Thickness AKRO)	480 mm
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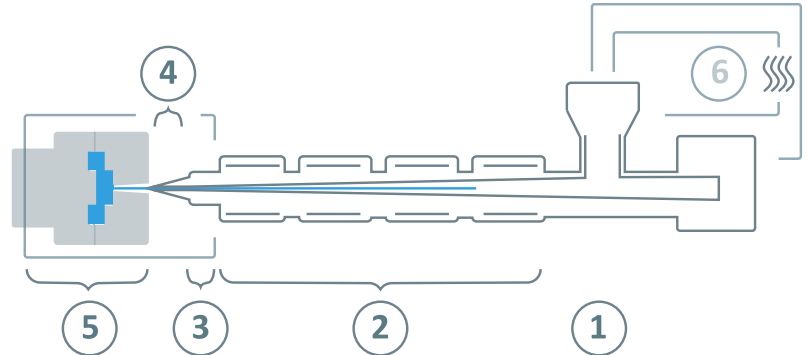
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Processing information

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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