

PA6 – Polyamide 6 PA6 GF60

**AKROMID® B+ GF 60 6 black (7390)**

Tensile modulus

**22000 MPa**

1 mm/min

ISO 527-2

Stress at break

**260 MPa**

5 mm/min

ISO 527-2

Charpy impact strength

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

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.

22000 MPa

conditioned

13000 MPa

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

d.a.m.

260 MPa

conditioned

170 MPa

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

d.a.m.

2,8 %

conditioned

4,5 %

Flexural modulus (2 mm/min | ISO 178)

d.a.m.

22000 MPa

Flexural strength (2 mm/min | ISO 178)

d.a.m.

425 MPa

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

d.a.m.

3 %

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

d.a.m.

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

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

d.a.m.

105 kJ/m<sup>2</sup>

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

d.a.m.

21 kJ/m<sup>2</sup>

conditioned

24 kJ/m<sup>2</sup>

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

d.a.m.

19 kJ/m<sup>2</sup>

conditioned

20 kJ/m<sup>2</sup>**Thermal Properties**

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

218 °C

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

218 °C

Temperature of deflection under load HDT/C (8 MPa | ISO 75)

190 °C

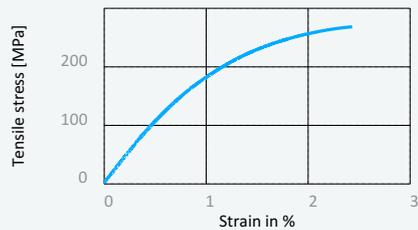
Melt temperature (DSC, 10K/min | DIN EN 11357-1)

220 °C

**Disclaimer:**

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Stress strain chart at 23°C



### General properties

Density (23°C   ISO 1183)	1,69 g/cm <sup>3</sup>
Humidity absorption (70°C, 62% r.H.   ISO 1110)	1,0-1,2 %
Molding shrinkage (flow   ISO 294-4)	0,1-0,2 %
Molding shrinkage (transverse   ISO 294-4)	0,3-0,5 %



### Rheological Properties

Flowability (2mm Thickness   AKRO)	320 mm
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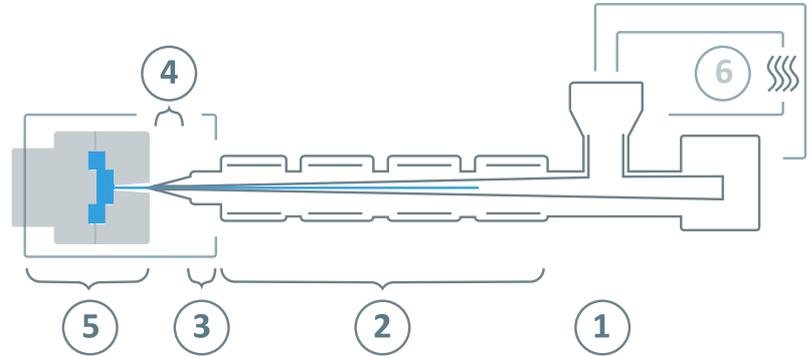
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### Processing information

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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