

PA6 – Polyamide 6 PA6 GF35

AKROMID® B+ GF 35 6 black (7544)

Tensile modulus

11200 MPa

1 mm/min

ISO 527-2

Stress at break

190 MPa

5 mm/min

ISO 527-2

Charpy impact strength

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.

11200 MPa

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

d.a.m.

190 MPa

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

d.a.m.

3,2 %



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

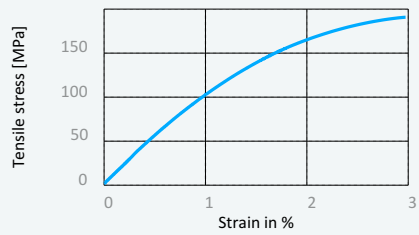


General properties

Disclaimer:

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Stress strain chart at 23°C



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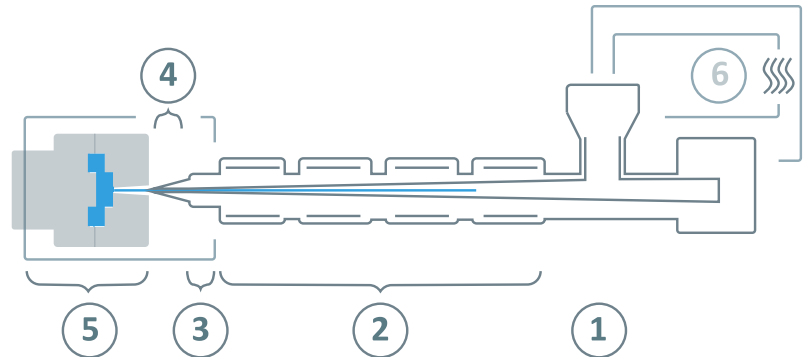
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Processing information

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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