

PA6.6 – Polyamide 6.6 PA66 + PA6I/6T GF50

## AKROLOY® PA GF 50 natural (7573)

Tensile modulus

**17000 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

AKROLOY® PA GF 50 natural (7573) is a 50% glass fibre reinforced, semi-aromatic polyamide blend with very high stiffness and strength, even in conditioned state.

This product is especially equipped for high laser transparency for laser welding.

### Typical applications

Components with high dimensional stability, independent from moisture content. AKROLOY® PA GF 50 is an alternative for aluminium- and zinc diecast alloys.



### Mechanical Properties

Tensile modulus (1 mm/min | ISO 527-2)

d.a.m.

17000 MPa

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

d.a.m.

260 MPa

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

d.a.m.

3 %

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

d.a.m.

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

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

d.a.m.

18 kJ/m<sup>2</sup>



### Thermal Properties

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

245 °C



### Flammability

Burning rate (UL 94)

1,6mm Wall thickness

HB Class



### General properties

Density (23°C | ISO 1183)

1,57 g/cm<sup>3</sup>

#### Disclaimer:

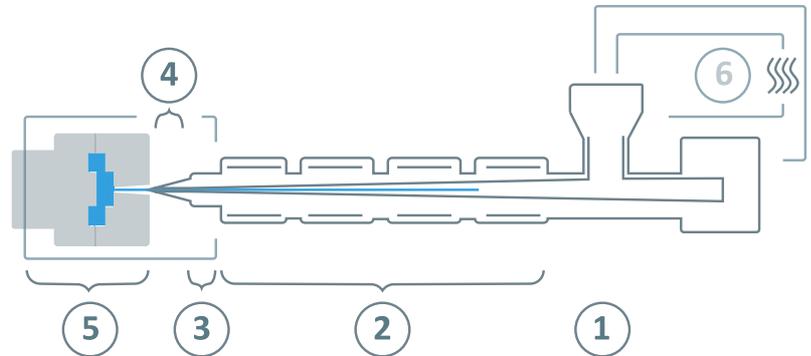
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### Processing information

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	260 - 300°C
③	Nozzle temperature	270 - 300°C
④	Melt temperature	280 - 300°C
⑤	Mold temperature	90 - 130°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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