

AKROLOY® PRELIMINARY

PA GF 60 LA black (8168)

PA66 + PA6I/6T GF60

AKROLOY® PA GF 60 LA black (8168) is a 60% glass fibre reinforced, semi-aromatic polyamide-blend with very high stiffness and strength, even in conditioned state.

Features

laser markable

Properties

Modulus

21.400 MPa

Strength

275 MPa

Impact

95 kJ/m²

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

21400 MPa

Tensile stress at break

ISO 527-2

5 mm/min | d.a.m.

275 MPa

Tensile strain at break

ISO 527-2

5 mm/min | d.a.m.

2,2 %

Charpy impact strength

ISO 179-1/1eU

23°C | d.a.m.

95 kJ/m²

Charpy notched impact strength

ISO 179-1/1eA

23°C | d.a.m.

18 kJ/m²

Thermal Properties

Melting temperature

ISO 11357-3

DSC, 10K/min

255 °C

Flammability

Flammability

UL 94

0,8 mm Wall thickness

HB Class

General Properties

Density

ISO 1183

23°C

1,72 g/cm³

Humidity absorption

ISO 1110

70°C, 62% r.H.

1,1 %

Processing

The values mentioned are recommendations. We only recommend desiccant / dry air dryers or vacuum dryers. Too long a drying time and the resulting residual moisture content below the lower limit can lead to filling problems and surface defects. The specified drying time refers to closed and undamaged bagged material. When processing from previously opened bags or from octabins with polyolefin inliners, a longer drying time may be necessary. It is recommended to check the residual moisture content after the drying process.



D	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