+135-3858-6433 (GuangDong)
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AKRO COMPOUNDS

Compound No.: **6414**

AKROLOY®
PA GF 50 natural (6414)

PA66+PA6I/6T GF50

AKROLOY® PA GF 50 natural (6414) is a 50% glass fibre reinforced, semi-aromatic polyamide blend with very high stiffness and strength, even in conditioned state.

Features

reduced moisture | metal substitution

Properties

Modulus	Strength	Impact
17.000 MPa	**275** MPa	**110** kJ/m²

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min | d.a.m.	**17000 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.	**2,8 %**
Charpy impact strength ISO 179-1/1eU	23°C | d.a.m.	**110 kJ/m²**

Thermal Properties

Temperature of deflection under load HDT/A ISO 75	1,8 MPa	**245 °C**
Temperature of deflection under load HDT/C ISO 75	8 MPa	**185 °C**
Melting temperature ISO 11357-3	DSC, 10K/min	**255 °C**

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General Properties

Density ISO 1183	23°C	**1,56 g/cm³**
Molding shrinkage ISO 294-4	flow	**0,1 - 0,3 %**
	transverse	**0,3 - 0,5 %**

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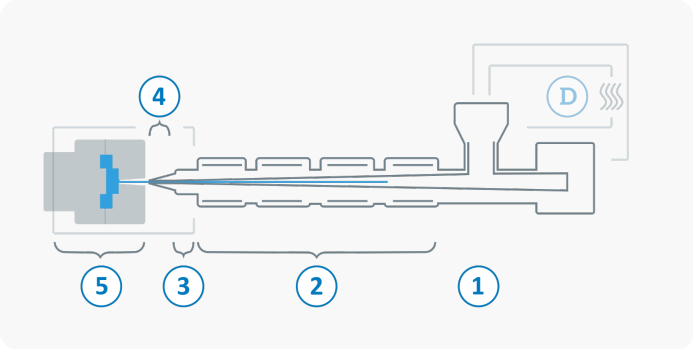
Processing

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 (τ <= -30°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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Diagrams