

**AKROLOY® PA GF 40 natural (6413)**

(PA66+PA6I/6T)-GF40

Akro-Plastic GmbH

**Product Texts**

Alternative for aluminium- and zinc diecast alloys.

**Processing/Physical Characteristics**

	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Molding shrinkage, parallel	<b>0.3</b>	%	ISO 294-4, 2577
Molding shrinkage, normal	<b>0.8</b>	%	ISO 294-4, 2577

**Mechanical properties**

	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Tensile Modulus	<b>13000</b>	MPa	ISO 527
Stress at break	<b>235</b>	MPa	ISO 527
Strain at break	<b>2.9</b>	%	ISO 527
Flexural modulus, 23°C	<b>12500</b>	MPa	ISO 178
Flexural strength	<b>330</b>	MPa	ISO 178
Charpy impact strength, +23°C	<b>95</b>	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	<b>15</b>	kJ/m <sup>2</sup>	ISO 179/1eA

**Thermal properties**

	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Melting temperature, 10°C/min	<b>255</b>	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	<b>237</b>	°C	ISO 75-1/-2
Temp. of deflection under load, 8.00 MPa	<b>173</b>	°C	ISO 75-1/-2

**Other properties**

	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Density	<b>1470</b>	kg/m <sup>3</sup>	ISO 1183

**Processing Recommendation Injection Molding**

	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Melt temperature	<b>320</b>	°C	-
Mold temperature	<b>100</b>	°C	-
Injection pressure	<b>75</b>	MPa	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

Europe, Asia Pacific

**Delivery form**

Natural Color