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AKRO COMPOUNDS

Compound No.: **8444**

AKROMID® PRELIMINARY
NEXT 5.6 3 GF 30 S3 black (8444)

PA56 GF30

The partly bio-based AKROMID® NEXT 5.6 3 GF 30 S3 black (8444) is a HMD-free (hexamethylenediamine) alternative to PA 6.6. The dry-impact modified PA 5.6 with 30% glass fibre reinforcement is suitable for components with requirements on high strength and stiffness.

Features

Bio-based | heat stabilised 130 | impact modified | Sports & leisure

Properties

Modulus	Strength	Impact
8.600 MPa	180 MPa	96 kJ/m²

Sustainability

Biobased carbon content	**35 %**

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min | d.a.m. 1 mm/min | conditioned	**8600 MPa** **5700 MPa**
Tensile stress at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**180 MPa** **115 MPa**
Tensile strain at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**3,5 %** **8 %**
Charpy impact strength ISO 179-1/1eU	23°C | d.a.m. 23°C | conditioned	**96 kJ/m²** **98 kJ/m²**
Charpy notched impact strength ISO 179-1/1eA	23°C | d.a.m. 23°C | conditioned	**15 kJ/m²** **22 kJ/m²**

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Thermal Properties

Melting temperature ISO 11357-3	DSC, 10K/min	**254 °C**

General Properties

Density ISO 1183	23°C	**1,32 g/cm³**

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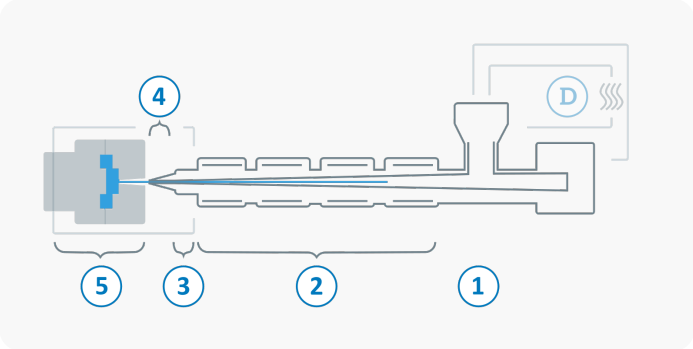
Processing

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 - 310 °C
4	Melt temperature	280 - 300 °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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Diagrams