

AKROMID® PRELIMINARY

A28 GF 33 1 LA black (6686)

PA66 GF33

AKROMID® A28 GF 33 1 LA black (6686) is a 33% glass fiber reinforced, easy flowing polyamide 6.6. The material is characterised by good processability due to its very good flowability. Owing to its high stiffness and strength, it is perfectly suitable for technical parts in industrial engineering and in the automotive industry. The compound is laser markable.

Features

heat stabilised 130 laser markable easy flow

Properties

Modulus

11.000 MPa

Strength

205 MPa

Impact

85 kJ/m²

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

11000 MPa

Tensile stress at break

ISO 527-2

5 mm/min | d.a.m.

205 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.

85 kJ/m²

Charpy notched impact strength

ISO 179-1/1eA

23°C | d.a.m.

14 kJ/m²

Thermal Properties

Melting temperature

ISO 11357-3

DSC, 10K/min

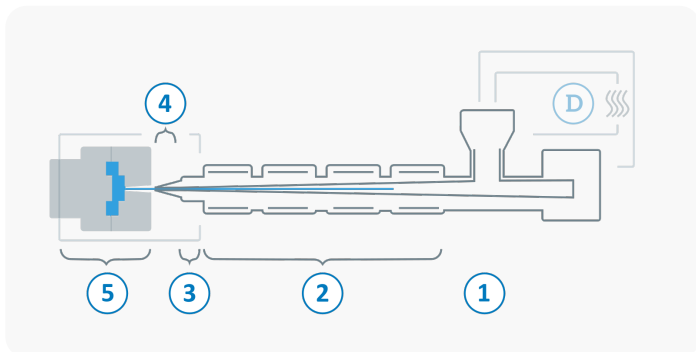
262 °C

General Properties

Density ISO 1183	23°C	1,37 g/cm ³
Humidity absorption ISO 1110	70°C, 62% r.H.	1,9 - 2,1 %
Water absorption ISO 62	23°C, saturated	5,2 - 5,7 %
Molding shrinkage ISO 294-4	flow	0,1 - 0,3 %
	transverse	0,7 - 0,9 %

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 - 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

Diagrams

