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AKRO COMPOUNDS

Compound No.: **7278**

AKROMID®
A28 GF 35 6 black (7278)

PA66 GF35

AKROMID® A28 GF 35 6 black (7278) is a 35% glass fiber reinforced, easy-flowing, inorganically highly heat-stabilized polyamide 6.6. The material is characterized by easy processability due to its very good flowability. Its high rigidity and strength make it the material of choice for technical components in mechanical engineering and the automotive industry.

Features

laser markable | easy flow

Properties

Modulus	Strength	Impact
11.500 MPa	**210** MPa	**85** kJ/m²

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min | d.a.m. 1 mm/min | conditioned	**11500 MPa** **8300 MPa**
Tensile stress at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**210 MPa** **140 MPa**
Tensile strain at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**3 %** **5 %**
Charpy impact strength ISO 179-1/1eU	23°C | d.a.m. 23°C | conditioned	**85 kJ/m²** **95 kJ/m²**
Charpy notched impact strength ISO 179-1/1eA	23°C | d.a.m. 23°C | conditioned	**15 kJ/m²** **20 kJ/m²**

Thermal Properties

Melting temperature ISO 11357-3	DSC, 10K/min	**262 °C**

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Flammability

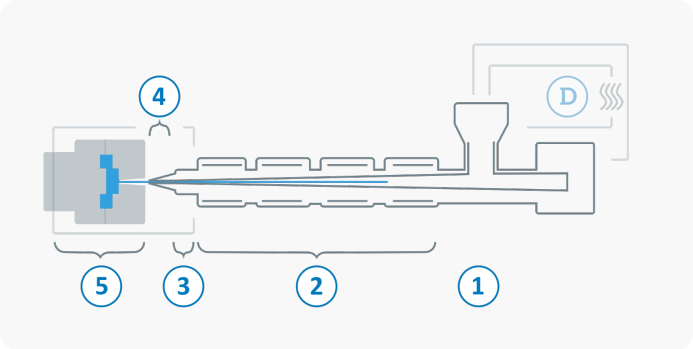
Burning rate (<100 mm/min) FMVSS 302	> 1 mm Thickness	+

General Properties

Density ISO 1183	23°C	**1,4 g/cm³**
Humidity absorption ISO 1110	70°C, 62% r.H.	**1,8 - 2,0 %**
Molding shrinkage ISO 294-4	flow transverse	**0,1 - 0,3 %** **0,65 - 0,85 %**

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

Diagrams