

AKROMID® PRELIMINARY

A3 black (7557)

PA66

AKROMID® A3 black (7557) is an unreinforced polyamide 6.6 which is characterized by an improved UV resistance compared to standard PA6.6. Furthermore, it shows good flowability and is particularly suitable for connecting and fixing elements for outdoor applications.

Properties

Modulus

3.000 MPa

Strength

80 MPa

Impact

180 kJ/m²

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

3000 MPa

1 mm/min | conditioned

1100 MPa

Tensile stress at yield

ISO 527-2

50 mm/min | d.a.m.

80 MPa

50 mm/min | conditioned

45 MPa

Tensile strain at break

ISO 527-2

50 mm/min | d.a.m.

> 15 %

50 mm/min | conditioned

> 25 %

Charpy impact strength

ISO 179-1/1eU

23°C | d.a.m.

no break

23°C | conditioned

no break

-30°C | d.a.m.

no break

-30°C | conditioned

no break

Charpy notched impact strength

ISO 179-1/1eA

23°C | d.a.m.

4 kJ/m²

23°C | conditioned

21 kJ/m²

Thermal Properties

Temperature of deflection under load HDT/A

ISO 75

1,8 MPa

65 °C

Temperature of deflection under load HDT/B ISO 75	0,45 MPa	210 °C
Temperature of deflection under load HDT/C ISO 75	8 MPa	45 °C
Melting temperature ISO 11357-3	DSC, 10K/min	260 °C

Flammability

Flammability UL 94	1,6 mm Wall thickness	HB Class
Burning rate (<100 mm/min) FMVSS 302	> 1 mm Thickness	+

General Properties

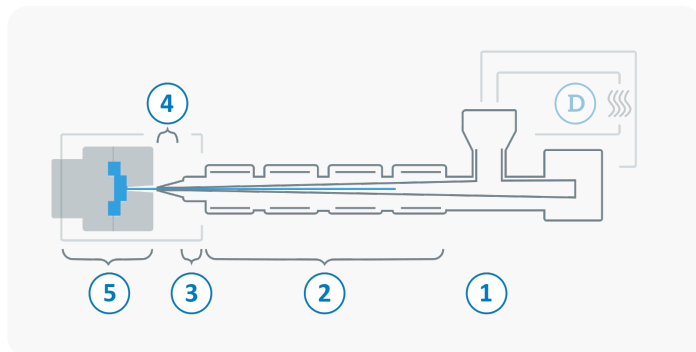
Density ISO 1183	23°C	1,14 g/cm³
Humidity absorption ISO 1110	70°C, 62% r.H.	2,9 %
Molding shrinkage ISO 294-4	flow transverse	1,3 - 1,5 % 1,5 - 1,7 %

Rheological Properties

Flowability AKRO	1 mm Thickness 2 mm Thickness	310 mm 980 mm
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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	2 - 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	270 - 300 °C
5	Mold temperature	40 - 90 °C
→	Holding pressure, spec.	300 - 800 bar
←	Back pressure, spec.	50 - 150 bar
	Injection speed	medium to high
	Screw speed	8 - 15 m/min