

AKROMID®

A3 GF 30 6 black (6736)

PA66 GF30

AKROMID® A3 GF 30 6 black (6736) is a 30% glass fiber reinforced polyamide 6.6. It is characterised by high stiffness and strength. Furthermore, the material is anorganically heat stabilised and therefore perfectly suitable for technical parts in industrial engineering and in the automotive industry which are exposed to higher temperatures.

Features

heat stabilised 160

Properties

Modulus

10.000 MPa

Strength

200 MPa

Impact

75 kJ/m²

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

10000 MPa

Tensile stress at break

ISO 527-2

5 mm/min | d.a.m.

200 MPa

Tensile strain at break

ISO 527-2

5 mm/min | d.a.m.

3,2 %

Charpy impact strength

ISO 179-1/1eU

23°C | d.a.m.

75 kJ/m²

Thermal Properties

Temperature of deflection under load HDT/A

ISO 75

1,8 MPa

255 °C

Melting temperature

ISO 11357-3

DSC, 10K/min

262 °C

Temperature index for 50% loss of tensile strength

IEC 60216

5.000 h

165 °C

Flammability

Burning rate (<100 mm/min)

FMVSS 302

> 1 mm Thickness

+

General Properties

Density

ISO 1183

23°C

1,36 g/cm³

Humidity absorption

ISO 1110

70°C, 62% r.H.

1,9 - 2,1 %

Molding shrinkage

ISO 294-4

flow

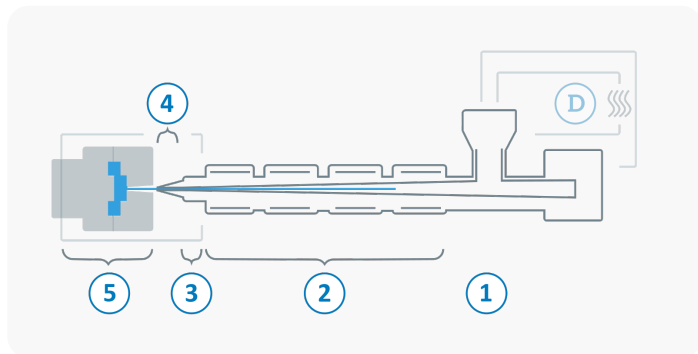
0,1 - 0,3 %

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

