

AKROMID®

A3 GK 30 black (2306)

PA66 GB30

AKROMID® A3 GK 30 black (2306) is a PA 6.6 filled with 30% glass beads. It is characterized by a high surface quality and low tendency to warp, which makes it suitable for use in technically demanding components in mechanical engineering and in the automotive industry.

Features

low warpage

Properties

Modulus

5.000 MPa

Strength

90 MPa

Impact

28 kJ/m²

Sustainability

Recycled content 30 %

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

5000 MPa

Tensile stress at break

ISO 527-2

5 mm/min | d.a.m.

90 MPa

Tensile strain at break

ISO 527-2

5 mm/min | d.a.m.

4 %

Flexural modulus

ISO 178

2 mm/min | d.a.m.

4300 MPa

Flexural strength

ISO 178

2 mm/min | d.a.m.

140 MPa

Flexural strain at break

ISO 178

2 mm/min | d.a.m.

6,5 %

Charpy impact strength

ISO 179-1/1eU

23°C | d.a.m.

28 kJ/m²

-30°C | d.a.m.

22 kJ/m²

Charpy notched impact strength

ISO 179-1/1eA

23°C | d.a.m.

4 kJ/m²

-30°C | d.a.m.

3 kJ/m²

Thermal Properties

Temperature of deflection under load HDT/A

ISO 75

1,8 MPa

100 °C

Temperature of deflection under load HDT/B

ISO 75

0,45 MPa

225 °C

Melting temperature

ISO 11357-3

DSC, 10K/min

262 °C

Flammability

Flammability

UL 94

1,6 mm Wall thickness

HB Class

GWFI

IEC 60695-2-12

1,6 mm Wall thickness

650 °C

Burning rate (<100 mm/min)

FMVSS 302

> 1 mm Thickness

+

General Properties

Density

ISO 1183

23°C

1,35 g/cm³

Humidity absorption

ISO 1110

70°C, 62% r.H.

2,0 %

Molding shrinkage

ISO 294-4

flow

1,1 %

transverse

1,3 %

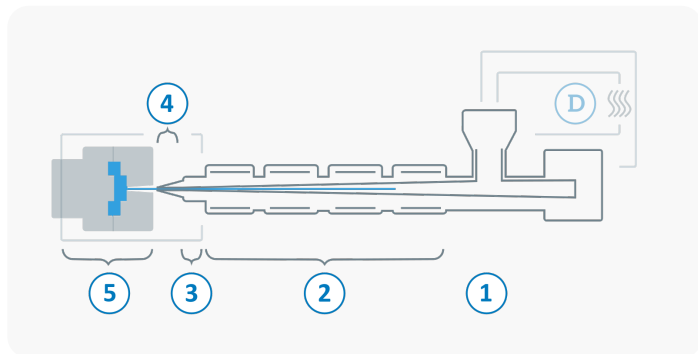
Electrical Properties

Surface resistivity IEC 62631-3-2	d.a.m.	10¹³ Ω
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Comparative tracking index IEC 60112	Test liquid A	500 V
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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 ($\tau \leq -30^{\circ}\text{C}$)	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