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AKRO COMPOUNDS

Compound No.: **6774**

AKROMID®
A3 GK 30 6 natural (6774)

PA66 GB30

AKROMID® A3 GK 30 6 natural (6774) is a 30% glass beads filled and inorganic high temperature stabilised PA6.6. 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

heat stabilised 160 | recycled content | low warpage

Properties

Modulus	Strength	Impact
4.600 MPa	**90** MPa	**25** kJ/m²

Sustainability

Recycled content	**30 %**

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min | d.a.m. 1 mm/min | conditioned	**4600 MPa** **2000 MPa**
Tensile stress at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**90 MPa** **52 MPa**
Tensile strain at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**>= 4 %** **25 %**
Flexural modulus ISO 178	2 mm/min | d.a.m. 2 mm/min | conditioned	**4400 MPa** **2000 MPa**
Flexural strength ISO 178	2 mm/min | d.a.m. 2 mm/min | conditioned	**135 MPa** **70 MPa**

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Flexural strain at break ISO 178	2 mm/min | d.a.m. 2 mm/min | conditioned	**8 %** **14 %**
Charpy impact strength ISO 179-1/1eU	23°C | d.a.m. 23°C | conditioned	**25 kJ/m²** **170 kJ/m²**
Charpy notched impact strength ISO 179-1/1eA	23°C | d.a.m. 23°C | conditioned	**4,5 kJ/m²** **5 kJ/m²**

Thermal Properties

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

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 transverse	**1,1 %** **1,3 %**

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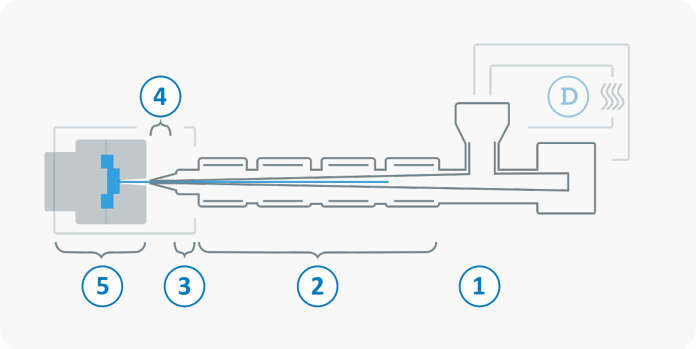
Processing

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 (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