+135-3858-6433 (GuangDong)
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AKRO COMPOUNDS

Compound No.: **7367**

AKROMID®
C28 GFM 10/20 5 XTC black (7367)

PA66+PA6 (GF10+MD20)

AKROMID® C28 GFM 10/20 5 XTC black (7367) is a 10% glass fiber and 20% mineral reinforced, easy flowing polyamide 6.6/6 blend. It is characterised by excellent temperature resistance as well as a very high surface quality. Furthermore, the material impresses with low warpage, resulting in high dimensional stability. It is therefore perfectly suitable for parts in industrial engineering and in the automotive industry, e.g. under the hood, which are exposed to high temperatures.

Features

heat stabilised 230 | surface modified | low warpage | easy flow

Properties

Modulus	Strength	Impact
9.500 MPa	**120** MPa	**40** kJ/m²

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min | d.a.m. 1 mm/min | conditioned	**9500 MPa** **6000 MPa**
Tensile stress at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**120 MPa** **80 MPa**
Tensile strain at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**2,5 %** **7 %**
Flexural modulus ISO 178	2 mm/min | d.a.m. 2 mm/min | conditioned	**8500 MPa** **4300 MPa**
Flexural strength ISO 178	2 mm/min | d.a.m. 2 mm/min | conditioned	**180 MPa** **110 MPa**
Flexural strain at break ISO 178	2 mm/min | d.a.m. 2 mm/min | conditioned	**3 %** **8 %**
Charpy impact strength ISO 179-1/1eU	23°C | d.a.m. 23°C | conditioned	**40 kJ/m²** **60 kJ/m²**

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Charpy notched impact strength ISO 179-1/1eA	23°C | d.a.m. 23°C | conditioned	**4 kJ/m²** **6 kJ/m²**

Thermal Properties

Temperature of deflection under load HDT/A ISO 75	1,8 MPa	**225 °C**
Melting temperature ISO 11357-3	DSC, 10K/min	**245 °C**
Coefficient of linear thermal expansion ISO 11359-1/2	23°C to 80°C | parallel 23°C to 80°C | transverse	**0,3 10^{-4}/K** **0,98 10^{-4}/K**

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	**1,38 g/cm³**
Humidity absorption ISO 1110	70°C, 62% r.H.	**1,7 %**
Molding shrinkage ISO 294-4	flow transverse	**0,4 - 0,6 %** **0,7 - 0,9 %**

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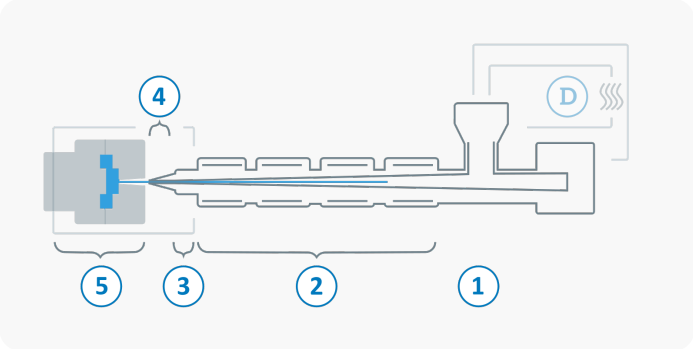
Processing

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 - 300 °C
4	Melt temperature	270 - 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