

AKROMID®

C3 GFM 15/25 1 black (6653)

PA66+PA6 (GF15+M25)

AKROMID® C3 GFM 15/25 1 black (6653) is a glass fibre reinforced, mineral-filled, heat stabilised polyamide 6.6/6 blend for appealing surfaces and dimensional stability

Features

heat stabilised 130 surface modified low warpage

Properties

Modulus

8.000 MPa

Strength

120 MPa

Impact

50 kJ/m²

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

8000 MPa

1 mm/min | conditioned

4500 MPa

Tensile stress at break

ISO 527-2

5 mm/min | d.a.m.

120 MPa

5 mm/min | conditioned

70 MPa

Tensile strain at break

ISO 527-2

5 mm/min | d.a.m.

3 %

5 mm/min | conditioned

15 %

Charpy impact strength

ISO 179-1/1eU

23°C | d.a.m.

50 kJ/m²

23°C | conditioned

85 kJ/m²

Charpy notched impact strength

ISO 179-1/1eA

23°C | d.a.m.

5 kJ/m²

23°C | conditioned

7 kJ/m²

Thermal Properties

Temperature of deflection under load HDT/A

ISO 75

1,8 MPa

230 °C

Melting temperature

ISO 11357-3

DSC, 10K/min

262 °C

Flammability

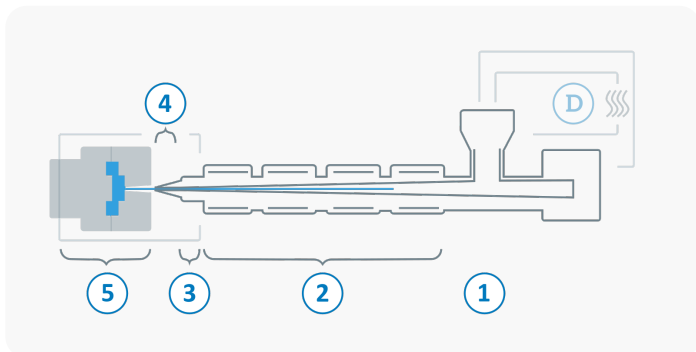
Flammability UL 94	1,6 mm Wall thickness	HB Class
Burning rate (<100 mm/min) FMVSS 302	> 1 mm Thickness	+

General Properties

Density ISO 1183	23°C	1,45 g/cm³
Humidity absorption ISO 1110	70°C, 62% r.H.	1,7 %
Molding shrinkage ISO 294-4	flow	0,3 - 0,5 %
	transverse	0,9 - 1,0 %

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 - 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