

Compound No.: 5657

# AKROMID® PRELIMINARY C3 GF 30 8 black (5657)

PA66 + PA6 GF30

AKROMID® C3 GF 30 8 black (5657) is 30% glass fiber reinforced PA6.6/6 Blend with average rigidity and strength. The material corresponds to the European food guideline EU 10/2011 and to the American FDA 21 CFR. This grade is suitable for parts of kitchen and household appliances.

#### Regulatory





#### **Properties**

Modulus	Strength	Impact
<b>9.400</b> MPa	<b>190</b> MPa	<b>82</b> kJ/m²

## **Mechanical Properties**

Tensile modulus ISO 527-2	1 mm/min   d.a.m.	9400 MPa
Tensile stress at break ISO 527-2	5 mm/min   d.a.m.	190 MPa
Tensile strain at break ISO 527-2	5 mm/min   d.a.m.	3,5 %
Charpy impact strength ISO 179-1/1eU	23°C   d.a.m.	82 kJ/m²

## **Thermal Properties**

Melting temperature		
ISO 11357-3	DSC, 10K/min <b>26</b> 6	0°C

## **Flammability**



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

## **General Properties**

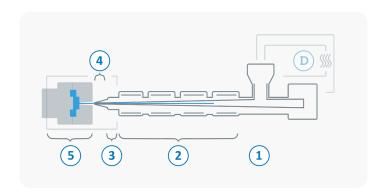
Density ISO 1183	23°C	1,36 g/cm³
Molding shrinkage ISO 294-4	flow transverse	0,1 - 0,3 % 0,6 - 0,8 %



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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
$\bigcirc$	Holding pressure, spec.	300 - 800 bar
	Back pressure, spec.	50 - 150 bar
	Injection speed	medium to high
	Screw speed	8 - 15 m/min