

# 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

9.400 MPa

#### Strength

190 MPa

#### Impact

82 kJ/m<sup>2</sup>

## 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/m<sup>2</sup>

## Thermal Properties

### Melting temperature

ISO 11357-3

DSC, 10K/min

260 °C

## Flammability

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**Flammability**

UL 94

1,6 mm Wall thickness

**HB Class**

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**Burning rate (<100 mm/min)**

FMVSS 302

> 1 mm Thickness

**+**

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**General Properties**

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**Density**

ISO 1183

23°C

**1,36 g/cm<sup>3</sup>**

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**Molding shrinkage**

ISO 294-4

flow

**0,1 - 0,3 %**

transverse

**0,6 - 0,8 %**

## 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.



<b>D</b>	Drying time	0 - 4 h
	Drying temperature ( $\tau \leq -30^{\circ}\text{C}$ )	80 °C
	Processing moisture	0,02 - 0,1 %
<b>1</b>	Feed section	60 - 80 °C
<b>2</b>	Temperature Zone 1 - Zone 4	260 - 300 °C
<b>3</b>	Nozzle temperature	270 - 300 °C
<b>4</b>	Melt temperature	270 - 300 °C
<b>5</b>	Mold temperature	80 - 100 °C
<b>→</b>	Holding pressure, spec.	300 - 800 bar
<b>←</b>	Back pressure, spec.	50 - 150 bar
	Injection speed	medium to high
	Screw speed	8 - 15 m/min