

AKROMID®

C28 M 30 6 black (7934)

PA66+PA6 MD30

AKROMID® C28 M 30 6 black (7934) is a 30% mineral filled, high heat stabilized polyamid 6.6/6 with very good surface low warpage and easy flow.

Features

heat stabilised 160 surface modified low warpage easy flow

Properties

Modulus

6.000 MPa

Strength

70 MPa

Impact

30 kJ/m²

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

6000 MPa

1 mm/min | conditioned

3000 MPa

Tensile stress at break

ISO 527-2

5 mm/min | d.a.m.

70 MPa

50 mm/min | d.a.m.

70 MPa

50 mm/min | conditioned

45 MPa

Tensile strain at break

ISO 527-2

5 mm/min | d.a.m.

3 %

50 mm/min | d.a.m.

3 %

50 mm/min | conditioned

20 %

Charpy impact strength

ISO 179-1/1eU

23°C | d.a.m.

30 kJ/m²

Thermal Properties

Melting temperature

ISO 11357-3

DSC, 10K/min

260 °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

1,39 g/cm³

Humidity absorption

ISO 1110

70°C, 62% r.H.

1,6 - 1,8 %

Molding shrinkage

ISO 294-4

flow

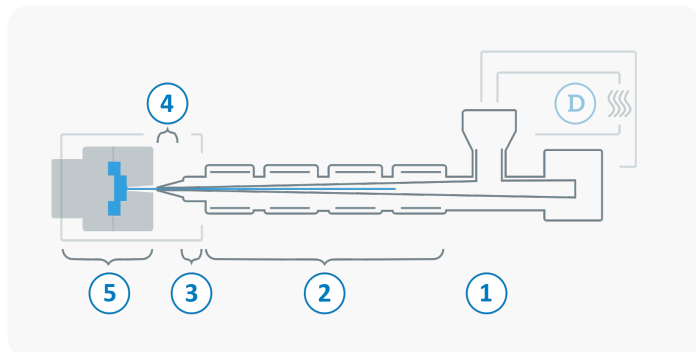
0,9 - 1,1 %

transverse

1,1 - 1,3 %

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	40 - 80 °C
→	Holding pressure, spec.	300 - 800 bar
←	Back pressure, spec.	50 - 150 bar
	Injection speed	medium to high
	Screw speed	8 - 15 m/min