

PA6.6 – Polyamide 6.6 PA66-I

## AKROMID® A3 1 S3 black (21002)

Tensile modulus

**2300 MPa**

1 mm/min

ISO 527-2

Stress at yield

**60 MPa**

50 mm/min

ISO 527-2

Charpy impact strength

**n.b.**

23°C

ISO 179-1/1eU

AKROMID® A3 1 S3 black (21002) is an unreinforced, heat stabilised, medium dry impact resistant polyamide 6.6.

### Typical applications

Connecting and fixing systems, used at elevated temperatures in the automotive and electro industry



### Mechanical Properties

Tensile modulus (1 mm/min | ISO 527-2)

d.a.m.

2300 MPa

conditioned

800 MPa

Stress at yield (50 mm/min | ISO 527-2)

d.a.m.

60 MPa

conditioned

40 MPa

Strain at break (50 mm/min | ISO 527-2)

d.a.m.

45 %

conditioned

&gt; 200 %

Charpy impact strength (23°C | ISO 179-1/1eU)

d.a.m.

n.b.

conditioned

n.b.

Charpy notched impact strength (23°C | ISO 179-1/1eA)

d.a.m.

16 kJ/m<sup>2</sup>

conditioned

100 kJ/m<sup>2</sup>

Charpy notched impact strength (-30°C | ISO 179-1/1eA)

d.a.m.

12 kJ/m<sup>2</sup>

### Thermal Properties

Temperature of deflection under load HDT/A (1,8 MPa | ISO 75)

60 °C

Melt temperature (DSC, 10K/min | DIN EN 11357-1)

262 °C



### Flammability

Burning rate (UL 94)

1,6mm Wall thickness

HB Class



### General properties

Density (23°C | ISO 1183)

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

Humidity absorption (70°C, 62% r.H. | ISO 1110)

2 %

Molding shrinkage (flow | ISO 294-4)

1,3-1,5 %

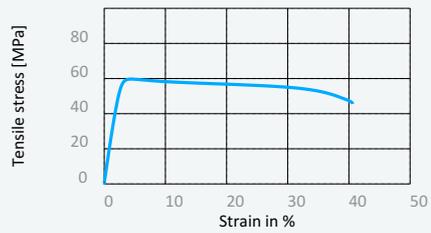
Molding shrinkage (transverse | ISO 294-4)

1,5-1,7 %

#### Disclaimer:

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Stress strain chart at 23°C



**Disclaimer:**

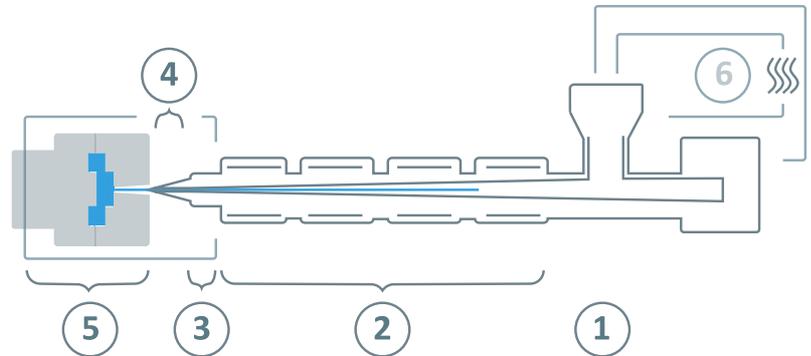
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### Processing information

The listed values are recommendations. Higher values should be used for higher glass loadings. We recommend only dehumidifying or vacuum dryers. Extensive drying can cause filling problems and surface defects.



⑥	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 - 310°C
④	Melt temperature	280 - 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

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