

PA6.6 – Polyamide 6.6 PA66

## AKROMID® A4 5 EN black (5111)

Tensile modulus

**3500 MPa**

1 mm/min

ISO 527-2

Stress at yield

**80 MPa**

50 mm/min

ISO 527-2

Charpy impact strength

**n.b.**

23°C

ISO 179-1/1eU

AKROMID® A4 5 EN black (5111) is an unreinforced, high temperature stabilised, electrical neutral, high viscosity polyamide 6.6

### Typical applications

Highly stressed parts such as gear-wheels, bearing cages, cable connectors and coil formers.



### Mechanical Properties

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

d.a.m.

3500 MPa

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

d.a.m.

80 MPa

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

d.a.m.

2,7 %

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

d.a.m.

n.b.

conditioned

n.b.



### Thermal Properties

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

262 °C



### General properties

Density (23°C | ISO 1183)

1,14 g/cm<sup>3</sup>

#### Disclaimer:

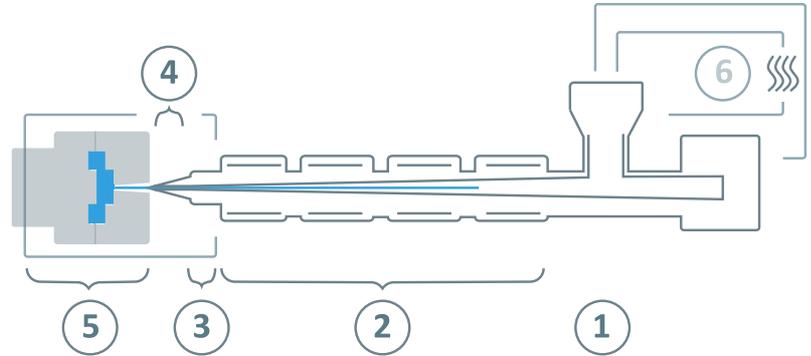
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### Processing information

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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