

PA6.6 – Polyamide 6.6 PA66

AKROMID® A3 6 LT black (5651)

Tensile modulus

3500 MPa

1 mm/min

ISO 527-2

Stress at yield

90 MPa

50 mm/min

ISO 527-2

Charpy impact strength

n.b.

23°C

ISO 179-1/1eU

AKROMID® A3 6 LT black (5651) is an unreinforced, inorganic high temperature stabilised and laser-transparent polyamide 6.6

Typical applications

Components and fixtures in the automotive industry. Formerly labeled as A3 5 LT black (5651)

**Mechanical Properties**

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

d.a.m.

3500 MPa

conditioned

1450 MPa

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

d.a.m.

90 MPa

conditioned

55 MPa

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

d.a.m.

5 %

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

d.a.m.

10 %

conditioned

30 %

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.

4,5 kJ/m²

conditioned

11 kJ/m²**Thermal Properties**

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

70 °C

Temperature of deflection under load HDT/B (0,45 MPa | ISO 75)

220 °C

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

262 °C

**Flammability**

Burning rate (UL 94)

1,6mm Wall thickness

V-2 Class

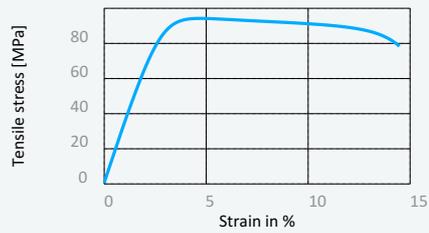
Burning rate (<100 mm/min) (> 1 mm Thickness | FMVSS 302)

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Disclaimer:

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Stress strain chart at 23°C

**General properties**

Density (23°C ISO 1183)	1,14 g/cm ³
Humidity absorption (70°C, 62% r.H. ISO 1110)	2,5 %
Molding shrinkage (flow ISO 294-4)	1,1 %
Molding shrinkage (transverse ISO 294-4)	1,5 %

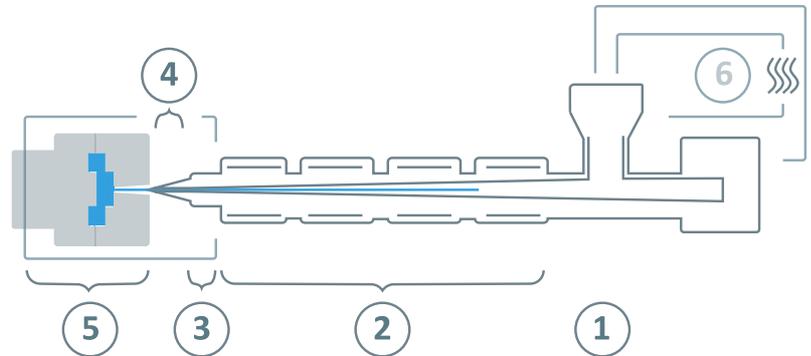
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AKROMID® A3 6 LT black (5651)**Processing information**

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	2 - 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	270 - 300°C
⑤	Mold temperature	40 - 90°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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