

PA6.6 – Polyamide 6.6 PA66 GF30

AKROMID® A3 GF 30 HU black (6567)

Tensile modulus

10500 MPa

1 mm/min
ISO 527-2

Stress at break

200 MPa

5 mm/min
ISO 527-2

Charpy impact strength

75 kJ/m²

23°C
ISO 179-1/1eU

AKROMID® A3 GF 30 HU black (6567) is a 30% glass fibre reinforced, heat stabilised polyamide 6.6 with high rigidity and strength, listed at UL in all colors

Typical applications

Components in mechanical engineering and in the automotive industry

Regulatory



Mechanical Properties

Tensile modulus (1 mm/min ISO 527-2)	
d.a.m.	10500 MPa
conditioned	7200 MPa

Stress at break (5 mm/min ISO 527-2)	
d.a.m.	200 MPa
conditioned	130 MPa

Strain at break (5 mm/min ISO 527-2)	
d.a.m.	3,1 %
conditioned	6 %

Charpy impact strength (23°C ISO 179-1/1eU)	
d.a.m.	75 kJ/m ²

Charpy notched impact strength (23°C ISO 179-1/1eA)	
d.a.m.	12 kJ/m ²



Thermal Properties

RTI electrical 0,4mm Wall thickness (UL 746B)	125 °C

RTI electrical 0,8mm Wall thickness (UL 746B)	125 °C

RTI electrical 1,6mm Wall thickness (UL 746B)	130 °C

RTI electrical 3,2mm Wall thickness (UL 746B)	130 °C

RTI impact 0,8mm Wall thickness (UL 746B)	120 °C

RTI impact 1,6mm Wall thickness (UL 746B)	120 °C

RTI impact 3,2mm Wall thickness (UL 746B)	120 °C

RTI strength 0,8mm Wall thickness (UL 746B)	130 °C

RTI strength 1,6mm Wall thickness (UL 746B)	130 °C

RTI strength 3,2mm Wall thickness (UL 746B)	130 °C

Temperature of deflection under load HDT/A (1,8 MPa ISO 75)	255 °C

Temperature of deflection under load HDT/B (0,45 MPa ISO 75)	260 °C

Melting temperature (DSC, 10K/min DIN EN 11357-1)	262 °C

Temperature index for 50% loss of tensile strength after 5.000h (5.000 h IEC 60216)	155 °C

Disclaimer:

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Flammability

Burning rate (UL 94)

0,4mm Wall thickness	HB Class
0,8mm Wall thickness	HB Class
1,6mm Wall thickness	HB Class
3,2mm Wall thickness	HB Class

HWI (UL 746A)

0,4mm Wall thickness	4 PLC
0,8mm Wall thickness	4 PLC
1,6mm Wall thickness	4 PLC
3,2mm Wall thickness	4 PLC

HAI (UL 746A)

0,4mm Wall thickness	0 PLC
0,8mm Wall thickness	0 PLC
1,6mm Wall thickness	0 PLC
3,2mm Wall thickness	0 PLC



General properties

Density (23°C ISO 1183)	1,35 g/cm ³
Humidity absorption (70°C, 62% r.F. ISO 1110)	1,9-2,1 %
Molding shrinkage (flow ISO 294-4)	0,1-0,3 %
Molding shrinkage (transverse ISO 294-4)	0,7-0,9 %



Electrical Properties

Comparative tracking index (Test liquid A IEC 60112)	>600 V
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Disclaimer:

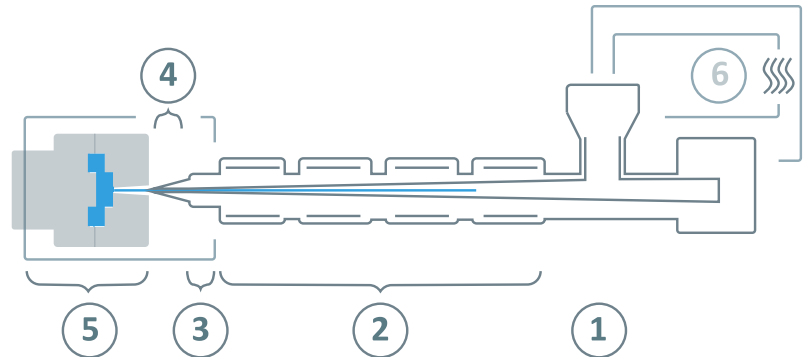
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Processing information

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	Melting temperature	280 - 300°C
⑤	Mold temperature	80 - 100°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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