

PA6.6 – Polyamide 6.6 PA66 GF50

AKROMID® A3 GF 50 HU natural (6662)

Tensile modulus

18000 MPa

1 mm/min
ISO 527-2

Stress at break

255 MPa

5 mm/min
ISO 527-2

Charpy impact strength

105 kJ/m²

23°C
ISO 179-1/1eU

AKROMID® A3 GF 50 HU natural (6662) is a 50% glass fibre reinforced, heat stabilised polyamide 6.6 with very high rigidity and strength, light inherent color and listet 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.	18000 MPa
Stress at break (5 mm/min ISO 527-2) d.a.m.	255 MPa
Strain at break (5 mm/min ISO 527-2) d.a.m.	2,8 %
Charpy impact strength (23°C ISO 179-1/1eU) d.a.m.	105 kJ/m ²
Charpy notched impact strength (23°C ISO 179-1/1eA) d.a.m.	20 kJ/m ²



Thermal Properties

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

Burning rate (UL 94)	
0,8mm Wall thickness	HB Class
1,6mm Wall thickness	HB Class
3,2mm Wall thickness	HB Class
GWFI (IEC 60695-2-12)	
0,8mm Wall thickness	700 °C
1,6mm Wall thickness	700 °C
3,2mm Wall thickness	800 °C



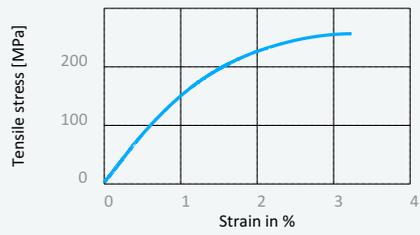
General properties

Density (23°C ISO 1183)	1,56 g/cm ³
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Disclaimer:

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Stress strain chart at 23°C



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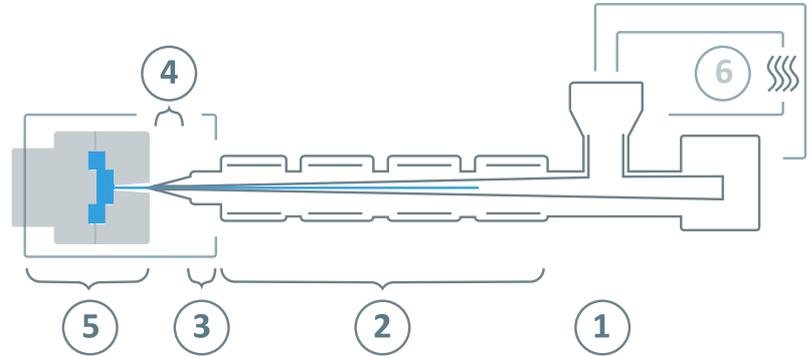
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Processing information

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	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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