

PA6.6 – Polyamide 6.6 PA66 GF30

## AKROMID® A3 GF 30 1 natural (6767)

Tensile modulus

**10000 MPa**

1 mm/min  
ISO 527-2

Stress at break

**205 MPa**

5 mm/min  
ISO 527-2

Charpy impact strength

**80 kJ/m<sup>2</sup>**

23°C  
ISO 179-1/1eU

AKROMID® A3 GF 30 1 natural (6767) is a 30% glass fibre reinforced, heat stabilised polyamide 6.6 with high stiffness and strength and light inherent color

### Typical applications

Components in mechanical engineering and in the automotive industry



### Mechanical Properties

Tensile modulus (1 mm/min   ISO 527-2) d.a.m.	10000 MPa
Stress at break (5 mm/min   ISO 527-2) d.a.m.	205 MPa
Strain at break (5 mm/min   ISO 527-2) d.a.m.	3,3 %
Charpy impact strength (23°C   ISO 179-1/1eU) d.a.m.	80 kJ/m <sup>2</sup>
Charpy notched impact strength (23°C   ISO 179-1/1eA) d.a.m.	14 kJ/m <sup>2</sup>



### Thermal Properties

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



### Flammability

Burning rate (UL 94) 1,6mm Wall thickness	HB Class
Burning rate (<100 mm/min) (> 1 mm Thickness   FMVSS 302)	+



### General properties

Density (23°C   ISO 1183)	1,36 g/cm <sup>3</sup>
Molding shrinkage (flow   ISO 294-4)	0,1 - 0,3 %
Molding shrinkage (transverse   ISO 294-4)	0,7 - 0,9 %

#### Disclaimer:

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### Electrical Properties

Volume resistivity (IEC 60093)  
d.a.m.

1,0E+13 Ohm x cm

Surface resistivity (acc. to IEC 60093)  
d.a.m.

1,0E+12 Ohm

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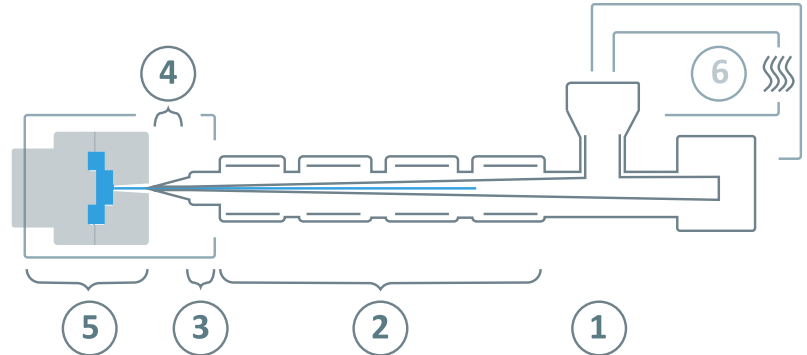
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### Processing information

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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