

AKROMID®

A3 GF 50 HU natural (6662)

PA66 GF50

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

Features

heat stabilised 130

Regulatory



Properties

Modulus

18.000 MPa

Strength

255 MPa

Impact

105 kJ/m²

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

18000 MPa

Tensile stress at break

ISO 527-2

5 mm/min | d.a.m.

255 MPa

Tensile strain at break

ISO 527-2

5 mm/min | d.a.m.

2,8 %

Charpy impact strength

ISO 179-1/1eU

23°C | d.a.m.

105 kJ/m²

Charpy notched impact strength

ISO 179-1/1eA

23°C | d.a.m.

20 kJ/m²

UV Exposure and Water Immersion

UL 746C



f2

Thermal Properties

RTI electrical UL 746B	UL 0,4mm Wall thickness	125 °C
	UL 0,8mm Wall thickness	125 °C
	UL 1,6mm Wall thickness	130 °C
	UL 3,2mm Wall thickness	130 °C
RTI impact UL 746B	UL 0,8mm Wall thickness	120 °C
	UL 1,6mm Wall thickness	120 °C
	UL 3,2mm Wall thickness	120 °C
RTI strength UL 746B	UL 0,8mm Wall thickness	130 °C
	UL 1,6mm Wall thickness	130 °C
	UL 3,2mm Wall thickness	130 °C
Melting temperature ISO 11357-3	DSC, 10K/min	262 °C

Flammability

Flammability UL 94	UL 0,8 mm Wall thickness	HB Class
	UL 1,6 mm Wall thickness	HB Class
	UL 3,2 mm Wall thickness	HB Class
GWFI IEC 60695-2-12	0,8 mm Wall thickness	700 °C
	1,6 mm Wall thickness	700 °C
	3,2 mm Wall thickness	800 °C
HWI UL 746A	UL 0,4 mm Wall thickness	4 PLC
	UL 0,8 mm Wall thickness	4 PLC
	UL 1,6 mm Wall thickness	4 PLC
	UL 3,2 mm Wall thickness	4 PLC
HAI UL 746A	UL 0,4 mm Wall thickness	0 PLC
	UL 0,8 mm Wall thickness	0 PLC
	UL 1,6 mm Wall thickness	0 PLC
	UL 3,2 mm Wall thickness	0 PLC

General Properties

Density ISO 1183	23°C	1,56 g/cm ³
Humidity absorption ISO 1110	70°C, 62% r.H.	1,3 - 1,5 %

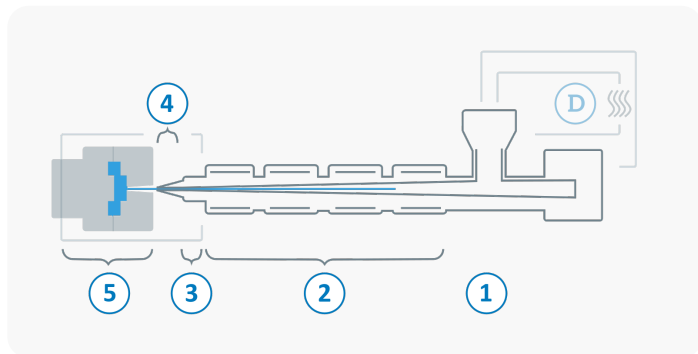
Water absorption ISO 62	23°C, saturated	3,7 - 4,3 %
Molding shrinkage ISO 294-4	flow transverse	0,1 - 0,3 % 0,5 - 0,7 %

Electrical Properties

Volume resistivity IEC 62631-3-1	 d.a.m.	10¹¹ Ω x cm
Comparative tracking index ASTM D3638		0 PLC
Dielectric strength IEC 60243	 3 mm	12 kV/mm
High voltage arc tracking rate (HVTR) UL 746A		1 PLC
High Volt, Low Current Arc Resistance ASTM D495		5 PLC

Processing

The values mentioned are recommendations. We only recommend desiccant / dry air dryers or vacuum dryers. Too long a drying time and the resulting residual moisture content below the lower limit can lead to filling problems and surface defects. The specified drying time refers to closed and undamaged bagged material. When processing from previously opened bags or from octabins with polyolefin inliners, a longer drying time may be necessary. It is recommended to check the residual moisture content after the drying process.



D	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

Diagrams

