

PA6.6/6 – Polyamide 6.6/6 PA66 + PA6 GF 35

AKROMID® C3 GF 35 5 XTC black (5552)

Tensile modulus

11000 MPa

1 mm/min

ISO 527-2

Stress at break

200 MPa

5 mm/min

ISO 527-2

Charpy impact strength

100 kJ/m²

23°C

ISO 179-1/1eU

AKROMID® C3 GF 35 5 XTC black (5552) is a 35% glass fibre reinforced, high heat stabilised polyamid 66/6 blend with high stiffness and strength and with extra high temperature tolerance.

Typical applications

Technical parts in mechanical engineering and automotive industry

**Mechanical Properties**

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

d.a.m.

11000 MPa

conditioned

8000 MPa

Stress at break (5 mm/min | ISO 527-2)

d.a.m.

200 MPa

conditioned

135 MPa

Strain at break (5 mm/min | ISO 527-2)

d.a.m.

3,3 %

conditioned

6,5 %

Charpy impact strength (23°C | ISO 179-1/1eU)

d.a.m.

100 kJ/m²

conditioned

95 kJ/m²

Charpy notched impact strength (23°C | ISO 179-1/1eA)

d.a.m.

18 kJ/m²

conditioned

19 kJ/m²**Thermal Properties**

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

230 °C

Melting temperature (DSC, 10K/min | DIN EN ISO 11357-3)

245 °C

**Flammability**

Burning rate (UL 94)

1,6mm Wall thickness

HB Class

**General properties**

Density (23°C | ISO 1183)

1,40 g/cm³

Humidity absorption (70°C, 62% r.H. | ISO 1110)

1,9-2,1 %

Molding shrinkage (flow | ISO 294-4)

0,1-0,3 %

Molding shrinkage (transverse | ISO 294-4)

0,4-0,6 %

**Electrical Properties**

Surface resistivity (DIN EN 62631-3-2)

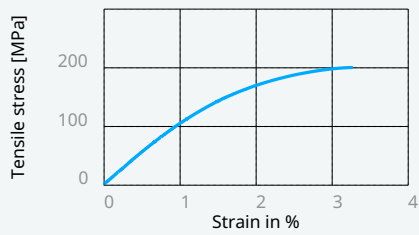
d.a.m.

1,0E+12 Ohm

Disclaimer:

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Stress strain chart at 23°C

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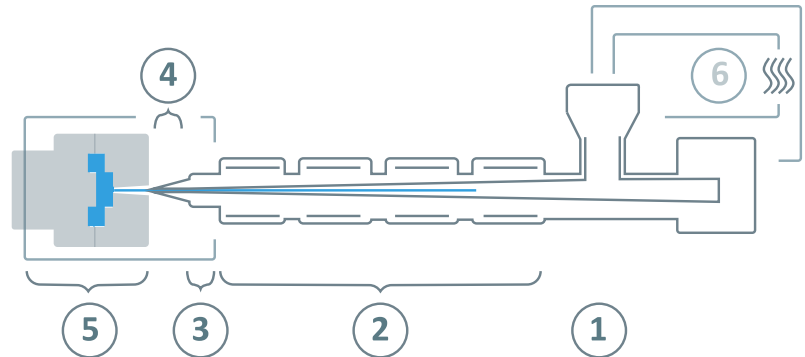
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Processing information

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 - 300°C
④	Melt temperature	270 - 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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