

AKROMID®

A28 GF 37 1 GIT black (5887)

PA66 GF37



Think Polyamide

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Preliminary Datasheet

Description:

AKROMID® A3 GF 37 1 GIT black (5887) is a 37% glass fibre reinforced, heat stabilised, easy flowing polyamide 6.6 with high stiffness and strength for gas injection technology

Applications

Engineering parts, which are produced by gas injection technology. Furthermore A3 GF 37 1 GIT black (5887) can be used for standard injection moulding for demanding surface quality.

Typical values	Test specification	Method	Unit	Value
				d.a.m.

Mechanical Properties

Tensile modulus	1 mm/min	ISO 527-2	MPa	11700
Stress at break	5 mm/min	ISO 527-2	MPa	210
Strain at break	5 mm/min	ISO 527-2	%	3

Thermal Properties

Melting temperature	DSC, 10K/min	DIN EN 11357-1	°C	255
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Flammability

Wall thickness			mm	0,4	0,8	1,6	2,0	3,2
Flammability		UL 94	class		HB			
Burning rate (< 100 mm/min)	> 1 mm thickness	FMVSS 302						+

General Properties

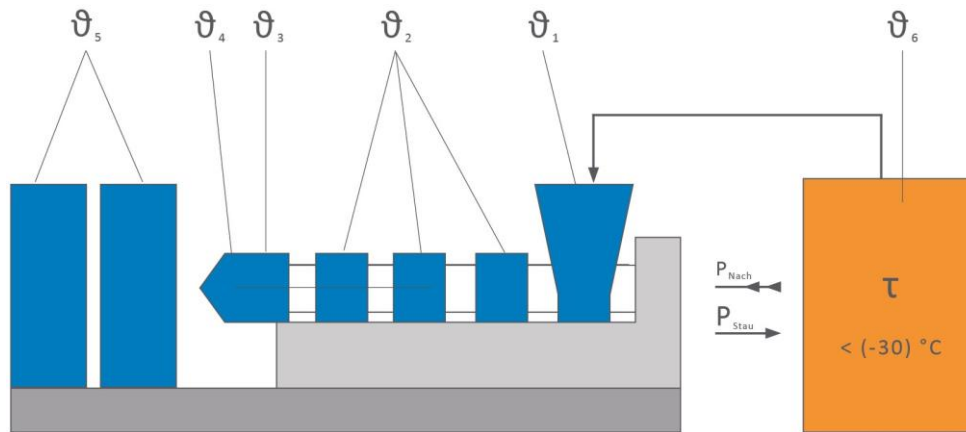
Content reinforcement/Content Filler		ISO 1172	%	37
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Rheological Properties

MVR	275/5	ISO 1133	cm ³ /10min	28
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Continuation

Processing recommendations



ϑ_6	Drying time	h	0 - 4
ϑ_6	Drying temperature	°C	80
	Processing moisture	%	0,02 - 0,1
ϑ_1	Feed section	°C	60 - 80
ϑ_2	Section 1 - Section 4	°C	260 - 300
ϑ_3	Nozzle	°C	270 - 310
ϑ_4	Melt	°C	280 - 300
ϑ_5	Mould	°C	80 - 100
P_{Nach}	Holding pressure, spec.	bar	300 - 800
P_{Stau}	Back pressure, spez.	bar	50 - 150
	Injection speed		medium to high
	Screw speed	m/min	8 - 15

The listed values are recommendations. Higher values should be used for higher glass loadings. We recommend only de-humidifying or vacuum dryers. Extensive drying can cause filling problems and surface defects.