

Datasheet**Description:**

AKROMID® A3 1 black (2417) is a heat stabilised, nonreinforced polyamide 6.6

Applications

Applications are housings and fixtures in automotive and electric industry

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

Mechanical Properties

Tensile modulus	1 mm/min	ISO 527-2	MPa	3200	1100
Stress at yield	50 mm/min	ISO 527-2	MPa	85	50
Strain at break	50 mm/min	ISO 527-2	%	> 20	> 50
Flexural modulus	2 mm/min	ISO 178	MPa	2800	
Flexural strength	2 mm/min	ISO 178	MPa	110	
Charpy impact strength	23°C	ISO 179-1/1eU	kJ/m ²	n.b.	n.b.
Charpy impact strength	-30°C	ISO 179-1/1eU	kJ/m ²	n.b.	
Charpy notched impact strength	23°C	ISO 179-1/1eA	kJ/m ²	5	13
Charpy notched impact strength	-30°C	ISO 179-1/1eA	kJ/m ²	2	

Electrical Properties

Volume resistivity		IEC 60093	Ohm x cm	1,0E+13	1,0E+10
Surface resistivity		b.o. IEC 60093	Ohm	1,0E+13	1,0E+10
Comparative tracking index	test solution A	IEC 60112		600	

Thermal Properties

Melting temperature	DSC, 10K/min	DIN EN 11357-1	°C	262	
Temp. of deflection under load HDT/A	1,8 MPa	ISO 75	°C	75	
Temp. of deflection under load HDT/B	0,45 MPa	ISO 75	°C	215	
Coeff. of linear therm. expansion, parallel	23°C - 80°C	ISO 11359-1/2	1,0E-4/K	0,71	
Coeff. of linear therm. expansion, normal	23°C - 80°C	ISO 11359-1/2	1,0E-4/K	1,1	

Flammability

Wall thickness			mm	0,4	0,8	1,6	2,0	3,2
Flammability		UL 94	class		V2			
GWFI		IEC 60695-2-12	°C			750		
GWIT		IEC 60695-2-13	°C			675		
Burning rate (< 100 mm/min)	> 1 mm thickness	FMVSS 302						+

General Properties

Density	23°C	ISO 1183	g/cm ³	1,14	
Humidity absorption	70°C, 62% r.h.	ISO 1110	%	2,9 - 3,1	
Water absorption	23°C, saturated	ISO 62	%	8,0 - 9,0	

Processing

Flowability	7 x 3,5 mm & **	AKRO	mm	1040	
Molding shrinkage	flow	ISO 294-4	%	1,5	
Molding shrinkage	transverse	ISO 294-4	%	1,6	

b.o.: based on

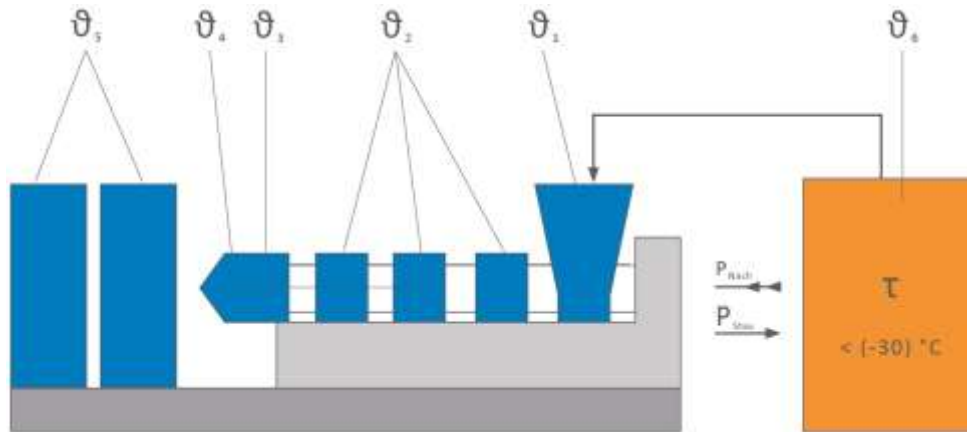
n.b. = not broken

* = specimen acc. ISO 1110 stored

** = mould temperature: 100°C, melt temperature: 320°C, injection pressure: 750 bar

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	40 - 80
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.