

AKROMID®

A3 GF 30 1 S3 black (3502)

PA66-I GF30



Think Polyamide

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Datasheet

Description:

AKROMID® A3 GF 30 1 S3 black (3502) is a 30% glass fibre reinforced, heat stabilised, dry impact resistant polyamide 6.6 with high stiffness and strength

Applications

Connecting and fixing systems, used at elevated temperatures in the automotive and electric industry

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

Tensile modulus	1 mm/min	ISO 527-2	MPa	8000
Stress at break	5 mm/min	ISO 527-2	MPa	170
Strain at break	5 mm/min	ISO 527-2	%	4,5
Flexural modulus	2 mm/min	ISO 178	MPa	8200
Flexural strength	2 mm/min	ISO 178	MPa	270
Flexural strain at break	2 mm/min	ISO 178	%	4,7
Charpy impact strength	23°C	ISO 179-1/1eU	kJ/m ²	100
Charpy impact strength	-30°C	ISO 179-1/1eU	kJ/m ²	110
Charpy notched impact strength	23°C	ISO 179-1/1eA	kJ/m ²	17
Charpy notched impact strength	-30°C	ISO 179-1/1eA	kJ/m ²	12

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	245

Flammability

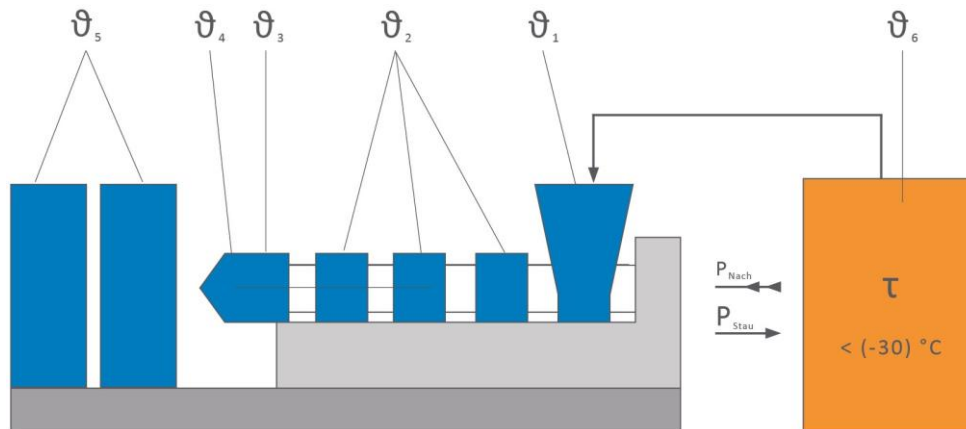
Wall thickness			mm	0,4	0,8	1,6	2,0	3,2
Flammability		UL 94	class			HB		
Burning rate (< 100 mm/min)	> 1 mm thickness	FMVSS 302				+		

General Properties

Density	23°C	ISO 1183	g/cm ³	1,34
Content reinforcement/Content Filler		ISO 1172	%	30

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.