

AKROMID®

A3 GF 35 1 black (4834)

PA66 GF35



Think Polyamide

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Datasheet

Description:

AKROMID® A3 GF 35 1 black (4834) is a 35% glass fibre reinforced, heat stabilised polyamide 6.6 with high rigidity and strength, very good flowability and UL listed.

Applications

Components in mechanical engineering and in the automotive industry

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

Mechanical Properties

Tensile modulus	1 mm/min	ISO 527-2	MPa	12000	9000
Stress at break	5 mm/min	ISO 527-2	MPa	215	145
Strain at break	5 mm/min	ISO 527-2	%	3	4,6
Flexural modulus	2 mm/min	ISO 178	MPa	11000	
Flexural strength	2 mm/min	ISO 178	MPa	300	
Flexural strain at break	2 mm/min	ISO 178	%	3,3	
Charpy impact strength	23°C	ISO 179-1/1eU	kJ/m ²	75	
Charpy notched impact strength	23°C	ISO 179-1/1eA	kJ/m ²	12	

Thermal Properties

Melting temperature	DSC, 10K/min	DIN EN 11357-1	°C	262	
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General Properties

Density	23°C	ISO 1183	g/cm ³	1,4	
Content reinforcement/Content Filler		ISO 1172	%	35	
Humidity absorption	70°C, 62% r.h.	ISO 1110	%	1,77	

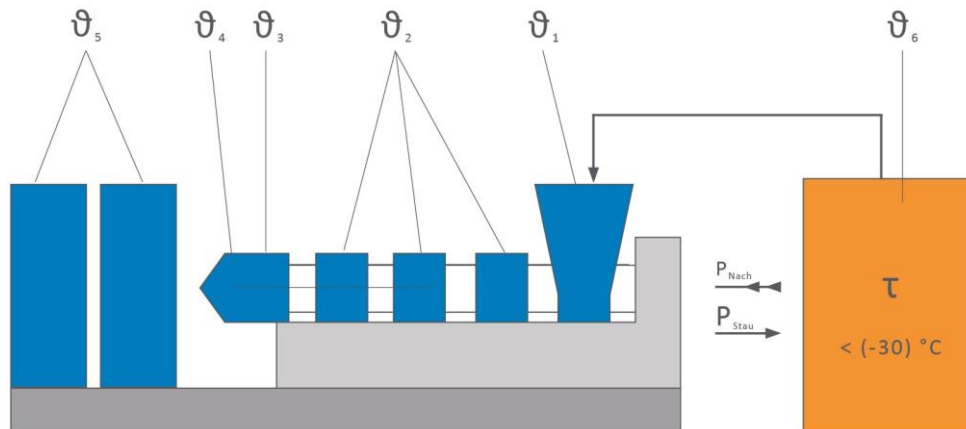
Processing

Molding shrinkage	flow	ISO 294-4	%	0,1 - 0,3	
Molding shrinkage	transverse	ISO 294-4	%	0,65 - 0,85	

* = specimen acc. ISO 1110 stored

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.