

PA6.6 – Polyamide 6.6 PA66 GF35

## AKROMID® A3 GF 35 1 EN natural (5821)

Tensile modulus

**11500 MPa**

1 mm/min  
ISO 527-2

Stress at break

**215 MPa**

5 mm/min  
ISO 527-2

Charpy impact strength

**90 kJ/m<sup>2</sup>**

23°C  
ISO 179-1/1eU

AKROMID® A3 GF 35 1 EN natural (5821) is a 35% glass fibre reinforced, heat stabilised, electrical neutral polyamide 6.6 with high rigidity and strength and light inherent color

### Typical applications

Components in mechanical engineering and in the automotive industry



### Mechanical Properties

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

d.a.m.	11500 MPa
conditioned	8400 MPa

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

d.a.m.	215 MPa
conditioned	145 MPa

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

d.a.m.	3 %
conditioned	5 %

Flexural modulus (2 mm/min | ISO 178)

d.a.m.	10000 MPa
conditioned	8000 MPa

Flexural strength (2 mm/min | ISO 178)

d.a.m.	300 MPa
conditioned	245 MPa

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

d.a.m.	90 kJ/m <sup>2</sup>
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Charpy notched impact strength (23°C | ISO 179-1/1eA)

d.a.m.	15 kJ/m <sup>2</sup>
conditioned	19 kJ/m <sup>2</sup>

Ball indentation hardness (961N/30s | ISO 2039-1)

d.a.m.	255 MPa
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### Thermal Properties

Temperature of deflection under load HDT/A (1,8 MPa | ISO 75) 255 °C

Temperature of deflection under load HDT/B (0,45 MPa | ISO 75) 260 °C

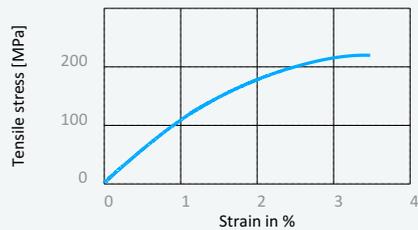
Temperature of deflection under load HDT/C (8 MPa | ISO 75) 220 °C

Melt temperature (DSC, 10K/min | DIN EN 11357-1) 262 °C

#### Disclaimer:

All specifications and information given on this website are based on our current knowledge and experience. A legally binding promise of certain characteristics or suitability for a concrete individual case cannot be derived from this information. The information supplied here is not intended to release processors and users from the responsibility of carrying out their own tests and inspections in each concrete individual case. AKRO®, AKROMID®, AKROLEN®, AKROLOY®, AKROTEK®, ICX® and PRECITE® are registered trademarks of the Feddersen Group.

Stress strain chart at 23°C



**Flammability**

Burning rate (UL 94) 0,8mm Wall thickness	HB Class
GWFI (IEC 60695-2-12) 1,6mm Wall thickness	650 °C
Burning rate (<100 mm/min) (> 1 mm Thickness   FMVSS 302)	+



**General properties**

Density (23°C   ISO 1183)	1,4 g/cm <sup>3</sup>
Molding shrinkage (flow   ISO 294-4)	0,2 %
Molding shrinkage (transverse   ISO 294-4)	1,3 %



**Electrical Properties**

Comparative tracking index (Test liquid A   IEC 60112)	600 V
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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.

Drying time	0 - 4 h
Drying temperature ( $\tau \leq -30^{\circ}\text{C}$ )	80°C
Processing moisture	0,02 - 0,1%
Feed section	60 - 80°C
Temperature zone 1 - Zone 4	260 - 300°C
Nozzle temperature	270 - 310°C
Melt temperature	280 - 300°C
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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