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AKRO COMPOUNDS

Compound No.: **8642**

AKROMID® PRELIMINARY
NEXT U28 GF 35 1 natural (8642)

PA11 GF35

AKROMID® NEXT U28 GF 35 1 natural (8642) is a Polyamide 11 reinforced with 35% glass fibre It is characterised by a high stiffness and strength.

Features

reduced density | reduced moisture | 3D printing / additive manufacturing | Sports & leisure | lightweight construction

Properties

Modulus	Strength	Impact
8.200 MPa	**130** MPa	**100** kJ/m²

Sustainability

Biobased carbon content	**90 %**

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min | d.a.m.	**8200 MPa**
Tensile stress at break ISO 527-2	5 mm/min | d.a.m.	**130 MPa**
Tensile strain at break ISO 527-2	5 mm/min | d.a.m.	**5 %**
Charpy impact strength ISO 179-1/1eU	23°C | d.a.m.	**100 kJ/m²**
Charpy notched impact strength ISO 179-1/1eA	23°C | d.a.m.	**20 kJ/m²**

Thermal Properties

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Melting temperature ISO 11357-3	DSC, 10K/min	**189 °C**

Flammability

Flammability UL 94	1,6 mm Wall thickness	**HB Class**

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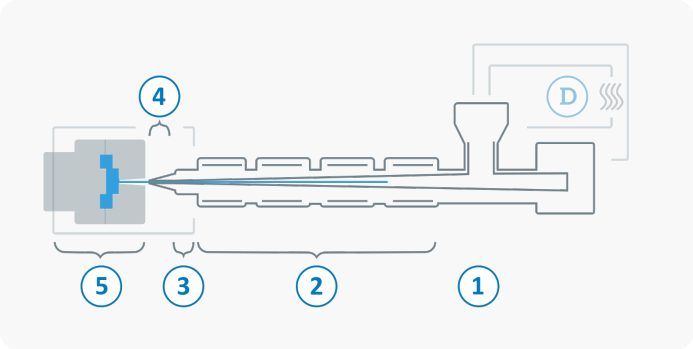
Processing

The values mentioned are recommendations. We only recommend desiccant / dry air dryers or vacuum dryers. Too long a drying time and the resulting residual moisture content below the lower limit can lead to filling problems and surface defects. The specified drying time refers to closed and undamaged bagged material. When processing from previously opened bags or from octabins with polyolefin inliners, a longer drying time may be necessary. It is recommended to check the residual moisture content after the drying process.



D	Drying time	0 - 4 h
	Drying temperature (τ <= -30°C)	80 °C
	Processing moisture	0,02 - 0,1 %
1	Feed section	60 - 80 °C
2	Temperature Zone 1 - Zone 4	240 - 300 °C
3	Nozzle temperature	230 - 300 °C
4	Melt temperature	240 - 290 °C
5	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