

Compound No.: 2955

# AKROMID® A3 1 S3 grey (2955)

PA66+PA6-I

AKROMID® A3 1 S3 grey (2955) is an unreinforced, impact modified Polyamide 6.6 in grey color, similar to RAL 7011. It is characterised by a medium dry impact strength. Furthermore, the material is heat stabilised and therefore perfectly suitable for connecting and fixing systems which are used at elevated temperatures in the automotive and electro industry.

# heat stabilised 130 impact modified Properties Modulus Strength Impact 2.500 MPa 68 MPa 180 kJ/m²

### **Mechanical Properties**

Tensile modulus ISO 527-2	1 mm/min   d.a.m.	2500 MPa
Tensile stress at yield ISO 527-2	50 mm/min   d.a.m.	68 MPa
Tensile strain at break ISO 527-2	50 mm/min   d.a.m.	> 25 %
Charpy impact strength ISO 179-1/1eU	23°C   d.a.m.	no break
Charpy notched impact strength ISO 179-1/1eA	23°C   d.a.m. -30°C   d.a.m.	11 kJ/m² 8 kJ/m²

### **Thermal Properties**

Temperature of deflection under load HDT/A	1.8 MPa	60 °C
ISO 75	1,0 1111 d	00 0



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Melting temperature	DSC. 10K/min	260 °C
ISO 11357-3	55C, 1010111111	200 C

# **Flammability**

Flammability UL 94	1,6 mm Wall thickness	HB Class
Burning rate (<100 mm/min) FMVSS 302	> 1 mm Thickness	+

# **General Properties**

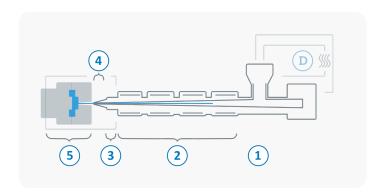
<b>Density</b> ISO 1183	23°C	1,11 g/cm³
Molding shrinkage ISO 294-4	flow transverse	1,3 - 1,5 % 1,5 - 1,7 %





### **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	2 - 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	260 - 300 °C
3	Nozzle temperature	270 - 310 °C
4	Melt temperature	270 - 300 °C
5	Mold temperature	40 - 90 °C
$\ni$	Holding pressure, spec.	300 - 800 bar
	Back pressure, spec.	50 - 150 bar
	Injection speed	medium to high
	Screw speed	8 - 15 m/min