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AKRO COMPOUNDS

Compound No.: **2391**

AKROMID®
A3 GF 30 1 natural (2391)

PA66 GF30

AKROMID® A3 GF 30 1 natural (2391) is a 30% glass fiber reinforced polyamide 6.6. It is characterised by high stiffness and strength. Furthermore, the material is heat stabilised and therefore perfectly suitable for technical parts in industrial engineering and in the automotive industry. The material has a light inherent color.

Features

heat stabilised 130

Properties

Modulus	Strength	Impact
10.000 MPa	**200** MPa	**85** kJ/m²

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min | d.a.m. 1 mm/min | conditioned	**10000 MPa** **7100 MPa**
Tensile stress at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**200 MPa** **130 MPa**
Tensile strain at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**3 %** **>= 6 %**
Flexural modulus ISO 178	2 mm/min | d.a.m. 2 mm/min | conditioned	**8800 MPa** **7200 MPa**
Flexural strength ISO 178	2 mm/min | d.a.m. 2 mm/min | conditioned	**285 MPa** **220 MPa**
Charpy impact strength ISO 179-1/1eU	23°C | d.a.m. 23°C | conditioned -30°C | d.a.m.	**85 kJ/m²** **95 kJ/m²** **80 kJ/m²**
Charpy notched impact strength ISO 179-1/1eA	23°C | d.a.m. 23°C | conditioned -30°C | d.a.m.	**12 kJ/m²** **16 kJ/m²** **11 kJ/m²**

Ball indentation hardness ISO 2039-1	961N/30s | d.a.m.	**240 MPa**

Thermal Properties

Temperature of deflection under load HDT/A ISO 75	1,8 MPa	**255 °C**
Temperature of deflection under load HDT/B ISO 75	0,45 MPa	**260 °C**
Temperature of deflection under load HDT/C ISO 75	8 MPa	**210 °C**
Melting temperature ISO 11357-3	DSC, 10K/min	**262 °C**
Coefficient of linear thermal expansion ISO 11359-1/2	23°C to 80°C | parallel 23°C to 80°C | transverse	**0,19 10^{-4}/K** **0,95 10^{-4}/K**
Temperature index for 50% loss of tensile strength IEC 60216	5.000 h 20.000 h	**160 - 175 °C** **130 - 150 °C**

Flammability

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

General Properties

Density ISO 1183	23°C	**1,36 g/cm^3**
Humidity absorption ISO 1110	70°C, 62% r.H.	**1,9 - 2,1 %**
Water absorption ISO 62	23°C, saturated	**5,2 -5,8 %**

Molding shrinkage ISO 294-4	flow	**0,1 - 0,3 %**
	transverse	**0,7 - 0,9 %**

Electrical Properties

Volume resistivity IEC 62631-3-1	d.a.m.	**10^{13} Ω x cm**
	conditioned	**10^{10} Ω x cm**
Surface resistivity IEC 62631-3-2	d.a.m.	**10^{12} Ω**
	conditioned	**10^{10} Ω**
Comparative tracking index IEC 60112	Test liquid A	**600 V**

Rheological Properties

Flowability AKRO	2 mm Thickness	**420 mm**

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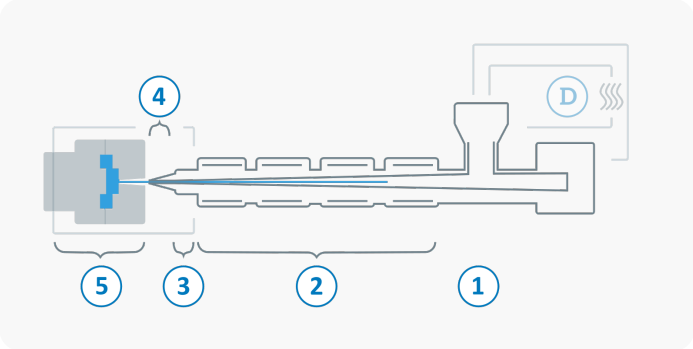
Processing

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	260 - 300 °C
3	Nozzle temperature	270 - 310 °C
4	Melt temperature	280 - 300 °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

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Diagrams