AKROMID®
A3 GF 13 S3 natural (2788)

PA66-I GF13

AKROMID® A3 GF 13 S3 natural (2788) is a 13% glass fiber reinforced, impact modified PA 6.6. It is characterised by a higher impact strength compared to standard glass fiber reinforced PA 6.6 and therefore perfectly suitable for technical applications in the mechanical engineering and automotive industry. The material hat a light inherent color.

Features

impact modified

Properties

Modulus	Strength	Impact
5.200 MPa	**125** MPa	**75** kJ/m²

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min | d.a.m.	**5200 MPa**
Tensile stress at break ISO 527-2	5 mm/min | d.a.m.	**125 MPa**
Tensile strain at break ISO 527-2	5 mm/min | d.a.m.	**4 %**
Flexural modulus ISO 178	2 mm/min | d.a.m.	**4800 MPa**
Flexural strength ISO 178	2 mm/min | d.a.m.	**180 MPa**
Charpy impact strength ISO 179-1/1eU	23°C | d.a.m. -30°C | d.a.m.	**75 kJ/m²** **55 kJ/m²**
Charpy notched impact strength ISO 179-1/1eA	23°C | d.a.m. -30°C | d.a.m.	**11 kJ/m²** **6 kJ/m²**

Thermal Properties

+135-3858-6433 (GuangDong)
+188-1699-6168 (ShangHai)
+852-6957-5415 (HongKong)

Temperature of deflection under load HDT/A ISO 75	1,8 MPa	**245 °C**
Temperature of deflection under load HDT/B ISO 75	0,45 MPa	**260 °C**
Melting temperature ISO 11357-3	DSC, 10K/min	**260 °C**

General Properties

Density ISO 1183	23°C	**1,2 g/cm³**
Molding shrinkage ISO 294-4	flow transverse	**0,3 %** **0,9 %**

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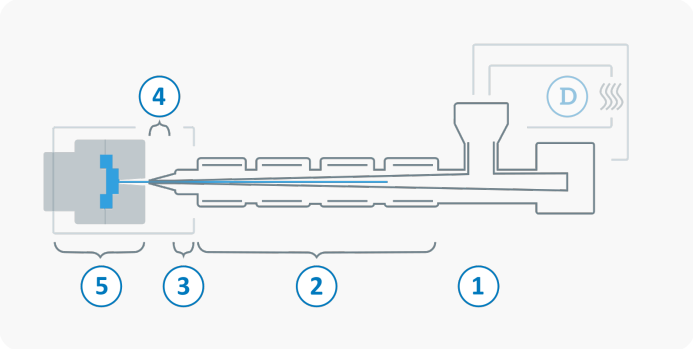
Processing

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