

AKROMID®

A3 GF 25 3 black (3094)

PA66 GF25

AKROMID® A3 GF 25 3 black (3094) is a 25% glass fibre reinforced, nucleated polyamide 6.6 with high stiffness and strength

Features

nucleated

Properties

Modulus

8.500 MPa

Strength

160 MPa

Impact

50 kJ/m²

Sustainability

Recycled content 30 %

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

8500 MPa

1 mm/min | conditioned

6000 MPa

Tensile stress at break

ISO 527-2

5 mm/min | d.a.m.

160 MPa

5 mm/min | conditioned

110 MPa

Tensile strain at break

ISO 527-2

5 mm/min | d.a.m.

3 %

5 mm/min | conditioned

6 %

Flexural modulus

ISO 178

2 mm/min | d.a.m.

6600 MPa

Flexural strength

ISO 178

2 mm/min | d.a.m.

230 MPa

Flexural strain at break

ISO 178

2 mm/min | d.a.m.

3,6 %

Charpy impact strength

ISO 179-1/1eU

23°C | d.a.m.

50 kJ/m²

23°C | conditioned

70 kJ/m²

-30°C | d.a.m.

45 kJ/m²

Charpy notched impact strength

ISO 179-1/1eA

23°C | d.a.m.

6 kJ/m²

23°C | conditioned

10 kJ/m²

Izod notched impact strength

ISO 180/1A

23°C | d.a.m.

6 kJ/m²

Thermal Properties

Melting temperature

ISO 11357-3

DSC, 10K/min

262 °C

Flammability

Flammability

UL 94

1,6 mm Wall thickness

HB Class

Burning rate (<100 mm/min)

FMVSS 302

> 1 mm Thickness

+

General Properties

Density

ISO 1183

23°C

1,32 g/cm³

Humidity absorption

ISO 1110

70°C, 62% r.H.

2 - 2,2 %

Molding shrinkage

ISO 294-4

flow

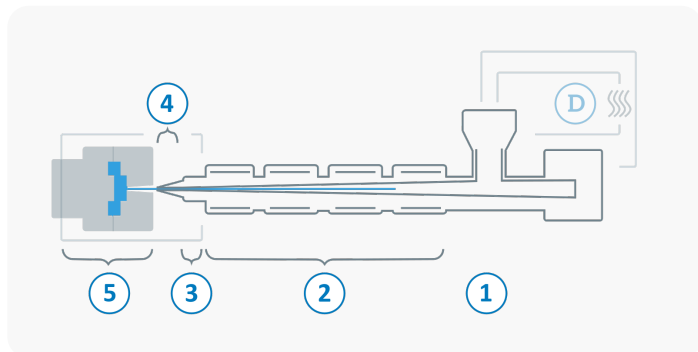
0,15 - 0,35 %

transverse

0,75 - 0,95 %

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 ($\tau \leq -30^{\circ}\text{C}$)	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

Diagrams

