

AKROMID®

A3 GF 25 FR natural (7649)

PA66 GF25 FR(40)

AKROMID® A3 GF 25 FR natural (7649) is a 25% glass fibre reinforced, halogen and red phosphorus free flame retardant polyamide 6.6 with high stiffness and strength and light inherent color

Properties

Modulus

9.200 MPa

Strength

135 MPa

Impact

63 kJ/m²

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

9200 MPa

1 mm/min | conditioned

5800 MPa

Tensile stress at break

ISO 527-2

5 mm/min | d.a.m.

135 MPa

5 mm/min | conditioned

90 MPa

Tensile strain at break

ISO 527-2

5 mm/min | d.a.m.

3 %

5 mm/min | conditioned

4,5 %

Charpy impact strength

ISO 179-1/1eU

23°C | d.a.m.

63 kJ/m²

Charpy notched impact strength

ISO 179-1/1eA

23°C | d.a.m.

10 kJ/m²

Thermal Properties

Melting temperature

ISO 11357-3

DSC, 10K/min

260 °C

Flammability

Flammability

UL 94

0,8 mm Wall thickness

V-0 Class

1,6 mm Wall thickness

V-0 Class

3,2 mm Wall thickness

V-0 Class

GWFI

IEC 60695-2-12

0,8 mm Wall thickness

960 °C

1,6 mm Wall thickness

960 °C

3,2 mm Wall thickness

960 °C

GWIT

IEC 60695-2-13

0,8 mm Wall thickness

750 °C

1,6 mm Wall thickness

725 °C

3,2 mm Wall thickness

750 °C

General Properties

Density

ISO 1183

23°C

1,37 g/cm³

Electrical Properties

Comparative tracking index

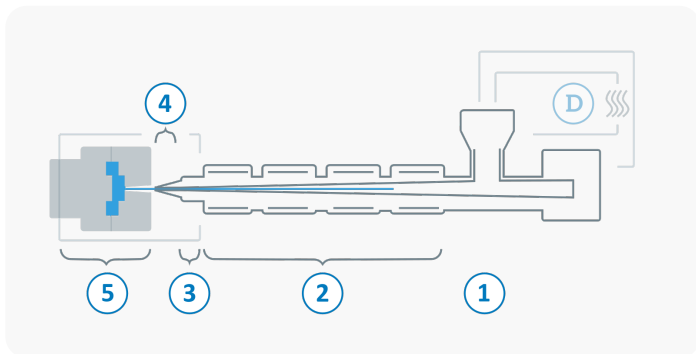
IEC 60112

Test liquid A

600 V

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 ($\tau \leq -30^{\circ}\text{C}$)	80 °C
	Processing moisture	0,02 - 0,08 %
1	Feed section	60 - 80 °C
2	Temperature Zone 1 - Zone 4	260 - 290 °C
3	Nozzle temperature	260 - 300 °C
4	Melt temperature	270 - 290 °C
5	Mold temperature	60 - 100 °C
→	Holding pressure, spec.	300 - 800 bar
←	Back pressure, spec.	30 - 100 bar
	Injection speed	medium
	Screw speed	5 - 10 m/min