

AKROMID®

A3 GF 15 1 GIT black (4620)

PA66 GF15

AKROMID® A3 GF 15 1 GIT black (4620) is a 15% glass fibre reinforced, heat stabilised, easy flowing polyamide 6.6. It is characterised by average stiffness and strength and shows an excellent surface. Furthermore, the material is designed for gas injection technology.

Features

heat stabilised 130 surface modified fluid injection (GIT/WIT/FIT)

Properties

Modulus

5.500 MPa

Strength

125 MPa

Impact

40 kJ/m²

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

5500 MPa

1 mm/min | conditioned

3500 MPa

Tensile stress at break

ISO 527-2

5 mm/min | d.a.m.

125 MPa

5 mm/min | conditioned

80 MPa

Tensile strain at break

ISO 527-2

5 mm/min | d.a.m.

3 %

5 mm/min | conditioned

12 %

Charpy impact strength

ISO 179-1/1eU

23°C | d.a.m.

40 kJ/m²

23°C | conditioned

75 kJ/m²

Charpy notched impact strength

ISO 179-1/1eA

23°C | d.a.m.

7 kJ/m²

23°C | conditioned

8 kJ/m²

Thermal Properties

Melting temperature

ISO 11357-3

DSC, 10K/min

255 °C

Flammability

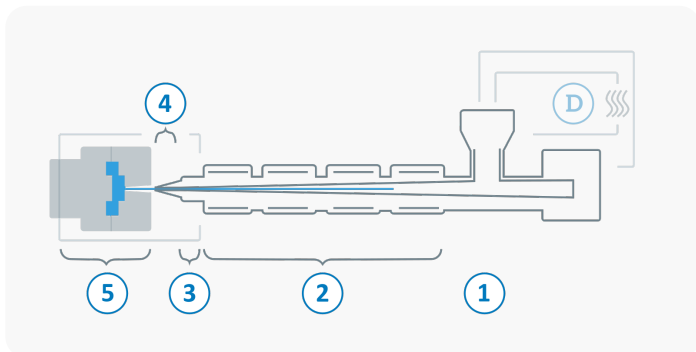
Flammability UL 94	0,8 mm Wall thickness	HB Class
Burning rate (<100 mm/min) FMVSS 302	> 1 mm Thickness	+

General Properties

Density ISO 1183	23°C	1,24 g/cm³
Humidity absorption ISO 1110	70°C, 62% r.H.	2,5 %
Molding shrinkage ISO 294-4	flow	0,3 - 0,5 %
	transverse	0,9 - 1,1 %

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

