

AKROMID®

A3 GF 35 1 natural (2393)

PA66 GF35

AKROMID® A3 GF 35 1 natural (2393) is a 35% glass fiber reinforced polyamide 6.6. It is characterised by a very 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

11.600 MPa

Strength

215 MPa

Impact

92 kJ/m²

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

11600 MPa

1 mm/min | conditioned

8400 MPa

Tensile stress at break

ISO 527-2

5 mm/min | d.a.m.

215 MPa

5 mm/min | conditioned

145 MPa

Tensile strain at break

ISO 527-2

5 mm/min | d.a.m.

3 %

5 mm/min | conditioned

5 %

Flexural modulus

ISO 178

2 mm/min | d.a.m.

10000 MPa

2 mm/min | conditioned

8000 MPa

Flexural strength

ISO 178

2 mm/min | d.a.m.

300 MPa

2 mm/min | conditioned

245 MPa

Charpy impact strength

ISO 179-1/1eU

23°C | d.a.m.

92 kJ/m²

23°C | conditioned

102 kJ/m²

-30°C | d.a.m.

90 kJ/m²

Charpy notched impact strength

ISO 179-1/1eA

23°C | d.a.m.

15 kJ/m²

23°C | conditioned

19 kJ/m²

-30°C | d.a.m.

13 kJ/m²

Ball indentation hardness

ISO 2039-1

961N/30s | d.a.m.

255 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

220 °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

0,22 10⁻⁴/K

23°C to 80°C | transverse

0,67 10⁻⁴/K

Temperature index for 50% loss of tensile strength

IEC 60216

5.000 h

160 - 175 °C

20.000 h

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

1,4 g/cm³

Humidity absorption

ISO 1110

70°C, 62% r.H.

1,8 - 2,0 %

Water absorption

ISO 62

23°C, saturated

4,7 - 5,3 %

Molding shrinkage

ISO 294-4

flow

0,1 - 0,3 %

transverse

0,65 - 0,85 %

Electrical Properties

Volume resistivity

IEC 62631-3-1

d.a.m.

$10^{13} \Omega \times \text{cm}$

conditioned

$10^{10} \Omega \times \text{cm}$

Surface resistivity

IEC 62631-3-2

d.a.m.

$10^{12} \Omega$

conditioned

$10^{10} \Omega$

Comparative tracking index

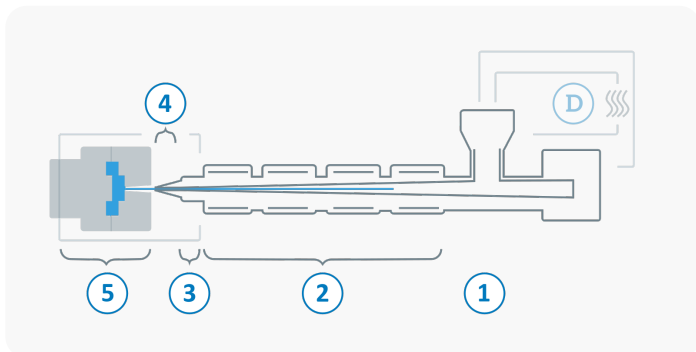
IEC 60112

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	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

