

AKROMID®

A3 GF 35 1 HU natural (8418)

PA66 GF35

AKROMID® A3 GF 35 1 HU natural (8418) is a 35% glass fibre reinforced, heat ageing resistant polyamide 6.6 with high rigidity and strength. This UL94 HB listed grade is suitable for technical components in mechanical engineering and the automotive industry.

Features

heat stabilised 130

E&E

Regulatory



Properties

Modulus

11.900 MPa

Strength

216 MPa

Impact

Na

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

11900 MPa

Tensile stress at break

ISO 527-2

5 mm/min | d.a.m.

216 MPa

Tensile strain at break

ISO 527-2

5 mm/min | d.a.m.

3,1 %

Thermal Properties

Melting temperature

ISO 11357-3

DSC, 10K/min

262 °C

Flammability

Flammability

UL 94

 0,8 mm Wall thickness

HB Class

General Properties

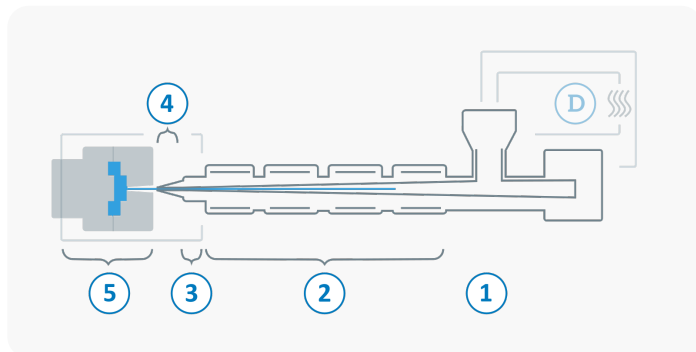
Density ISO 1183	23°C	1,4 g/cm ³
Humidity absorption ISO 1110	70°C, 62% r.H.	1,8 - 2,0 %
Molding shrinkage ISO 294-4	flow	0,1 - 0,3 %
	transverse	0,6 - 0,8 %

Electrical Properties

Comparative tracking index IEC 60112	 Test liquid A	600 V
Comparative tracking index ASTM D3638		0 PLC

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