

AKROMID®

A3 GFM 25/15 1 black (3335)

PA66 (GF25+MD15)

AKROMID® A3 GFM 25/15 1 black (3335) is a 25% glass fibre reinforced, 15% mineral filled, heat stabilised polyamide 6.6 with good surface and dimensional stability

Features

heat stabilised 130

Properties

Modulus

10.000 MPa

Strength

150 MPa

Impact

50 kJ/m²

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

10000 MPa

Tensile stress at break

ISO 527-2

5 mm/min | d.a.m.

150 MPa

Tensile strain at break

ISO 527-2

5 mm/min | d.a.m.

2,4 %

Charpy impact strength

ISO 179-1/1eU

23°C | d.a.m.

50 kJ/m²

Charpy notched impact strength

ISO 179-1/1eA

23°C | d.a.m.

4,5 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

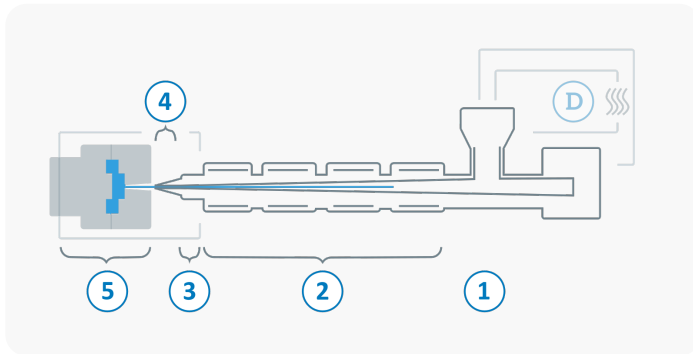
ISO 1183

23°C

1,47 g/cm³

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