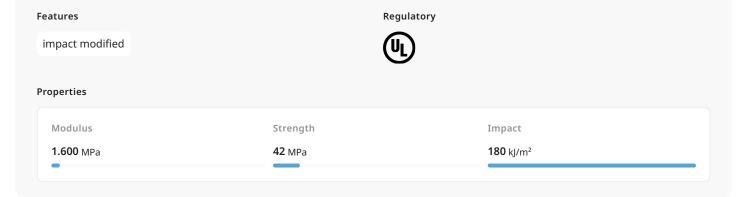


Compound No.: 8180

AKROMID® UL PRELIMINARY A3 S1 white (8180)

PA66-I

AKROMID® A3 S1 white (8180) is an UL94 HB listed unreinforced, impact modified Polyamide 6.6. colored in white similar to RAL 9016. The material is characterised by a very high impact strength even at low temperatures and is therefore perfectly suitable for connecting and fixing systems which are used in the automotive and electro industry and that are exposed to high loading speeds.



Mechanical Properties

1 mm/min d.a.m.	1600 MPa
50 mm/min d.a.m.	42 MPa
50 mm/min d.a.m.	> 70 %
23°C d.a.m.	no break
23°C d.a.m.	90 kJ/m²
	50 mm/min d.a.m. 50 mm/min d.a.m. 23°C d.a.m.

Thermal Properties

Melting temperature	DSC, 10K/min	262 °C
ISO 11357-3		



Compound No.: 8180

Flammability

Flammability UL 94	UL 0,8 mm Wall thickness	HB Class
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General Properties

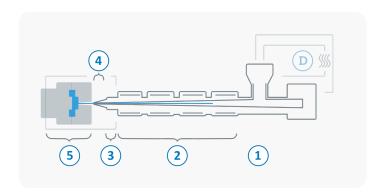
Humidity absorption ISO 1110	70°C, 62% r.H.	1,7 - 2,2 %
Molding shrinkage ISO 294-4	flow transverse	1,3 - 1,5 % 1,5 - 1,7 %





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 (τ <= -30°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	270 - 300 °C
5	Mold temperature	40 - 90 °C
\ominus	Holding pressure, spec.	300 - 800 bar
	Back pressure, spec.	50 - 150 bar
	Injection speed	medium to high
	Screw speed	8 - 15 m/min