+135-3858-6433 (GuangDong)
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AKRO COMPOUNDS

Compound No.: **4748**

AKROMID®
C3 GF 35 1 natural (4748)

PA66+PA6 GF35

AKROMID® C3 GF 35 1 natural (4748) is a 35% glass fiber reinforced polyamide 6.6/6 blend. It is characterised by a 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	Strength	Impact
11.000 MPa	**200** MPa	**100** kJ/m²

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min | d.a.m.	**11000 MPa**
Tensile stress at break ISO 527-2	5 mm/min | d.a.m.	**200 MPa**
Tensile strain at break ISO 527-2	5 mm/min | d.a.m.	**3 %**
Charpy impact strength ISO 179-1/1eU	23°C | d.a.m.	**100 kJ/m²**
Charpy notched impact strength ISO 179-1/1eA	23°C | d.a.m.	**17 kJ/m²**

Thermal Properties

Melting temperature ISO 11357-3	DSC, 10K/min	**260 °C**

General Properties

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Density ISO 1183	23°C	**1,40 g/cm³**
Molding shrinkage ISO 294-4	flow	**0,1 - 0,3 %**
	transverse	**0,55 - 0,75 %**

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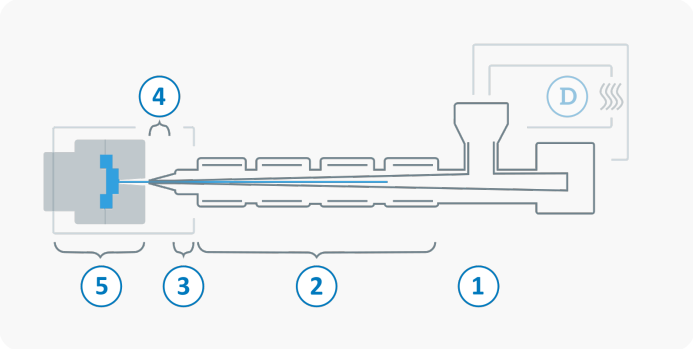
Processing

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 (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 - 300 °C
4	Melt temperature	270 - 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