+135-3858-6433 (GuangDong)
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AKRO COMPOUNDS

Compound No.: **8417**

AKROMID® UL
A3 GF 35 1 HU black (8417)

PA66 GF35

AKROMID® A3 GF 35 1 HU black (8417) is a 35% glass fibre reinforced, heat ageing resistant polyamide 6.6 with high rigidity and strength. The material is colored in black and has a very good flowability. This UL94 HB listed grade is suitable for technical components in mechanical engineering and the automotive industry.

Features

heat stabilised 130 | easy flow | E&E

Regulatory

Properties

Modulus	Strength	Impact
12.000 MPa	**215** MPa	**75** kJ/m²

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min | d.a.m. 1 mm/min | conditioned	**12000 MPa** **9000 MPa**
Tensile stress at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**215 MPa** **145 MPa**
Tensile strain at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**3 %** **4,6 %**
Flexural modulus ISO 178	2 mm/min | d.a.m.	**11000 MPa**
Flexural strength ISO 178	2 mm/min | d.a.m.	**300 MPa**
Flexural strain at break ISO 178	2 mm/min | d.a.m.	**3,3 %**
Charpy impact strength ISO 179-1/1eU	23°C | d.a.m.	**75 kJ/m²**
Charpy notched impact strength ISO 179-1/1eA	23°C | d.a.m.	**12 kJ/m²**

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Thermal Properties

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

Flammability

Flammability UL 94	UL 0,8 mm Wall thickness	**HB Class**

General Properties

Density ISO 1183	23°C	**1,4 g/cm³**
Humidity absorption ISO 1110	70°C, 62% r.H.	**1,8 - 2,0 %**
Molding shrinkage ISO 294-4	flow transverse	**0,1 - 0,3 %** **0,6 - 0,8 %**

Electrical Properties

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

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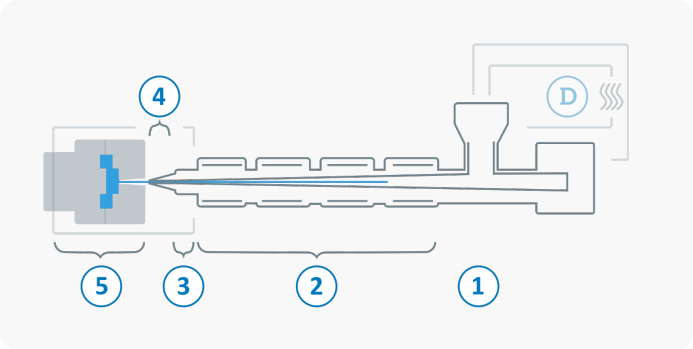
Processing

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 - 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

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Diagrams