

Datasheet**Description:**

AKROMID® B28 GF 30 S3 natural (4835) is a 30% glass fibre reinforced, dry impact resistant, easy flowing polyamide 6 with high stiffness and strength and light inherent color

Applications

Applications are housings and covers for the automotive industry and power tools

Typical values	Test specification	Method	Unit	Value	
				d.a.m.	moist.*

Mechanical Properties

Tensile modulus	1 mm/min	ISO 527-2	MPa	9000	4900
Stress at break	5 mm/min	ISO 527-2	MPa	160	105
Strain at break	5 mm/min	ISO 527-2	%	4,5	10
Flexural modulus	2 mm/min	ISO 178	MPa	7500	
Flexural strength	2 mm/min	ISO 178	MPa	245	
Flexural strain at break	2 mm/min	ISO 178	%	5,5	
Charpy impact strength	23°C	ISO 179-1/1eU	kJ/m ²	100	100
Charpy impact strength	-30°C	ISO 179-1/1eU	kJ/m ²	110	
Charpy notched impact strength	23°C	ISO 179-1/1eA	kJ/m ²	20	30
Charpy notched impact strength	-30°C	ISO 179-1/1eA	kJ/m ²	15	

Thermal Properties

Melting temperature	DSC, 10K/min	DIN EN 11357-1	°C	220	
Temp. of deflection under load HDT/A	1,8 MPa	ISO 75	°C	207	
Temp. of deflection under load HDT/B	0,45 MPa	ISO 75	°C	220	

General Properties

Density	23°C	ISO 1183	g/cm ³	1,3	
Content reinforcement/Content Filler		ISO 1172	%	30	
Humidity absorption	70°C, 62% r.h.	ISO 1110	%	2,1	

Rheological Properties

MVR	275/5	ISO 1133	cm ³ /10min	35	
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Processing

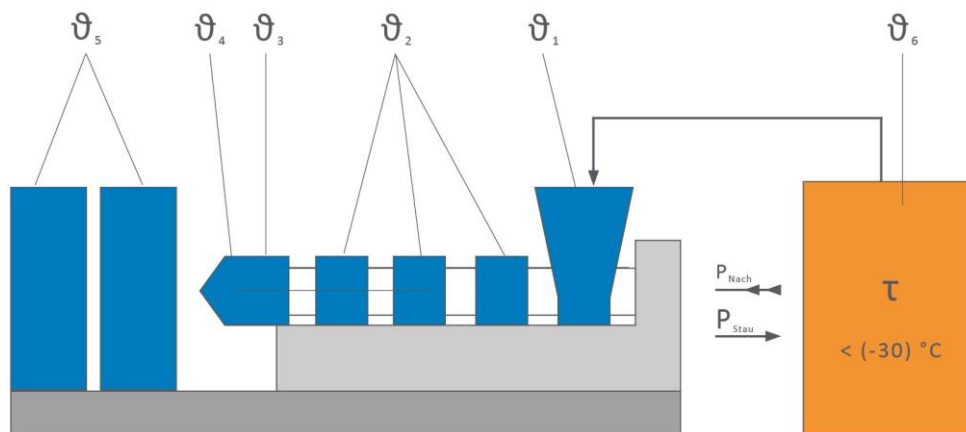
Flowability	8,4 x 1 mm & **	AKRO	mm	160	
Flowability	8,4 x 2 mm & **	AKRO	mm	480	
Flowability	7 x 3,5 mm & **	AKRO	mm	1220	

* = specimen acc. ISO 1110 stored

** = mould temperature: 80°C, melt temperature: 270°C, injection pressure: 750 bar

Continuation

Processing recommendations



ϑ_6	Drying time	h	0 - 4
ϑ_6	Drying temperature	°C	80
	Processing moisture	%	0,02 - 0,1
ϑ_1	Feed section	°C	60 - 80
ϑ_2	Section 1 - Section 4	°C	240 - 290
ϑ_3	Nozzle	°C	260 - 300
ϑ_4	Melt	°C	270 - 290
ϑ_5	Mould	°C	80 - 100
P_{Nach}	Holding pressure, spec.	bar	300 - 800
P_{Stau}	Back pressure, spez.	bar	50 - 150
	Injection speed		medium to high
	Screw speed	m/min	8 - 15

The listed values are recommendations. Higher values should be used for higher glass loadings. We recommend only de-humidifying or vacuum dryers. Extensive drying can cause filling problems and surface defects.