AKROMID ®

B3 GK 30 black (1827)

PA6 GB30

AKRO-PLASTIC GmbH
Member of the Feddersen Group

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Datasheet

Description:

AKROMID® B3 GK 30 black (1827) is a 30% glass bead filled polyamide 6 with low warpage and high surface appearance

Applications

Housings and covers in the automotive-, electro- and furniture industry

Typical values	Test specification	Method	Unit	Value	
				d.a.m.	moist.*
Mechanical Properties					
Tensile modulus	1 mm/min	ISO 527-2	MPa	4500	2000
Stress at break	5 mm/min	ISO 527-2	MPa	75	40
Strain at break	5 mm/min	ISO 527-2	%	> 3,5	> 25
Flexural modulus	2 mm/min	ISO 178	MPa	3300	
Flexural strength	2 mm/min	ISO 178	MPa	110	
Charpy impact strength	23°C	ISO 179-1/1eU	kJ/m²	20	40
Charpy notched impact strength	23°C	ISO 179-1/1eA	kJ/m²	3	5
Ball indentation hardness	961/30	ISO 2039-1	MPa	180	
Thermal Properties					
Melting temperature	DSC, 10K/min	DIN EN 11357-1	°C	222	
Temp. of deflection under load HDT/A	1,8 MPa	ISO 75	°C	70	
Temp. of deflection under load HDT/B	0,45 MPa	ISO 75	°C	185	
Vicat softening temperature B50	50 K/h	ISO 306	°C	205	
Flammability					
Wall thickness			mm	0,4 / 0,8 / 1,6 / 2,0 / 3,2	
Flammability		UL 94	class	HB	
Burning rate (< 100 mm/min)	> 1 mm thickness	FMVSS 302		+	
General Properties					
Density	23°C	ISO 1183	g/cm³	1,34	
Content reinforcement/Content Filler		ISO 1172	%	30	
Humidity absorption	70°C, 62% r.h.	ISO 1110	%	2,1	
Water absorption	23°C, saturated	ISO 62	%	6,5	
Processing					
Flowability	8,4 x 1 mm & **	AKRO	mm	120	
Flowability	8,4 x 2 mm & **	AKRO	mm	360	
Molding shrinkage	flow	ISO 294-4	%	1,1	
Molding shrinkage	transverse	ISO 294-4	%	1,2	

* = specimen acc. ISO 1110 stored

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

AKRO-PLASTIC GmbH
Commercial registered office: Niederzissen
Commercial Register: Koblenz HRB 12227
Managing Director: Andreas Stuber, Dirk Steinbrück
Chairman of the Supervisory Board: Dr. Matthias von Rönn

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AKRO-PLASTIC Think Polyamide

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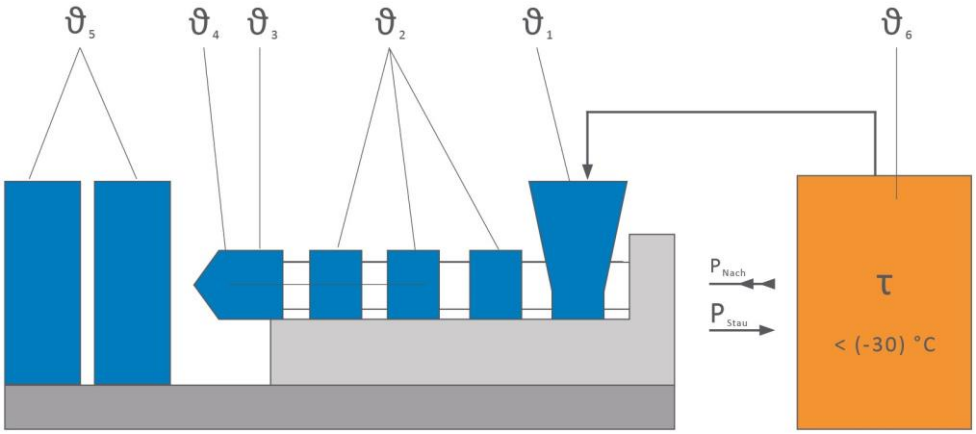
Continuation

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.

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