

Datasheet

Description:

AKROMID® B3 GK 30 natural (2719) is a 30% glass bead filled polyamide 6 with low warpage, high surface finish and light inherent color

Applications

Applications are 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	4400	1820
Stress at break	5 mm/min	ISO 527-2	MPa	70	38
Strain at break	5 mm/min	ISO 527-2	%	5	35
Flexural modulus	2 mm/min	ISO 178	MPa	3140	1570
Flexural strength	2 mm/min	ISO 178	MPa	95	55
Charpy impact strength	23°C	ISO 179-1/1eU	kJ/m ²	30	60
Charpy notched impact strength	23°C	ISO 179-1/1eA	kJ/m ²	3	5
Ball indentation hardness	961/30	ISO 2039-1	MPa	180	

Electrical Properties

Volume resistivity		IEC 60093	Ohm x cm	1,0E+15
Surface resistivity		b.o. IEC 60093	Ohm	1,0E+13

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/cm ³	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

Rheological Properties

MVR	275/5	ISO 1133	cm ³ /10min	100
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Processing

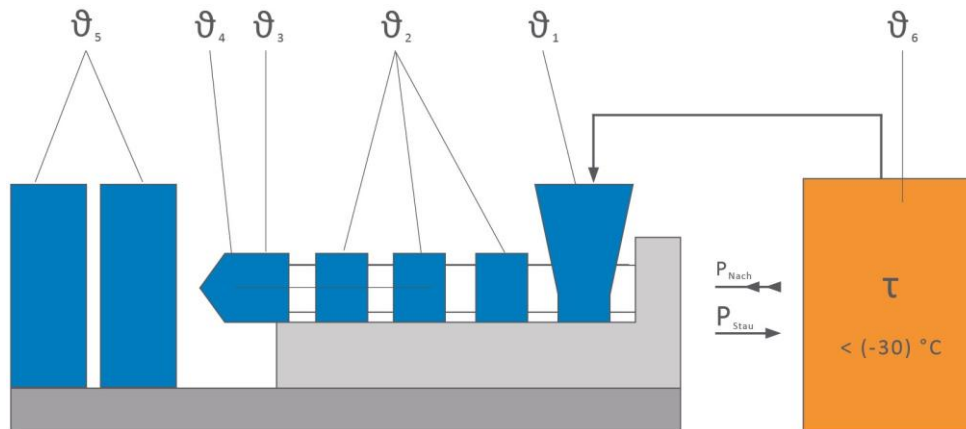
Molding shrinkage	flow	ISO 294-4	%	1,0
Molding shrinkage	transverse	ISO 294-4	%	1,0

b.o.: based on

* = specimen acc. ISO 1110 stored

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.