

Datasheet

Description:

AKROMID® B3 GM 15/15 natural (3079) is a 15% glass fibre and 15% glass bead reinforced polyamide 6 with good surface, low warpage and light inherent color

Applications

Handles and switches in the automotive and electro industry.

Typical values	Test specification	Method	Unit	Value d.a.m.
----------------	--------------------	--------	------	-----------------

Mechanical Properties

Tensile modulus	1 mm/min	ISO 527-2	MPa	7200
Stress at break	5 mm/min	ISO 527-2	MPa	130
Strain at break	5 mm/min	ISO 527-2	%	3,5
Charpy impact strength	23°C	ISO 179-1/1eU	kJ/m ²	64
Charpy notched impact strength	23°C	ISO 179-1/1eA	kJ/m ²	6

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	200
Temp. of deflection under load HDT/B	0,45 MPa	ISO 75	°C	221

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

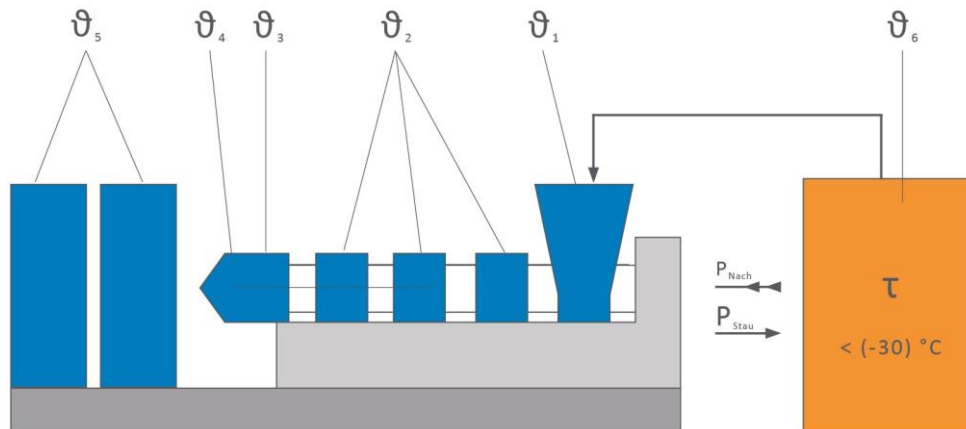
Density	23°C	ISO 1183	g/cm ³	1,34
Content reinforcement/Content Filler		ISO 1172	%	30

Processing

Molding shrinkage	flow	ISO 294-4	%	0,3
Molding shrinkage	transverse	ISO 294-4	%	1,1

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.