

Datasheet**Description:**

AKROMID® B3 natural (1024) is an unreinforced polyamide 6 with light inherent color

Applications

Handles and metal fittings in the electro- and electronic market as well as in the furniture industry, and parts in food industry

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

Mechanical Properties

Tensile modulus	1 mm/min	ISO 527-2	MPa	3200	910
Stress at yield	50 mm/min	ISO 527-2	MPa	83	43
Strain at yield	50 mm/min	ISO 527-2	%	4	20
Strain at break	50 mm/min	ISO 527-2	%	> 30	> 100
Flexural modulus	2 mm/min	ISO 178	MPa	3200	1100
Flexural strength	2 mm/min	ISO 178	MPa	120	
Charpy impact strength	23°C	ISO 179-1/1eU	kJ/m ²	n.b.	n.b.
Charpy impact strength	-30°C	ISO 179-1/1eU	kJ/m ²	n.b.	
Charpy notched impact strength	23°C	ISO 179-1/1eA	kJ/m ²	5	25
Charpy notched impact strength	-30°C	ISO 179-1/1eA	kJ/m ²	4	

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	57	
Temp. of deflection under load HDT/B	0,45 MPa	ISO 75	°C	160	

Flammability

Wall thickness			mm	0,4	0,8	1,6	2,0	3,2
Flammability		UL 94	class			V2		
GWFI		IEC 60695-2-12	°C			750		
GWIT		IEC 60695-2-13	°C			675		
Burning rate (< 100 mm/min)	> 1 mm thickness	FMVSS 302				+		

General Properties

Density	23°C	ISO 1183	g/cm ³	1,13	
Humidity absorption	70°C, 62% r.h.	ISO 1110	%	2,5	
Water absorption	23°C, saturated	ISO 62	%	9 - 10	

Processing

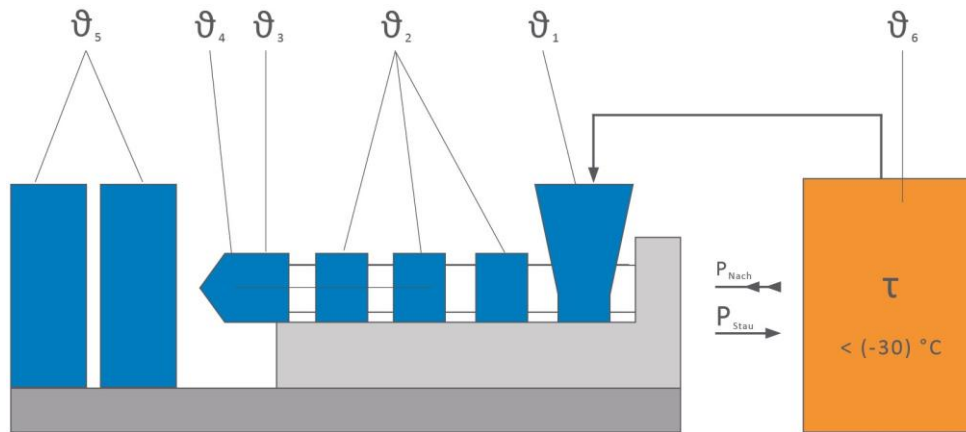
Molding shrinkage	flow	ISO 294-4	%	1,0 - 1,2	
Molding shrinkage	transverse	ISO 294-4	%	1,1 - 1,3	

n.b. = not broken

* = 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	220 - 270
ϑ_3	Nozzle	°C	230 - 300
ϑ_4	Melt	°C	240 - 270
ϑ_5	Mould	°C	40 - 80
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.