

PA6 – Polyamide 6 PA6 GF15

AKROMID® B3 GF 15 black (4002)

Tensile modulus

5900 MPa

1 mm/min

ISO 527-2

Stress at break

120 MPa

5 mm/min

ISO 527-2

Charpy impact strength

37 kJ/m²

23°C

ISO 179-1/1eU

AKROMID® B3 GF 15 black (4002) is a 15% glass fibre reinforced polyamide 6 with medium stiffness and strength

Typical applications

Mainly components in mechanical engineering and in the automotive industry



Mechanical Properties

Tensile modulus (1 mm/min ISO 527-2) d.a.m.	5900 MPa
Stress at break (5 mm/min ISO 527-2) d.a.m.	120 MPa
Strain at break (5 mm/min ISO 527-2) d.a.m.	3 %
Flexural modulus (2 mm/min ISO 178) d.a.m.	5800 MPa
Flexural strength (2 mm/min ISO 178) d.a.m.	180 MPa
Charpy impact strength (23°C ISO 179-1/1eU) d.a.m.	37 kJ/m ²
Charpy impact strength (-30°C ISO 179-1/1eU) d.a.m.	35 kJ/m ²
Charpy notched impact strength (23°C ISO 179-1/1eA) d.a.m.	6 kJ/m ²
Charpy notched impact strength (-30°C ISO 179-1/1eA) d.a.m.	5,5 kJ/m ²



Thermal Properties

Temperature of deflection under load HDT/A (1,8 MPa ISO 75)	205 °C
Melt temperature (DSC, 10K/min DIN EN 11357-1)	220 °C



Flammability

Burning rate (UL 94) 1,6mm Wall thickness	HB Class
Burning rate (<100 mm/min) (> 1 mm Thickness FMVSS 302)	+



General properties

Density (23°C ISO 1183)	1,23 g/cm ³
---------------------------	------------------------

Disclaimer:

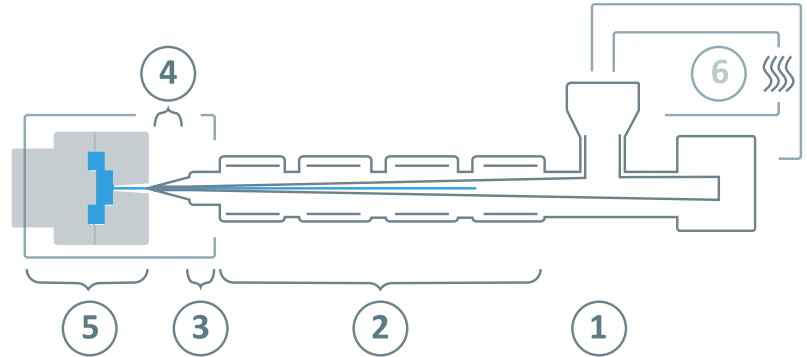
All specifications and information given on this website are based on our current knowledge and experience. A legally binding promise of certain characteristics or suitability for a concrete individual case cannot be derived from this information. The information supplied here is not intended to release processors and users from the responsibility of carrying out their own tests and inspections in each concrete individual case. AKRO®, AKROMID®, AKROLEN®, AKROLOY®, AKROTEK®, ICX® and PRECITE® are registered trademarks of the Feddersen Group.

PA6 – Polyamide 6 PA6 GF15

AKROMID® B3 GF 15 black (4002)

Processing information

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



⑥	Drying time	0 - 4 h
	Drying temperature ($\tau \leq -30^\circ\text{C}$)	80°C
	Processing moisture	0,02 - 0,1%
①	Feed section	60 - 80°C
②	Temperature zone 1 - Zone 4	240 - 290°C
③	Nozzle temperature	260 - 300°C
④	Melt temperature	270 - 290°C
⑤	Mold temperature	80 - 100°C
→	Holding pressure, spec.	300 - 800 bar
←	Back pressure, spec.	50 - 150 bar
	Injection speed	medium to high
	Screw speed	8 - 15 m/min

Disclaimer:

All specifications and information given on this website are based on our current knowledge and experience. A legally binding promise of certain characteristics or suitability for a concrete individual case cannot be derived from this information. The information supplied here is not intended to release processors and users from the responsibility of carrying out their own tests and inspections in each concrete individual case. AKRO®, AKROMID®, AKROLEN®, AKROLOY®, AKROTEK®, ICX® and PRECITE® are registered trademarks of the Feddersen Group.