

PA6 – Polyamide 6 PA6 + PP GF30

AKROMID® B3 GF 30 1 L natural (4684)

Tensile modulus

8500 MPa

1 mm/min

ISO 527-2

Stress at break

150 MPa

5 mm/min

ISO 527-2

Charpy impact strength

70 kJ/m²

23°C

ISO 179-1/1eU

AKROMID® B3 GF 30 1 L natural (4684) is a 30% glass fibre reinforced and heat stabilised polyamide-blend with a reduced density compared to standard PA6 GF 30

Typical applications

Technical components in the automotive and electronic industry, where a weight and cost reduction is required

**Mechanical Properties**

Tensile modulus (1 mm/min | ISO 527-2)

d.a.m.

8500 MPa

conditioned

6500 MPa

Stress at break (5 mm/min | ISO 527-2)

d.a.m.

150 MPa

conditioned

100 MPa

Strain at break (5 mm/min | ISO 527-2)

d.a.m.

3,2 %

conditioned

3,7 %

Flexural modulus (2 mm/min | ISO 178)

d.a.m.

8800 MPa

conditioned

6500 MPa

Flexural strength (2 mm/min | ISO 178)

d.a.m.

210 MPa

conditioned

150 MPa

Flexural strain at break (2 mm/min | ISO 178)

d.a.m.

3 %

conditioned

3,9 %

Charpy impact strength (23°C | ISO 179-1/1eU)

d.a.m.

70 kJ/m²

Charpy notched impact strength (23°C | ISO 179-1/1eA)

d.a.m.

17 kJ/m²**Thermal Properties**

Temperature of deflection under load HDT/A (1,8 MPa | ISO 75)

203 °C

Melting temperature (DSC, 10K/min | DIN EN 11357-1)

220 °C

**Flammability**

Burning rate (UL 94)

0,8mm Wall thickness

HB Class

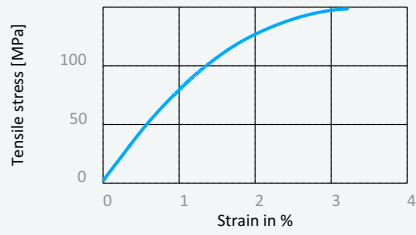
Burning rate (<100 mm/min) (> 1 mm Thickness | FMVSS 302)

+

Disclaimer:

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Stress strain chart at 23°C



General properties

Density (23°C | ISO 1183)

1,26 g/cm³



Rheological Properties

MVR (275°C/5kg | ISO 1133)

14 cm³/10min

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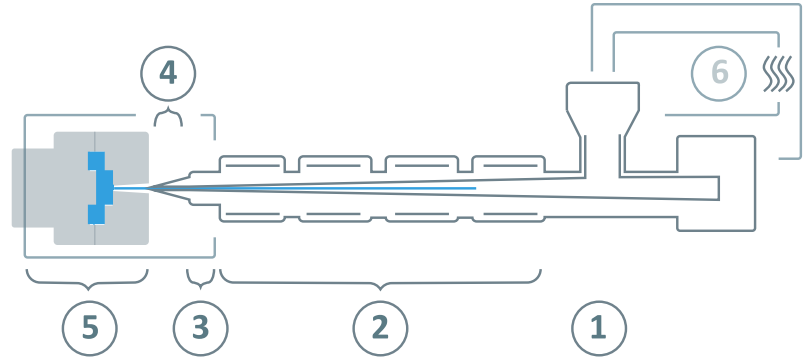
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Processing information

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	220 - 290°C
③	Nozzle temperature	240 - 300°C
④	Melt temperature	240 - 290°C
⑤	Mold temperature	70 - 100°C
→	Holding pressure, spec.	300 - 800 bar
←	Back pressure, spec.	50 - 150 bar
	Injection speed	medium to high
	Screw speed	5 - 15 m/min

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