

PA6 – Polyamide 6 PA6-I GF30

## AKROMID® B28 GF 30 S3 natural (4835)

Tensile modulus

**9000 MPa**

1 mm/min

ISO 527-2

Stress at break

**160 MPa**

5 mm/min

ISO 527-2

Charpy impact strength

**100 kJ/m<sup>2</sup>**

23°C

ISO 179-1/1eU

AKROMID® B28 GF 30 S3 natural (4835) is a 30% glass fibre reinforced, dry impact resistant, easy flowing polyamide 6 with high stiffness and strength and light inherent color

### Typical applications

Housings and covers for the automotive industry and power tools



### Mechanical Properties

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

d.a.m.

9000 MPa

conditioned

4900 MPa

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

d.a.m.

160 MPa

conditioned

105 MPa

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

d.a.m.

4,5 %

conditioned

10 %

Flexural modulus (2 mm/min | ISO 178)

d.a.m.

7500 MPa

Flexural strength (2 mm/min | ISO 178)

d.a.m.

245 MPa

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

d.a.m.

5,5 %

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

d.a.m.

100 kJ/m<sup>2</sup>

conditioned

100 kJ/m<sup>2</sup>

Charpy impact strength (-30°C | ISO 179-1/1eU)

d.a.m.

110 kJ/m<sup>2</sup>

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

d.a.m.

20 kJ/m<sup>2</sup>

conditioned

30 kJ/m<sup>2</sup>

Charpy notched impact strength (-30°C | ISO 179-1/1eA)

d.a.m.

15 kJ/m<sup>2</sup>

### Thermal Properties

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

207 °C

Temperature of deflection under load HDT/B (0,45 MPa | ISO 75)

220 °C

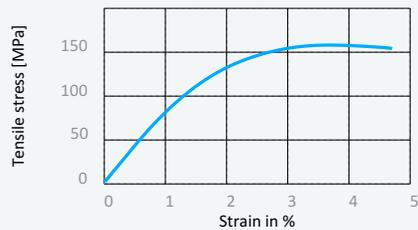
Melt temperature (DSC, 10K/min | DIN EN 11357-1)

220 °C

#### Disclaimer:

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Stress strain chart at 23°C

**General properties**

Density (23°C   ISO 1183)	1,3 g/cm <sup>3</sup>
Humidity absorption (70°C, 62% r.H.   ISO 1110)	2,1 %
Molding shrinkage (flow   ISO 294-4)	0,1 - 0,3 %
Molding shrinkage (transverse   ISO 294-4)	0,5 - 0,7 %

**Rheological Properties**

MVR (275°C/5kg   ISO 1133)	35 cm <sup>3</sup> /10min
Flowability (1mm Thickness   AKRO)	160 mm
Flowability (2mm Thickness   AKRO)	480 mm

**Disclaimer:**

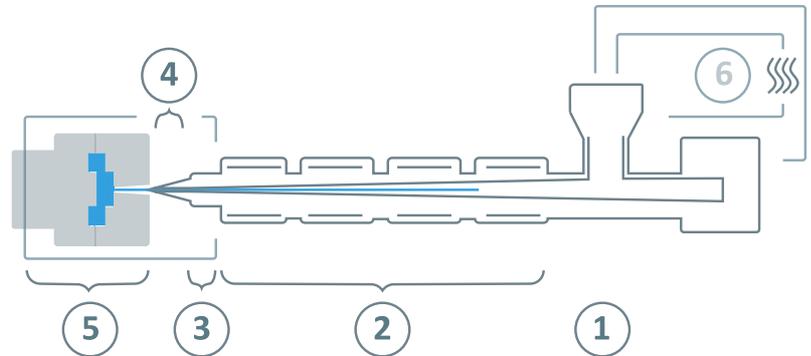
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### Processing information

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	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

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