

PA6 – Polyamide 6 PA6

AKROMID® B3 natural (5230)

Tensile modulus

3300 MPa

1 mm/min

ISO 527-2

Stress at yield

85 MPa

50 mm/min

ISO 527-2

Charpy impact strength

n.b.

23°C

ISO 179-1/1eU

AKROMID® B3 natural (5230) is an unreinforced Polyamid 6 with light inherent color.

Typical applications

Engineering parts like fasteners, clips, plugs and caps.



Mechanical Properties

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

d.a.m.

3300 MPa

conditioned

1100 MPa

Stress at yield (50 mm/min | ISO 527-2)

d.a.m.

85 MPa

conditioned

45 MPa

Strain at yield (50 mm/min | ISO 527-2)

d.a.m.

25 %

conditioned

> 50 %

Flexural modulus (2 mm/min | ISO 178)

d.a.m.

2800 MPa

conditioned

1000 MPa

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

d.a.m.

n.b.

conditioned

n.b.

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

d.a.m.

6 kJ/m²

conditioned

18 kJ/m²



Thermal Properties

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

220 °C



General properties

Density (23°C | ISO 1183)

1,13 g/cm³

Disclaimer:

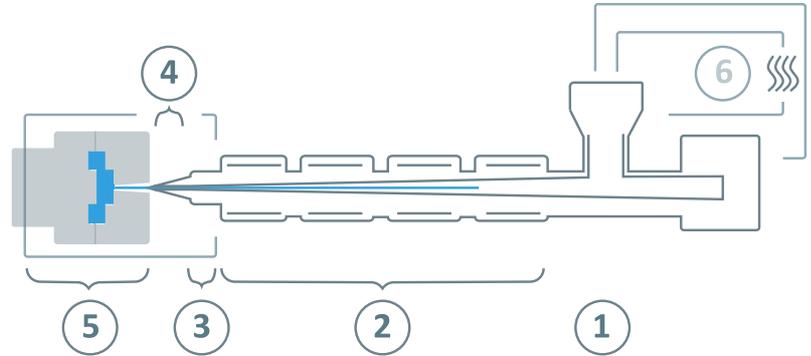
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Processing information

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	220 - 270°C
③	Nozzle temperature	230 - 300°C
④	Melt temperature	240 - 270°C
⑤	Mold temperature	40 - 80°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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