

PA6 – Polyamide 6 PA6

## AKROMID® B3 3 natural (5772)

Tensile modulus

**3200 MPa**

1 mm/min

ISO 527-2

Stress at yield

**80 MPa**

50 mm/min

ISO 527-2

Charpy impact strength

**23°C**

ISO 179-1/1eU

AKROMID® B3 3 natural (5772) is an unreinforced, nucleated polyamide 6 with light inherent color.

### Typical applications

Applications are thin wall parts and housings for the electro- and electronic market as well as for furniture and mechanical engineering



### Mechanical Properties

Tensile modulus (1 mm/min   ISO 527-2) d.a.m.	3200 MPa
Stress at yield (50 mm/min   ISO 527-2) d.a.m.	80 MPa
Strain at yield (50 mm/min   ISO 527-2) d.a.m.	4 %
Strain at break (50 mm/min   ISO 527-2) d.a.m.	20 %



### Thermal Properties

Melt temperature (DSC, 10K/min   DIN EN 11357-1)	220 °C
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### Flammability

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



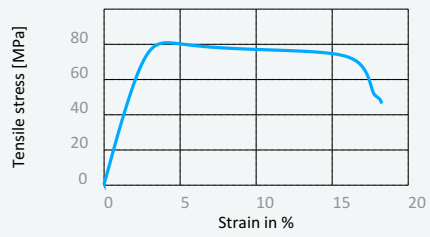
### General properties

Density (23°C   ISO 1183)	1,13 g/cm <sup>3</sup>
Molding shrinkage (flow   ISO 294-4)	1,0-1,2 %
Molding shrinkage (transverse   ISO 294-4)	1,1-1,3 %

#### Disclaimer:

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Stress strain chart at 23°C



**Disclaimer:**

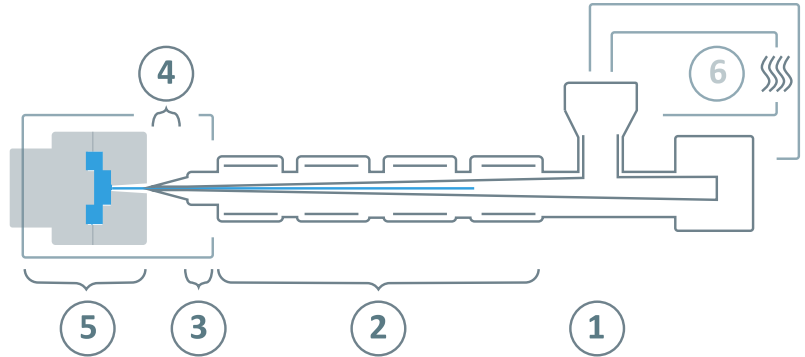
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### Processing information

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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