

PA6 – Polyamide 6 PA6 GF35

AKROMID® B3 GF 35 5 XTC black (7408)

Tensile modulus

11500 MPa

1 mm/min

ISO 527-2

Stress at break

190 MPa

5 mm/min

ISO 527-2

Charpy impact strength

90 kJ/m²

23°C

ISO 179-1/1eU

AKROMID® B3 GF 35 5 XTC black (7408) is a 35% glass fibre reinforced, high temperature stabilised polyamide 6 with high stiffness and strength and extra high temperature tolerance.

Typical applications

Functional parts in the mechanical engineering and the automotive industry.



Mechanical Properties

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

d.a.m.

11500 MPa

conditioned

8000 MPa

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

d.a.m.

190 MPa

conditioned

110 MPa

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

d.a.m.

3,1 %

conditioned

5 %

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

d.a.m.

90 kJ/m²

conditioned

100 kJ/m²



Thermal Properties

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

210 °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)

1,41 g/cm³

Humidity absorption (70°C, 62% r.H. | ISO 1110)

1,9 - 2,1 %

Molding shrinkage (flow | ISO 294-4)

0,2 ± 0,1 %

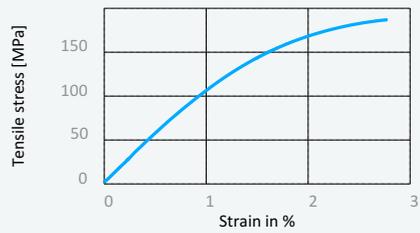
Molding shrinkage (transverse | ISO 294-4)

0,6 ± 0,1 %

Disclaimer:

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Stress strain chart at 23°C



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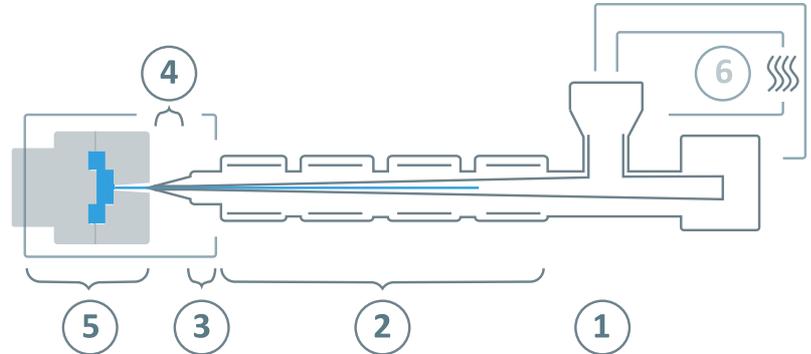
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Processing information

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	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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