

PA6 – Polyamide 6 PA6+PP GF30

## AKROMID® B3 GF 30 4 L black (7481)

Tensile modulus

**9000 MPa**

1 mm/min

ISO 527-2

Stress at break

**145 MPa**

5 mm/min

ISO 527-2

Charpy impact strength

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

23°C

ISO 179-1/1eU

**AKROMID® B3 GF 30 4 L black (7481) is a 30% glass fibre reinforced, hydrolysis 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.	9000 MPa
conditioned	7000 MPa
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Stress at break (5 mm/min   ISO 527-2)	
d.a.m.	145 MPa
conditioned	110 MPa
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Strain at break (5 mm/min   ISO 527-2)	
d.a.m.	3,1 %
conditioned	4,6 %
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Flexural modulus (2 mm/min   ISO 178)	
d.a.m.	9200 MPa
conditioned	6500 MPa
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Flexural strength (2 mm/min   ISO 178)	
d.a.m.	225 MPa
conditioned	160 MPa
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Flexural strain at break (2 mm/min   ISO 178)	
d.a.m.	3,4 %
conditioned	4,3 %
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Charpy impact strength (23°C   ISO 179-1/1eU)	
d.a.m.	70 kJ/m <sup>2</sup>
conditioned	65 kJ/m <sup>2</sup>
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Charpy notched impact strength (23°C   ISO 179-1/1eA)	
d.a.m.	17 kJ/m <sup>2</sup>
conditioned	18 kJ/m <sup>2</sup>



### Thermal Properties

Temperature of deflection under load HDT/A (1,8 MPa   ISO 75)	200 °C
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Temperature of deflection under load HDT/B (0,45 MPa   ISO 75)	217 °C
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Melting temperature (DSC, 10K/min   DIN EN 11357-1)	220 °C



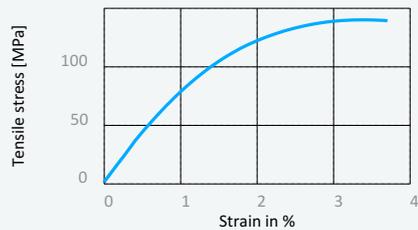
### Flammability

Burning rate (UL 94)	
0,8mm Wall thickness	HB Class
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Burning rate (<100 mm/min) (> 1 mm Thickness   FMVSS 302)	+

#### Disclaimer:

All specifications and information given on this website are based on our current knowledge and experience. A legally binding promise of certain characteristics or suitability for a concrete individual case cannot be derived from this information. The information supplied here is not intended to release processors and users from the responsibility of carrying out their own tests and inspections in each concrete individual case. AKRO®, AKROMID®, AKROLEN®, AKROLOY®, AKROTEK®, ICX® and PRECITE® are registered trademarks of the Feddersen Group.

Stress strain chart at 23°C



### General properties

Density (23°C   ISO 1183)	1,26 g/cm <sup>3</sup>
Humidity absorption (70°C, 62% r.F.   ISO 1110)	1,4 %
Molding shrinkage (flow   ISO 294-4)	0,1 - 0,3 %
Molding shrinkage (transverse   ISO 294-4)	0,5 - 0,7 %

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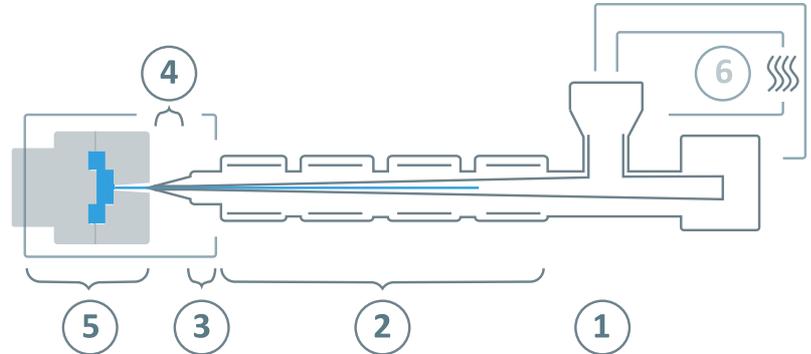
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### Processing information

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	Melting 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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