

PA6 – Polyamide 6 PA6 GF30

AKROMID® B3 GF 30 9 black (7658)

Tensile modulus

9300 MPa

1 mm/min

ISO 527-2

Stress at break

165 MPa

5 mm/min

ISO 527-2

Charpy impact strength

23°C

ISO 179-1/1eU

AKROMID® B3 GF 30 9 black (7658) is a 30% glass fibre reinforced, process-optimised polyamide 6 with high rigidity and strength

Typical applications

Mainly components in mechanical engineering and in the automotive industry



Mechanical Properties

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

d.a.m.

9300 MPa

conditioned

5200 MPa

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

d.a.m.

165 MPa

conditioned

90 MPa

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

d.a.m.

3,3 %

conditioned

5,8 %



Thermal Properties

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

210 °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



Flammability

Burning rate (<100 mm/min) (> 1 mm Thickness | FMVSS 302)

+



General properties

Density (23°C | ISO 1183)

1,36 g/cm³

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

2,1 - 2,3 %

Water absorption 23°C saturated (23°C, saturated | ISO 62)

6,3 - 6,9 %

Molding shrinkage (flow | ISO 294-4)

0,1 - 0,3 %

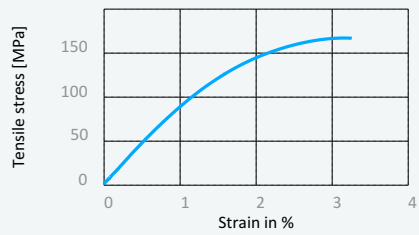
Molding shrinkage (transverse | ISO 294-4)

0,5 - 0,7 %

Disclaimer:

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Stress strain chart at 0°C



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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.

Drying time	0 - 4 h
Drying temperature ($\tau \leq -30^{\circ}\text{C}$)	80°C
Processing moisture	0,02 - 0,1%
Feed section	60 - 80°C
Temperature zone 1 - Zone 4	240 - 290°C
Nozzle temperature	260 - 300°C
Melt temperature	270 - 290°C
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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