

PA6 – Polyamide 6 PA6 GF35

AKROMID® B3 GF 35 1 EN LT black (7763)

Tensile modulus

11500 MPa

1 mm/min

ISO 527-2

Stress at break

195 MPa

5 mm/min

ISO 527-2

Charpy impact strength

100 kJ/m²

23°C

ISO 179-1/1eU

AKROMID® B3 GF 35 1 EN LT black (7763) is a 35% glass fibre reinforced, heat stabilised, electrical neutral, laser transparent polyamide 6 with high stiffness and strength

Typical applications

Components in mechanical engineering, electro and electronics as well as in the automotive industry



Mechanical Properties

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

d.a.m.

11500 MPa

conditioned

7300 MPa

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

d.a.m.

195 MPa

conditioned

120 MPa

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

d.a.m.

2,8 %

conditioned

4,5 %

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

d.a.m.

100 kJ/m²

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

d.a.m.

15 kJ/m²



Thermal Properties

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

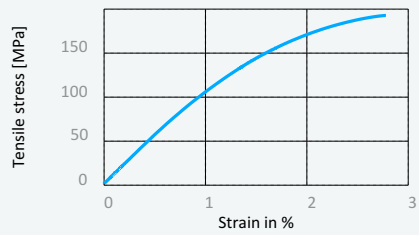
Density (23°C | ISO 1183)

1,41 g/cm³

Disclaimer:

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Stress strain chart at 23°C



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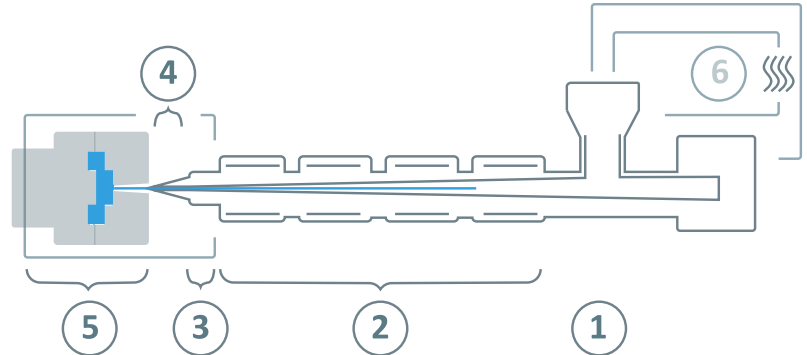
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Processing information

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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