+135-3858-6433 (GuangDong)
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AKRO COMPOUNDS

Compound No.: **8953**

AKROMID® PRELIMINARY
B25 GF 30 6 LA black (8953)

PA6 GF30

AKROMID® B25 GF 30 6 LA black (8953) is a 30% glass fiber reinforced easy flowing polyamide 6. It is characterised by a high stiffness and strength even at higher temperature. Furthermore, the material is inorganically high heat stabilised and therefore perfectly suitable for technical parts in industrial engineering and in the automotive industry. The material is laser markable.

Features

heat stabilised 160

Properties

Modulus	Strength	Impact
10.000 MPa	**175** MPa	**100** kJ/m²

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min | d.a.m. 1 mm/min | conditioned	**10000 MPa** **8000 MPa**
Tensile stress at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**175 MPa** **110 MPa**
Tensile strain at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**3,8 %** **9,4 %**
Charpy impact strength ISO 179-1/1eU	23°C | d.a.m. 23°C | conditioned	**100 kJ/m²** **100 kJ/m²**

Thermal Properties

Temperature of deflection under load HDT/A ISO 75	1,8 MPa	**210 °C**
Melting temperature ISO 11357-3	DSC, 10K/min	**220 °C**

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Flammability

Flammability UL 94	1,6 mm Wall thickness	**HB Class**

General Properties

Density ISO 1183	23°C	**1,36 g/cm³**
Humidity absorption ISO 1110	70°C, 62% r.H.	**2,1 - 2,3 %**
Molding shrinkage ISO 294-4	flow transverse	**0,1 - 0,3 %** **0,5 - 0,7 %**

Electrical Properties

Volume resistivity IEC 62631-3-1	d.a.m. conditioned	**10^{13} Ω x cm** **10^{10} Ω x cm**
Surface resistivity IEC 62631-3-2	d.a.m. conditioned	**10^{12} Ω** **10^{10} Ω**

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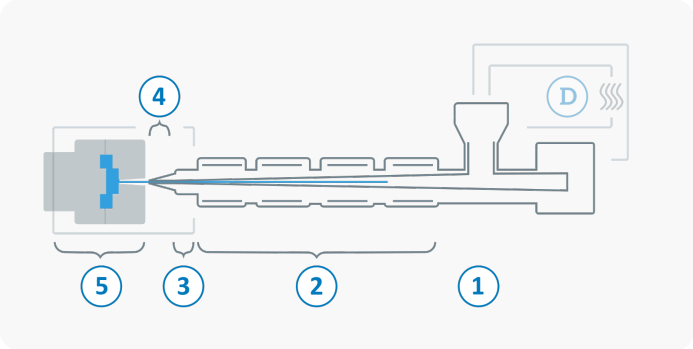
Processing

The values mentioned are recommendations. We only recommend desiccant / dry air dryers or vacuum dryers. Too long a drying time and the resulting residual moisture content below the lower limit can lead to filling problems and surface defects. The specified drying time refers to closed and undamaged bagged material. When processing from previously opened bags or from octabins with polyolefin inliners, a longer drying time may be necessary. It is recommended to check the residual moisture content after the drying process.



D	Drying time	0 - 4 h
	Drying temperature (τ <= -30°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