+135-3858-6433 (GuangDong)
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+852-6957-5415 (HongKong)

Compound No.: **8348**

AKROMID®
B28 GF 30 S3 natural (8348)

PA6-I GF30

AKROMID® B28 GF 30 S3 natural (8348) is a 30% glass fibre reinforced, easy flowing polyamide 6. Furthermore, the material is impact modified and therefore characterised by a higher dry impact strength compared to standard PA 6 GF 30. Its high strength and stiffness make it the material of your choice for technical applications in industrial engineering and in the furniture industry. The material has a light inherent color.

Features

impact modified | easy flow

Properties

Modulus	Strength	Impact
8.900 MPa	**160** MPa	**100** kJ/m²

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min | d.a.m. 1 mm/min | conditioned	**8900 MPa** **5000 MPa**
Tensile stress at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**160 MPa** **105 MPa**
Tensile strain at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**4,5 %** **10 %**
Charpy impact strength ISO 179-1/1eU	23°C | d.a.m. 23°C | conditioned	**100 kJ/m²** **100 kJ/m²**
Charpy notched impact strength ISO 179-1/1eA	23°C | d.a.m. 23°C | conditioned	**15 kJ/m²** **30 kJ/m²**

Thermal Properties

Melting temperature ISO 11357-3	DSC, 10K/min	**220 °C**

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Flammability

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

General Properties

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

Rheological Properties

MVR ISO 1133	275°C/5kg	**35 cm³/10 min**

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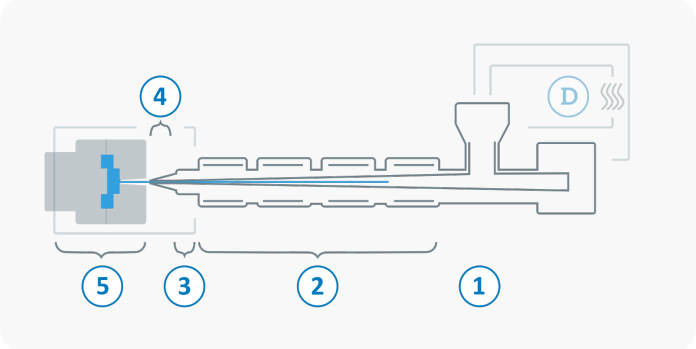
Processing

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