

AKROMID®

B28 GF 30 S3 white (8349)

PA6-I GF30

AKROMID® B28 GF 30 S3 white (8349) 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 is colored similar to RAL9003.

Features

impact modified

Properties

Modulus

8.900 MPa

Strength

150 MPa

Impact

94 kJ/m²

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

8900 MPa

Tensile stress at break

ISO 527-2

5 mm/min | d.a.m.

150 MPa

Tensile strain at break

ISO 527-2

5 mm/min | d.a.m.

4 %

Flexural modulus

ISO 178

2 mm/min | d.a.m.

8200 MPa

Flexural strength

ISO 178

2 mm/min | d.a.m.

240 MPa

Flexural strain at break

ISO 178

2 mm/min | d.a.m.

4,5 %

Charpy impact strength

ISO 179-1/1eU

23°C | d.a.m.

94 kJ/m²

Charpy notched impact strength

ISO 179-1/1eA

23°C | d.a.m.

18 kJ/m²

Thermal Properties

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

Flammability

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

General Properties

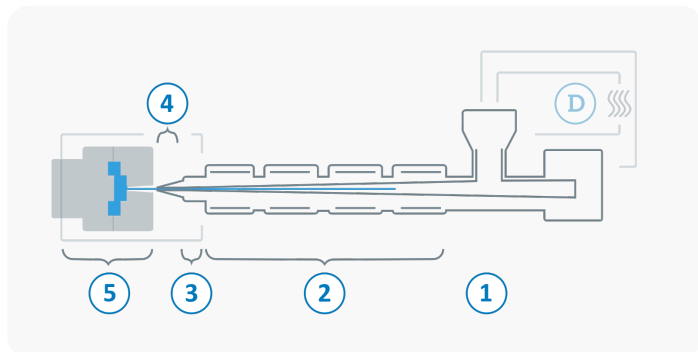
Density	23°C	1,30 g/cm ³
ISO 1183		
Molding shrinkage	flow	0,1 - 0,3 %
	transverse	0,5 - 0,7 %
ISO 294-4		

Rheological Properties

Flowability	1 mm Thickness	130 mm
	2 mm Thickness	450 mm
AKRO		
MVR	275°C/5kg	31 cm ³ /10 min
ISO 1133		

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 ($\tau \leq -30^{\circ}\text{C}$)	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

Diagrams

