

Compound No.: 5689

AKROMID® B3 GF 15 8 L natural (5689)

PA6+PP GF15

AKROMID® B3 GF 15 8 L natural (5689) is a PA6/PP-blend with reduced density compared to standard PA6 with 15% glass fibre reinforcement. The material is suitable for components with average strength and stiffness where cost and weight reduction are required at the same time. The material corresponds to the European food guideline EU 10/2011 and to the American FDA 21 CFR. This grade is suitable for parts of kitchen and household appliances.



Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min d.a.m.	5200 MPa
Tensile stress at break ISO 527-2	5 mm/min d.a.m.	110 MPa
Tensile strain at break ISO 527-2	5 mm/min d.a.m.	3,7 %
Charpy impact strength ISO 179-1/1eU	23°C d.a.m.	65 kJ/m²
Charpy notched impact strength ISO 179-1/1eA	23°C d.a.m.	12 kJ/m²

Thermal Properties

Temperature of deflection under load HDT/A	1.8 MPa	190 °C
ISO 75	1,5 1411 4	.50 €



Compound No.: 5689

Melting temperature	DSC. 10K/min	220 °C
ISO 11357-3	550, 1010111111	220 0

Flammability

Flammability UL 94	0,8 mm Wall thickness	HB Class
Burning rate (<100 mm/min) FMVSS 302	> 1 mm Thickness	+

General Properties

Density	23°C	1,14 g/cm³
ISO 1183	25 C	., g, c

Rheological Properties

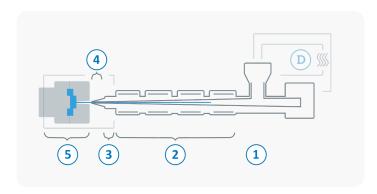
MVR	275°C/5kg	25 cm ³ /10 min
ISO 1133	273 C/3kg	25 (111 / 10 111111





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	220 - 290 °C
3	Nozzle temperature	240 - 300 °C
4	Melt temperature	240 - 290 °C
5	Mold temperature	70 - 100 °C
\ominus	Holding pressure, spec.	300 - 800 bar
\bigcirc	Back pressure, spec.	50 - 150 bar
	Injection speed	medium to high
	Screw speed	5 - 15 m/min