

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.

Features

reduced density

Regulatory



Properties

Modulus

5.200 MPa

Strength

110 MPa

Impact

65 kJ/m²

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

ISO 75

1,8 MPa

190 °C

Melting temperature

ISO 11357-3

DSC, 10K/min

220 °C

Flammability

Flammability

UL 94

0,8 mm Wall thickness

HB Class

Burning rate (<100 mm/min)

FMVSS 302

> 1 mm Thickness

+

General Properties

Density

ISO 1183

23°C

1,14 g/cm³

Rheological Properties

MVR

ISO 1133

275°C/5kg

25 cm³/10 min

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