

Compound No.: 8917

# AKROMID® PRELIMINARY B3 GF 30 AM black (8917)

PA6 GF30

AKROMID® B3 GF 30 AM black (8917) is a 30% glass fiber reinforced polyamide 6 with high stiffness and good sliding properties as well as optimised viscosity. It is suitable for a stable additive manufacturing process (3D Printing) at fast production speeds.

#### **Features**

surface modified	low warpage	process improved	3D printing / additive manufacturing	
Properties				
rioperties				
Modulus		Strength	Impact	
<b>8.400</b> MPa		<b>145</b> MPa	<b>80</b> kJ/m²	

#### **Mechanical Properties**

Tensile modulus ISO 527-2	1 mm/min   d.a.m.	8400 MPa
Tensile stress at break ISO 527-2	5 mm/min   d.a.m.	145 MPa
Tensile strain at break ISO 527-2	5 mm/min   d.a.m.	4 %
Charpy impact strength ISO 179-1/1eU	23°C   d.a.m.	80 kJ/m²
Charpy notched impact strength ISO 179-1/1eA	23°C   d.a.m.	12 kJ/m²

### **Flammability**

Flammability	1,6 mm Wall thickness	HB Class
UL 94		

## **General Properties**



Compound No.: 8917

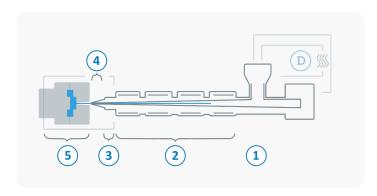
<b>Density</b> ISO 1183	23°C	1,36 g/cm³
Humidity absorption ISO 1110	70°C, 62% r.H.	2,1 - 2,3 %
Water absorption ISO 62	23°C, saturated	6,3 - 6,9 %
Molding shrinkage ISO 294-4	flow	0,5 - 0,7 %



Compound No.: 8917

#### **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
$\bigcirc$	Holding pressure, spec.	300 - 800 bar
	Back pressure, spec.	50 - 150 bar
	Injection speed	medium to high
	Screw speed	8 - 15 m/min