

AKROMID®

B3 GF 30 1 HU LA black (2862)

PA6 GF30

AKROMID® B3 GF 30 1 HU LA black (2862) is a 30% glass fibre reinforced, heat ageing resistant polyamide 6 with high rigidity and strength. This UL94 HB listed grade is suitable for technical components in mechanical engineering and the automotive industry. The material is laser markable.

Features

- heat stabilised 130
- laser markable
- E&E
- Sports & leisure

Regulatory



Properties

Modulus	Strength	Impact
10.300 MPa	185 MPa	95 kJ/m ²

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

10300 MPa

Tensile stress at break

ISO 527-2

5 mm/min | d.a.m.

185 MPa

Tensile strain at break

ISO 527-2

5 mm/min | d.a.m.

3 %

Flexural modulus

ISO 178

2 mm/min | d.a.m.

8500 MPa

Flexural strength

ISO 178

2 mm/min | d.a.m.

270 MPa

Charpy impact strength

ISO 179-1/1eU

23°C | d.a.m.

95 kJ/m²

-30°C | d.a.m.

85 kJ/m²

Charpy notched impact strength

ISO 179-1/1eA

23°C | d.a.m.

13 kJ/m²

-30°C | d.a.m.

12 kJ/m²

UV Exposure and Water Immersion

UL 746C

UL

f2

Thermal Properties

Temperature of deflection under load HDT/A

ISO 75

1,8 MPa

210 °C

Temperature of deflection under load HDT/B

ISO 75

0,45 MPa

220 °C

Temperature of deflection under load HDT/C

ISO 75

8 MPa

150 °C

Melting temperature

ISO 11357-3

DSC, 10K/min

220 °C

Flammability

Flammability

UL 94

UL

0,8 mm Wall thickness

HB Class

Burning rate (<100 mm/min)

FMVSS 302

> 1 mm Thickness

+

General Properties

Density

ISO 1183

23°C

1,36 g/cm³

Molding shrinkage

ISO 294-4

flow

0,1 - 0,3 %

transverse

0,5 - 0,7 %

Electrical Properties

Surface resistivity

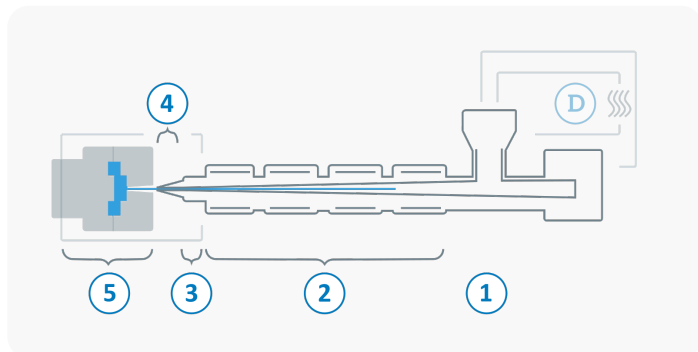
IEC 62631-3-2

d.a.m.

10¹² Ω

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

