

AKROMID®

B3 GF 30 1 GIT black (4598)

PA6 GF30

AKROMID® B3 GF 30 1 GIT black (4598) is a 30% glass fibre reinforced, heat stabilised polyamide 6 with high stiffness and strength for gas injection technology and suitable for IR welding.

Features

heat stabilised 130 surface modified fluid injection (GIT/WIT/FIT)

Properties

Modulus

9.500 MPa

Strength

175 MPa

Impact

Na

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

9500 MPa

1 mm/min | conditioned

6000 MPa

Tensile stress at break

ISO 527-2

5 mm/min | d.a.m.

175 MPa

5 mm/min | conditioned

110 MPa

Tensile strain at break

ISO 527-2

5 mm/min | d.a.m.

3,0 %

5 mm/min | conditioned

5,5 %

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

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

1,36 g/cm³

Humidity absorption

ISO 1110

70°C, 62% r.H.

2,0 - 2,2 %

Molding shrinkage

ISO 294-4

flow

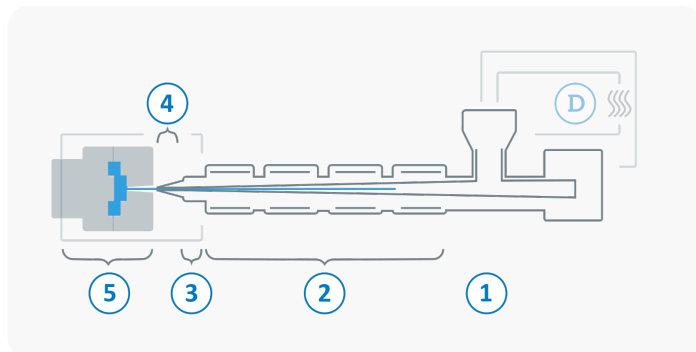
0,1 - 0,3 %

transverse

0,5 - 0,7 %

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