

AKROMID®

B3 GF 30 1 GIT LA black (8278)

PA6 GF30

AKROMID® B3 GF 30 1 GIT LA black (8278) is a 30% glass fibre reinforced, heat stabilised polyamide 6 with high stiffness and strength for gas injection technology and suitable for IR welding. The material is lasermarkable.

Features

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

Properties

Modulus

9.300 MPa

Strength

175 MPa

Impact

Na

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

9300 MPa

1 mm/min | conditioned

5900 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

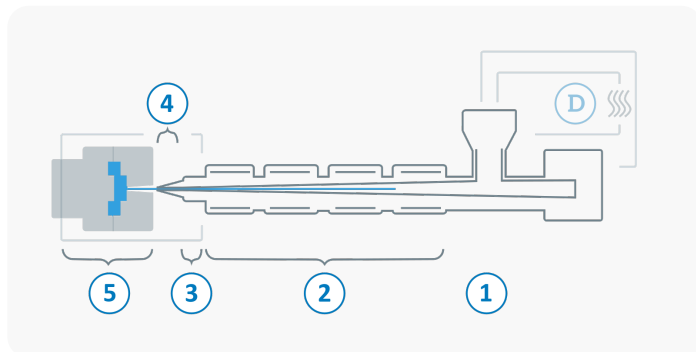
220 °C

General Properties

Density ISO 1183	23°C	1,36 g/cm³
Humidity absorption ISO 1110	70°C, 62% r.H.	1,9 - 2,3 %
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