

AKROMID® B3 8 natural (8487)

PA6

AKROMID® B3 8 natural (8487) is an unreinforced, nucleated polyamide 6. 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. The material is a dry blend.

Features		Regulatory	
nucleated			
		E 10/2011	
Properties			
Modulus	Strength	Impact	
3.200 MPa	80 MPa	Na	

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min d.a.m.	3200 MPa
Tensile stress at yield ISO 527-2	50 mm/min d.a.m.	80 MPa
Tensile strain at yield ISO 527-2	50 mm/min d.a.m.	4 %
Tensile strain at break ISO 527-2	50 mm/min d.a.m.	20 %

Thermal Properties

Melting temperature	DSC, 10K/min	220 °C
ISO 11357-3		

Flammability



Flammability UL 94	1,6 mm Wall thickness	HB Class
Burning rate (<100 mm/min) FMVSS 302	> 1 mm Thickness	+

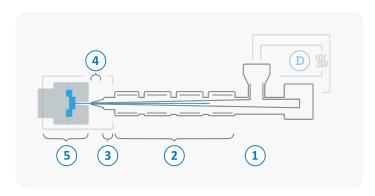
General Properties

Density ISO 1183	23°C	1,13 g/cm³
Molding shrinkage ISO 294-4	flow transverse	1,0 - 1,2 % 1,1 - 1,3 %



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	220 - 270 °C
3	Nozzle temperature	230 - 300 °C
4	Melt temperature	240 - 270 °C
5	Mold temperature	40 - 80 °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



Diagrams

