

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

nucleated

Regulatory



Properties

Modulus

3.200 MPa

Strength

80 MPa

Impact

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

ISO 11357-3

DSC, 10K/min

220 °C

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

1,0 - 1,2 %

transverse

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 ($\tau \leq -30^{\circ}\text{C}$)	80 °C
Processing moisture	0,02 - 0,1 %
(1) Feed section	60 - 80 °C
(2) Temperature Zone 1 - Zone 4	220 - 270 °C
(3) Nozzle temperature	230 - 300 °C
(4) Melt temperature	240 - 270 °C
(5) Mold temperature	40 - 80 °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

