

AKROMID® PRELIMINARY

B3 GF 50 ECO black (7926)

PA6 GF50

AKROMID® B3 GF 50 ECO black (7926) is a 50% glass fiber reinforced polyamide 6. It is characterised by a very high stiffness and strength. Furthermore, the material is heat stabilised and therefore perfectly suitable for technical parts in industrial engineering and in the automotive industry. The formulations of the sustainable ECO products are partly based on regenerated postindustrial feedstock saving valuable natural resources.

Features

heat stabilised 130 recycled content

Properties

Modulus

16.000 MPa

Strength

200 MPa

Impact

95 kJ/m²

Sustainability

Recycled content 20 %

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

16000 MPa

Tensile stress at break

ISO 527-2

5 mm/min | d.a.m.

200 MPa

Tensile strain at break

ISO 527-2

5 mm/min | d.a.m.

2,5 %

Charpy impact strength

ISO 179-1/1eU

23°C | d.a.m.

95 kJ/m²

Thermal Properties

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

Flammability

Flammability	1,6 mm Wall thickness	HB Class
UL 94		

Burning rate (<100 mm/min)	> 1 mm Thickness	+
FMVSS 302		

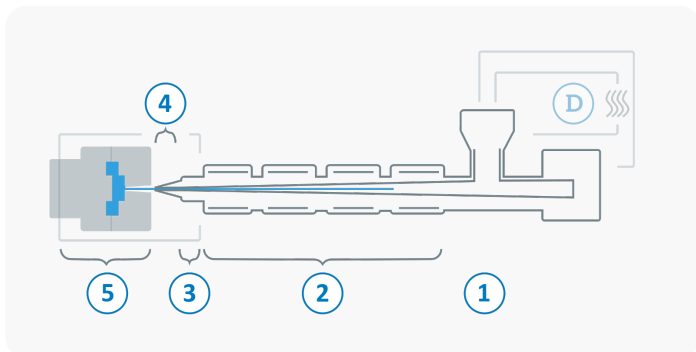
General Properties

Density	23°C	1,56 g/cm³
ISO 1183		

Molding shrinkage	flow	0,1 - 0,3 %
ISO 294-4	transverse	0,4 - 0,6 %

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