

AKROMID®

B3 GF 35 1 HU red (8416)

PA6 GF35

AKROMID® B3 GF 35 1 HU red (8416) is a 35% glass fibre reinforced, heat ageing resistant polyamide 6 with high rigidity and strength. The material is colored in red similar to RAL 3001. This UL94 HB listed grade is suitable for technical components in mechanical engineering and the automotive industry.

Features

heat stabilised 130 E&E

Regulatory



Properties

Modulus

12.000 MPa

Strength

190 MPa

Impact

Na

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

12000 MPa

Tensile stress at break

ISO 527-2

5 mm/min | d.a.m.

190 MPa

Tensile strain at break

ISO 527-2

5 mm/min | d.a.m.

3 %

Thermal Properties

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)	> 1 mm Thickness	+
FMVSS 302		

General Properties

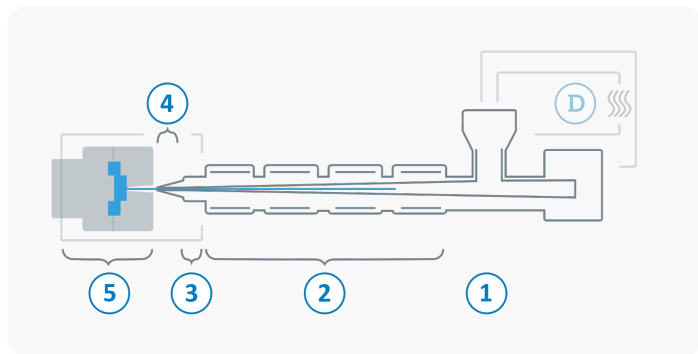
Density	23°C	1,4 g/cm ³
ISO 1183		
Humidity absorption	70°C, 62% r.H.	1,9 - 2,1 %
ISO 1110		
Molding shrinkage	flow	0,1 - 0,3 %
ISO 294-4	transverse	0,5 - 0,7 %

Electrical Properties

Comparative tracking index	UL Test liquid A	600 V
IEC 60112		
Comparative tracking index	UL	0 PLC
ASTM D3638		

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