

AKROMID®

B3 GF 35 S1 natural (920)

PA6-I GF35

AKROMID® B3 GF 35 S1 natural (920) is a 35% glass fibre reinforced, cold impact strength polyamide 6 with high stiffness and strength and light inherent color

Features

impact modified

Properties

Modulus

11.000 MPa

Strength

190 MPa

Impact

80 kJ/m²

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

11000 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.

3,5 %

Flexural modulus

ISO 178

2 mm/min | d.a.m.

10000 MPa

Flexural strength

ISO 178

2 mm/min | d.a.m.

265 MPa

Flexural strain at break

ISO 178

2 mm/min | d.a.m.

3,5 %

Charpy impact strength

ISO 179-1/1eU

23°C | d.a.m.

80 kJ/m²

-30°C | d.a.m.

80 kJ/m²

Charpy notched impact strength

ISO 179-1/1eA

23°C | d.a.m.

17 kJ/m²

-30°C | d.a.m.

12 kJ/m²

Thermal Properties

Melting temperature	DSC, 10K/min	225 °C
ISO 11357-3		

Flammability

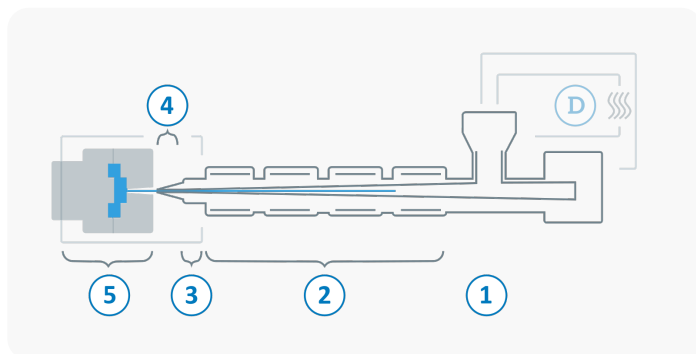
Burning rate (<100 mm/min)	> 1 mm Thickness	+
FMVSS 302		

General Properties

Density	23°C	1,4 g/cm³
ISO 1183		
Molding shrinkage	flow	0,1 - 0,3 %
	transverse	0,5 - 0,7 %
ISO 294-4		

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