

Compound No.: 8725

## AKROMID® PRELIMINARY B3 GF 40 5 black (8725)

PA6 GF40

AKROMID® B3 GF 40 5 black (8725) is a 40% glass fiber reinforced polyamide 6. It is characterized by high rigidity and strength. This grade was developed as a successor of AKROMID® B3 GF 40 5 black (7286) to meet the stringent UV stability requirements for outdoor applications. In addition, the material is stabilized at high temperatures and is therefore ideally suited for technical components in mechanical engineering, the automotive and agricultural industries.

# heat stabilised 160 UV-stabilised Properties Modulus Strength Impact 12.500 MPa 200 MPa 95 kJ/m²

#### **Mechanical Properties**

Tensile modulus ISO 527-2	1 mm/min   d.a.m.	12500 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.	3 %
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**



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

### **General Properties**

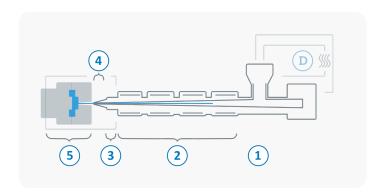
<b>Density</b> ISO 1183	23°C	1,45 g/cm³
Molding shrinkage	flow	0,1 - 0,3 %
ISO 294-4	transverse	0,5 - 0,7 %





#### **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	240 - 290 °C
3	Nozzle temperature	260 - 300 °C
4	Melt temperature	270 - 290 °C
5	Mold temperature	80 - 100 °C
$\ominus$	Holding pressure, spec.	300 - 800 bar
$\bigcirc$	Back pressure, spec.	50 - 150 bar
	Injection speed	medium to high
	Screw speed	8 - 15 m/min