

AKROMID®

B3 GF 30 FR orange (7857)

PA6 GF 30 FR(40)

AKROMID® B3 GF 30 FR orange (7857) is a 30 % glass fiber reinforced, flame retardant PA6, colored in orange similar to RAL 2003. The UL listed material in all-colors is based on a flame retardant system that is free of red phosphorus, halogens, melamine, zinc borate and PFAS. This grade is suitable for applications in the automotive and E&E markets where a V0 classification is required for thin wall thicknesses. We recommend our AKROMID® B28 GF 30 9 FR orange (8645) for projects involving component thicknesses from 1.6 mm.

Features

heat stabilised 130 electrically neutral flame retardant

E&E E-Mobility

Regulatory



Properties

Modulus

10.500 MPa

Strength

135 MPa

Impact

65 kJ/m²

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

10500 MPa

1 mm/min | conditioned

6500 MPa

Tensile stress at break

ISO 527-2

5 mm/min | d.a.m.

135 MPa

5 mm/min | conditioned

90 MPa

Tensile strain at break

ISO 527-2

5 mm/min | d.a.m.

3,0 %

5 mm/min | conditioned

6 %

Flexural modulus

ISO 178

2 mm/min | d.a.m.

11300 MPa

Flexural strength

ISO 178

2 mm/min | d.a.m.

230 MPa

Flexural strain at break

ISO 178

2 mm/min | d.a.m.

2,8 %

Charpy impact strength

ISO 179-1/1eU

23°C | d.a.m.

65 kJ/m²

23°C | conditioned

70 kJ/m²

Charpy notched impact strength

ISO 179-1/1eA

23°C | d.a.m.

10 kJ/m²

23°C | conditioned

14 kJ/m²

Thermal Properties

Temperature of deflection under load HDT/A

ISO 75

1,8 MPa

210 °C

Temperature of deflection under load HDT/B

ISO 75

0,45 MPa

220 °C

Melting temperature

ISO 11357-3

DSC, 10K/min

222 °C

Ball pressure test

IEC 60695-10-2

> 160 °C

Flammability

Flammability

UL 94

UL 0,8 mm Wall thickness

V-0 Class

UL 1,6 mm Wall thickness

V-0 Class

UL 3,2 mm Wall thickness

V-0 Class

GWFI

IEC 60695-2-12

UL 0,4 mm Wall thickness

960 °C

UL 0,8 mm Wall thickness

960 °C

UL 1,6 mm Wall thickness

960 °C

UL 3,2 mm Wall thickness

960 °C

GWIT

IEC 60695-2-13

UL 0,4 mm Wall thickness

800 °C

UL 0,8 mm Wall thickness

800 °C

UL 1,6 mm Wall thickness

800 °C

UL 3,2 mm Wall thickness

775 °C

HWI

UL 746A

UL 0,4 mm Wall thickness

0 PLC

UL 0,8 mm Wall thickness

0 PLC

UL 1,6 mm Wall thickness

0 PLC

UL 3,2 mm Wall thickness

0 PLC

HAI	UL 0,4 mm Wall thickness	0 PLC
UL 746A	UL 0,8 mm Wall thickness	0 PLC
	UL 1,6 mm Wall thickness	0 PLC
	UL 3,2 mm Wall thickness	0 PLC

General Properties

Density	23°C	1,43 g/cm³
ISO 1183		
Humidity absorption	70°C, 62% r.H.	1,4 - 1,6 %
ISO 1110		
Molding shrinkage	flow	0,1 - 0,3 %
ISO 294-4	transverse	0,5 - 0,7 %

Electrical Properties

Volume resistivity	UL d.a.m.	10¹² Ω x cm
IEC 62631-3-1		
Surface resistivity	d.a.m.	10¹¹ Ω
IEC 62631-3-2		
Comparative tracking index	Test liquid A	600 V
IEC 60112		
Comparative tracking index	UL	0 PLC
ASTM D3638		
Dielectric strength	UL 3 mm	9 kV/mm
IEC 60243		
Inclined-Plane Tracking, IPT	UL	1 kV
ASTM D2303-13		
High voltage arc tracking rate (HVTR)	UL	0 PLC
UL 746A		
High Volt, Low Current Arc Resistance	UL	6 PLC
ASTM D495		

Rheological Properties

Flowability

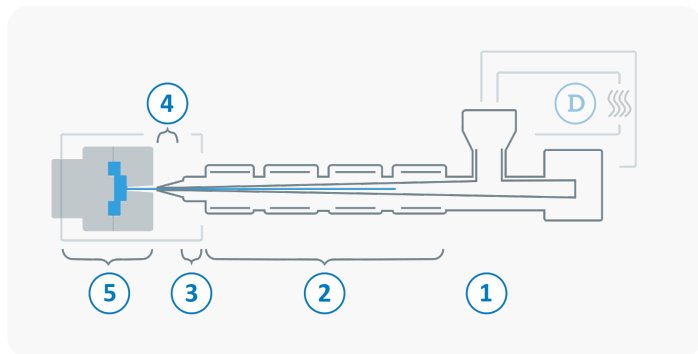
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2 mm Thickness

430 mm

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	2 - 4 h
	Drying temperature ($\tau \leq -30^{\circ}\text{C}$)	80 °C
	Processing moisture	0,02 - 0,08 %
1	Feed section	60 - 80 °C
2	Temperature Zone 1 - Zone 4	220 - 280 °C
3	Nozzle temperature	240 - 280 °C
4	Melt temperature	240 - 280 °C
5	Mold temperature	60 - 100 °C
→	Holding pressure, spec.	300 - 800 bar
←	Back pressure, spec.	30 - 100 bar
	Injection speed	medium
	Screw speed	5 - 10 m/min