

AKROMID® PRELIMINARY

B3 GKM 40 black (8632)

PA6 M40

AKROMID® B3 GKM 40 black (8632) is a 40 % mineral and glass beads filled polyamide 6. The material is characterised by its excellent surface properties and low warpage. It is suitable for use in housings, switches and covers of all kinds in the sanitary industry and for automotive applications. The possibility of chrome plating or adhesion to TPV is possible.

Features

surface modified low warpage adhesion modified metal substitution Sports & leisure

Properties

Modulus

4.700 MPa

Strength

70 MPa

Impact

150 kJ/m²

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

4700 MPa

Tensile stress at break

ISO 527-2

5 mm/min | d.a.m.

70 MPa

Tensile strain at break

ISO 527-2

5 mm/min | d.a.m.

20 %

Charpy impact strength

ISO 179-1/1eU

23°C | d.a.m.

150 kJ/m²

Charpy notched impact strength

ISO 179-1/1eA

23°C | d.a.m.

6 kJ/m²

Thermal Properties

Melting temperature

ISO 11357-3

DSC, 10K/min

220 °C

Flammability

Flammability

UL 94

1,6 mm Wall thickness

HB Class

General Properties

Density

ISO 1183

23°C

1,44 g/cm³

Humidity absorption

ISO 1110

70°C, 62% r.H.

2 %

Molding shrinkage

ISO 294-4

flow

0,9 %

transverse

1,0 %

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