AKRO COMPOUNDS

Compound No.: **5238**

AKROMID®
B3 GF 60 4 RM-M black (5238)

PA6+X GF60

AKROMID® B3 GF 60 4 RM-M black (5238) is a 60% glass fibre reinforced, chemical stabilised polyamide 6 with low humidity absorption and very good surface finish.

Features

hydrolysis / chemically stabilised | reduced moisture

Properties

Modulus	Strength	Impact
22.500 MPa	**225** MPa	**60** kJ/m²

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min | d.a.m. 1 mm/min | conditioned	**22500 MPa** **17000 MPa**
Tensile stress at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**225 MPa** **175 MPa**
Tensile strain at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**2 %** **2,7 %**
Charpy impact strength ISO 179-1/1eU	23°C | d.a.m. 23°C | conditioned -30°C | d.a.m.	**60 kJ/m²** **65 kJ/m²** **55 kJ/m²**
Charpy notched impact strength ISO 179-1/1eA	23°C | d.a.m. -30°C | d.a.m.	**22 kJ/m²** **18 kJ/m²**

Thermal Properties

Temperature of deflection under load HDT/A ISO 75	1,8 MPa	**205 °C**

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Temperature of deflection under load HDT/C ISO 75	8 MPa	**165 °C**
Melting temperature ISO 11357-3	DSC, 10K/min	**225 °C**
Coefficient of linear thermal expansion ISO 11359-1/2	23°C to 80°C | parallel 23°C to 80°C | transverse	**0,19 10^{-4}/K** **0,86 10^{-4}/K**

Flammability

Flammability UL 94	0,8 mm Wall thickness	**HB Class**
Burning rate (<100 mm/min) FMVSS 302	> 1 mm Thickness	**+**

General Properties

Density ISO 1183	23°C	**1,74 g/cm³**
Humidity absorption ISO 1110	70°C, 62% r.H.	**1,05 %**
Molding shrinkage ISO 294-4	flow transverse	**0,1 - 0,3 %** **0,3 - 0,5 %**

Electrical Properties

Comparative tracking index IEC 60112	Test liquid A	**600 V**

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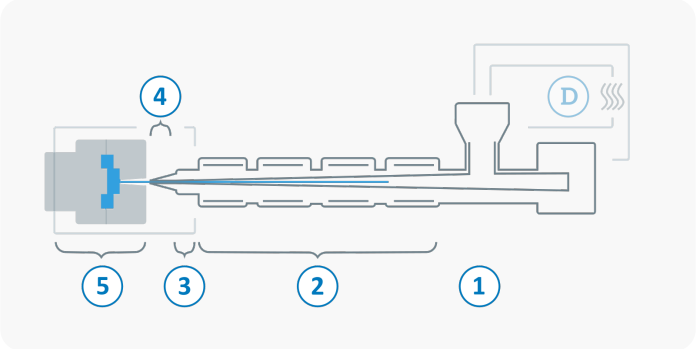
Processing

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	220 - 280 °C
3	Nozzle temperature	240 - 290 °C
4	Melt temperature	240 - 280 °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

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Diagrams