

AKROMID®

B3 GM 15/15 natural (3079)

PA6 (GF15+GB15)

AKROMID® B3 GM 15/15 natural (3079) is a 15% glass fibre and 15% glass bead reinforced polyamide 6 with good surface, low warpage and light inherent color

Features

surface modified low warpage

Properties

Modulus

7.200 MPa

Strength

130 MPa

Impact

64 kJ/m²

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

7200 MPa

Tensile stress at break

ISO 527-2

5 mm/min | d.a.m.

130 MPa

Tensile strain at break

ISO 527-2

5 mm/min | d.a.m.

3,5 %

Charpy impact strength

ISO 179-1/1eU

23°C | d.a.m.

64 kJ/m²

Charpy notched impact strength

ISO 179-1/1eA

23°C | d.a.m.

6 kJ/m²

Thermal Properties

Temperature of deflection under load HDT/A

ISO 75

1,8 MPa

200 °C

Temperature of deflection under load HDT/B

ISO 75

0,45 MPa

221 °C

Melting temperature	DSC, 10K/min	222 °C
ISO 11357-3		

Flammability

Flammability	1,6 mm Wall thickness	HB Class
UL 94		

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

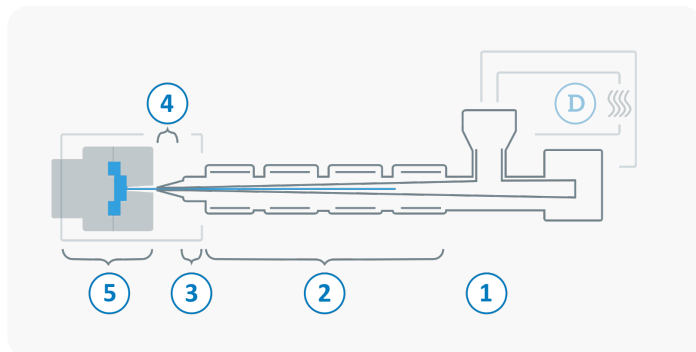
General Properties

Density	23°C	1,34 g/cm³
ISO 1183		

Molding shrinkage	flow	0,3 %
ISO 294-4	transverse	1,1 %

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