+135-3858-6433 (GuangDong)
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AKRO COMPOUNDS

Compound No.: **8058**

AKROMID®
B3 CGM 15/20 1 LA black (8058)

PA6 (CF15+GF20)

AKROMID® B3 CGM 15/20 1 LA black (8058) is a 15% carbon fibre reinforced, 20% glass fibre reinforced, heat stabilised polyamide 6 with high stiffness and strength. Furthermore, the material impresses with its good laser marking properties as well as electrical conductivity. It is therefore perfectly suitable for technical applications in the automotive industry e.g. fuel filter housing.

Features

heat stabilised 130 | laser markable | antistatic/conductive

Properties

Modulus	Strength	Impact
17.000 MPa	**195** MPa	**70** kJ/m²

Sustainability

Recycled content	**15 %**

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min | d.a.m.	**17000 MPa**
Tensile stress at break ISO 527-2	5 mm/min | d.a.m.	**195 MPa**
Tensile strain at break ISO 527-2	5 mm/min | d.a.m.	**2,5 %**
Charpy impact strength ISO 179-1/1eU	23°C | d.a.m.	**70 kJ/m²**
Charpy notched impact strength ISO 179-1/1eA	23°C | d.a.m.	**10 kJ/m²**

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Thermal Properties

Temperature of deflection under load HDT/A ISO 75	1,8 MPa	**210 °C**
Melting temperature ISO 11357-3	DSC, 10K/min	**220 °C**
Coefficient of linear thermal expansion ISO 11359-1/2	23°C to 80°C | parallel 23°C to 80°C | transverse	**0,07 10^{-4}/K** **0,98 10^{-4}/K**

Flammability

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

General Properties

Density ISO 1183	23°C	**1,36 g/cm³**
Humidity absorption ISO 1110	70°C, 62% r.H.	**1,8 - 2,1 %**
Molding shrinkage ISO 294-4	flow transverse	**0,1 - 0,3 %** **0,5 - 0,7 %**

Electrical Properties

Surface resistivity IEC 62631-3-2	d.a.m.	**10^4 Ω**

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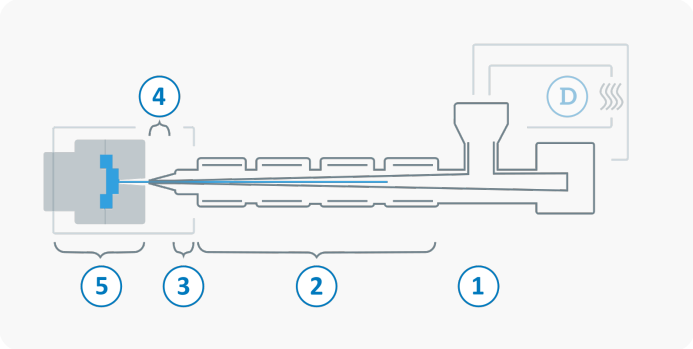
Processing

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	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

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Diagrams