

AKROMID® B3 GK 15 natural (1824)

PA6 GB15

AKROMID® B3 GK 15 natural (1824) is a PA 6 filled with 15% glass beads. It is characterized by a high surface quality and low tendency to warp, which makes it suitable for use in technically demanding components in mechanical engineering and in the automotive industry.

Features

low warpage

Properties

Modulus	Strength	Impact
4.000 MPa	85 MPa	30 kJ/m ²

Sustainability

Recycled content 15 %

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min d.a.m.	4000 MPa
Tensile stress at break ISO 527-2	5 mm/min d.a.m.	85 MPa
Tensile strain at break ISO 527-2	5 mm/min d.a.m.	4,5 %
Flexural modulus ISO 178	2 mm/min d.a.m.	3600 MPa
Flexural strength ISO 178	2 mm/min d.a.m.	125 MPa
Flexural strain at break ISO 178	2 mm/min d.a.m.	6 %

Charpy impact strength	23°C d.a.m.	30 kJ/m ²
ISO 179-1/1eU	-30°C d.a.m.	35 kJ/m ²

Charpy notched impact strength	23°C d.a.m.	2,5 kJ/m ²
ISO 179-1/1eA	-30°C d.a.m.	2,7 kJ/m ²

Thermal Properties

Temperature of deflection under load HDT/A	1,8 MPa	67 °C
ISO 75		

Temperature of deflection under load HDT/B	0,45 MPa	186 °C
ISO 75		

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

Flammability

Flammability	1,6 mm Wall thickness	HB Class
UL 94		

GWFI	1,6 mm Wall thickness	960 °C
IEC 60695-2-12		

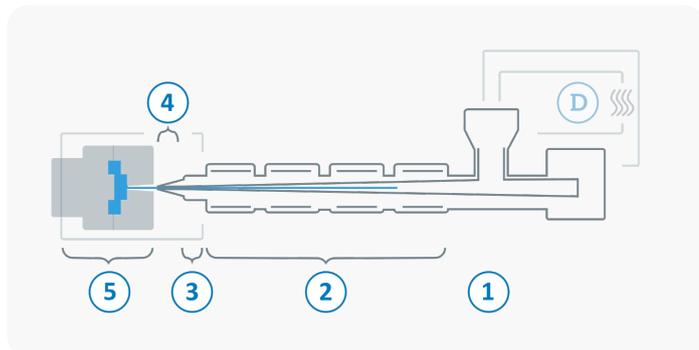
General Properties

Density	23°C	1,23 g/cm ³
ISO 1183		

Molding shrinkage	flow	1,3 %
ISO 294-4	transverse	1,2 %

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.



Ⓓ	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