+135-3858-6433 (GuangDong)
+188-1699-6168 (ShangHai)
+852-6957-5415 (HongKong)

AKRO COMPOUNDS

Compound No.: **null**

AKROMID® PRELIMINARY
NEXT B3 GF 30 1 L black (5212BMBCI)

PA6+PP GF30

AKROMID® NEXT B3 GF 30 1 L black (5212BMBCI) is a PA6/PP-blend with reduced density compared to standard PA6 GF 30. With 30% glass fibre reinforcement, the material is suitable for components with high strength and stiffness where weight reduction are required. The chemical resistance is particularly superior to calcium chloride ($CaCl_2$). The material is certified according to ISCC PLUS. 85% of the fossil raw materials required for manufacturing this product were replaced by sustainable biomass-balanced PP and PA (¥allocation factor).

Features

biomass balanced | heat stabilised 130 | UV-stabilised | reduced density

Regulatory

ISCC International Sustainability & Carbon Certification

Properties

Modulus	Strength	Impact
9.000 MPa	**135** MPa	**58** kJ/m²

Sustainability

Allocation factor only valid for ISCC PLUS/REDcert² certified products	**85 %**

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min | d.a.m.	**9000 MPa**
Tensile stress at break ISO 527-2	5 mm/min | d.a.m.	**135 MPa**
Tensile strain at break ISO 527-2	5 mm/min | d.a.m.	**2,7 %**
Charpy impact strength ISO 179-1/1eU	23°C | d.a.m.	**58 kJ/m²**

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Thermal Properties

Melting temperature ISO 11357-3	DSC, 10K/min	**220 °C**

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	**1,26 g/cm³**
Humidity absorption ISO 1110	70°C, 62% r.H.	**1,3 - 1,5 %**
Molding shrinkage ISO 294-4	flow transverse	**0,1 - 0,3 %** **0,5 - 0,7 %**

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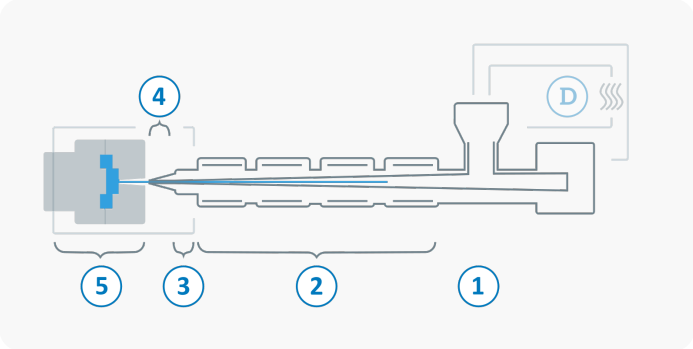
Processing

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 - 290 °C
3	Nozzle temperature	240 - 300 °C
4	Melt temperature	240 - 290 °C
5	Mold temperature	70 - 100 °C
→	Holding pressure, spec.	300 - 800 bar
←	Back pressure, spec.	50 - 150 bar
	Injection speed	medium to high
	Screw speed	5 - 15 m/min