

AKROMID® B4 natural (4333)

PA6

Akro-Plastic GmbH

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	1.1 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	1.4 / *	%	ISO 294-4, 2577

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	2500 / -	MPa	ISO 527
Yield stress	70 / -	MPa	ISO 527
Yield strain	5 / -	%	ISO 527
Charpy impact strength, +23°C	N / -	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	8 / -	kJ/m ²	ISO 179/1eA

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
Melting temperature, 10°C/min	222 / *	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	55 / *	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	135 / *	°C	ISO 75-1/-2
Burning behav. at 1.5 mm nom. thickn.	HB / *	class	IEC 60695-11-10
Thickness tested	1.6 / *	mm	-

Other properties	dry / cond	Unit	Test Standard
Density	1130 / -	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Melt temperature	270	°C	-
Mold temperature	80	°C	-
Injection pressure	75	MPa	-

Characteristics**Processing**

Injection Molding

Features

Color Stability

Delivery form

Natural Color

Regional Availability

Europe, Asia Pacific