AKROMID® B3 GM 10/20 1 L black (4646)

(PA6+PP)-(GB+GF)30 Akro-Plastic GmbH

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	**18 / ***	cm³/10min	ISO 1133
Temperature	**275 / ***	°C	-
Load	**5 / ***	kg	-
Molding shrinkage, parallel	**0.4 / ***	%	ISO 294-4, 2577
Molding shrinkage, normal	**0.7 / ***	%	ISO 294-4, 2577

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	**5100 / 3300**	MPa	ISO 527
Stress at break	**88 / 55**	MPa	ISO 527
Strain at break	**3.4 / 6**	%	ISO 527
Flexural modulus, 23°C	**4700 / -**	MPa	ISO 178
Flexural strength	**130 / -**	MPa	ISO 178
Charpy impact strength, +23°C	**46 / 44**	kJ/m²	ISO 179/1eU
Charpy impact strength, -30°C	**43 / 42**	kJ/m²	ISO 179/1eU
Charpy notched impact strength, +23°C	**7 / 9**	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	**4 / 4**	kJ/m²	ISO 179/1eA

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
Melting temperature, 10°C/min	**220 / ***	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	**165 / ***	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	**208 / ***	°C	ISO 75-1/-2
Burning behav. at thickness h	**HB / ***	class	IEC 60695-11-10
Thickness tested	**0.8 / ***	mm	-

Other properties	dry / cond	Unit	Test Standard
Density	**1260 / -**	kg/m³	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

Applications
Automotive, Electrical and Electronical

Delivery form
Black

Regional Availability
Europe, Asia Pacific

Special Characteristics
Heat stabilized or stable to heat