

AKROMID®

B28 GF 30 1 black (4962)

PA6 GF30

AKROMID® B28 GF 30 1 black (4962) is a 30% glass fibre reinforced, heat stabilised and easy flowing polyamide 6 with high stiffness and strength.

Features

heat stabilised 130 easy flow

Properties

Modulus

9.500 MPa

Strength

170 MPa

Impact

75 kJ/m²

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

9500 MPa

1 mm/min | conditioned

6000 MPa

Tensile stress at break

ISO 527-2

5 mm/min | d.a.m.

170 MPa

5 mm/min | conditioned

100 MPa

Tensile strain at break

ISO 527-2

5 mm/min | d.a.m.

3 %

5 mm/min | conditioned

5,5 %

Charpy impact strength

ISO 179-1/1eU

23°C | d.a.m.

75 kJ/m²

23°C | conditioned

85 kJ/m²

Charpy notched impact strength

ISO 179-1/1eA

23°C | d.a.m.

11 kJ/m²

23°C | conditioned

20 kJ/m²

Thermal Properties

Temperature of deflection under load HDT/A

ISO 75

1,8 MPa

210 °C

Temperature of deflection under load HDT/B

ISO 75

0,45 MPa

220 °C

Melting temperature

ISO 11357-3

DSC, 10K/min

220 °C

General Properties

Density

ISO 1183

23°C

1,36 g/cm³

Humidity absorption

ISO 1110

70°C, 62% r.H.

2,1 - 2,3 %

Molding shrinkage

ISO 294-4

flow

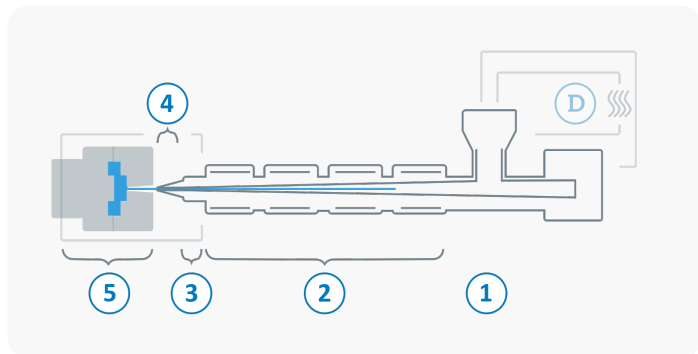
0,1 - 0,3 %

transverse

0,5 - 0,7 %

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 ($\tau \leq -30^{\circ}\text{C}$)	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

Diagrams

