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

AKRO COMPOUNDS

Compound No.: **8897**

# AKROMID® PRELIMINARY
# B28 GF 50 1 black (8897)

PA6 GF50

AKROMID® B28 GF 50 1 black (8897) is a 50% glass fiber reinforced polyamide 6 with a better flowability. It is characterised by a very high stiffness and strength. Furthermore, the material is heat stabilised and therefore perfectly suitable for technical parts in industrial engineering and in the automotive industry.

**Features**

heat stabilised 130 | easy flow

**Properties**

| Modulus | Strength | Impact |
|---|---|---|
| **16.500** MPa | **225** MPa | **85** kJ/m² |

## Mechanical Properties

| | | |
|---|---|---|
| **Tensile modulus**<br>ISO 527-2 | 1 mm/min \| d.a.m. | **16500 MPa** |
| **Tensile stress at break**<br>ISO 527-2 | 5 mm/min \| d.a.m. | **225 MPa** |
| **Tensile strain at break**<br>ISO 527-2 | 5 mm/min \| d.a.m. | **2,5 %** |
| **Charpy impact strength**<br>ISO 179-1/1eU | 23°C \| d.a.m. | **85 kJ/m²** |
| **Charpy notched impact strength**<br>ISO 179-1/1eA | 23°C \| d.a.m. | **15 kJ/m²** |

## Thermal Properties

| | | |
|---|---|---|
| **Temperature of deflection under load HDT/A**<br>ISO 75 | 1,8 MPa | **220 °C** |
| **Melting temperature**<br>ISO 11357-3 | DSC, 10K/min | **220 °C** |

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## Flammability

| | | |
|---|---|---|
| **Flammability**<br>UL 94 | 1,6 mm Wall thickness | **HB Class** |
| **Burning rate (<100 mm/min)**<br>FMVSS 302 | > 1 mm Thickness | + |

## General Properties

| | | |
|---|---|---|
| **Density**<br>ISO 1183 | 23°C | **1,56 g/cm³** |
| **Molding shrinkage**<br>ISO 294-4 | flow<br>transverse | **0,1 - 0,3 %**<br>**0,4 - 0,6 %** |

## Electrical Properties

| | | |
|---|---|---|
| **Comparative tracking index**<br>IEC 60112 | Test liquid A | **600 V** |

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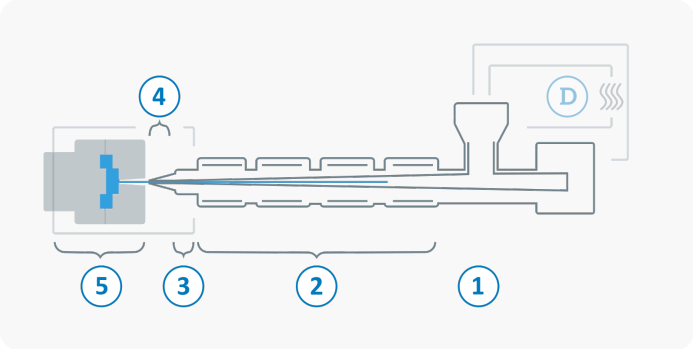
## Processing

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 | 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 |