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AKRO COMPOUNDS

Compound No.: **6941**

AKROMID® PRELIMINARY
B28 GF 30 natural (6941)

PA 6 GF 30

AKROMID B28 GF 30 natural (6941) is a 30% glass fibre reinforced, easy flowing PA6. Due to its very good flowability, this grade has a good surface. It complies with the bus fire standard ECE R 118.03 annex 6 and 8 and is suitable for panels, seat shells, armrests and footrests where high stiffness and strength is required. The material is easy to colour.

Features

easy flow

Regulatory

ECE118.03

Properties

Modulus	Strength	Impact
10.200 MPa	**180** MPa	**80** kJ/m²

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min | d.a.m. 1 mm/min | conditioned	**10200 MPa** **6200 MPa**
Tensile stress at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**180 MPa** **102 MPa**
Tensile strain at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**3 %** **5,5 %**
Flexural modulus ISO 178	2 mm/min | d.a.m.	**8400 MPa**
Flexural strength ISO 178	2 mm/min | d.a.m.	**230 MPa**
Charpy impact strength ISO 179-1/1eU	23°C | d.a.m. 23°C | conditioned	**80 kJ/m²** **87 kJ/m²**

Thermal Properties

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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**

Flammability

Flammability UL 94	0,4 mm Wall thickness	**HB Class**
	0,8 mm Wall thickness	**HB Class**
	1,6 mm Wall thickness	**HB Class**
	3,2 mm Wall thickness	**HB Class**
Burning rate (<100 mm/min) FMVSS 302	> 1 mm Thickness	+
Protection Bus ECE 118		**Appendix 6, 8**

General Properties

Density ISO 1183	23°C	**1,35 g/cm³**
Molding shrinkage ISO 294-4	flow	**0,1 - 0,3 %**
	transverse	**0,5 - 0,7 %**

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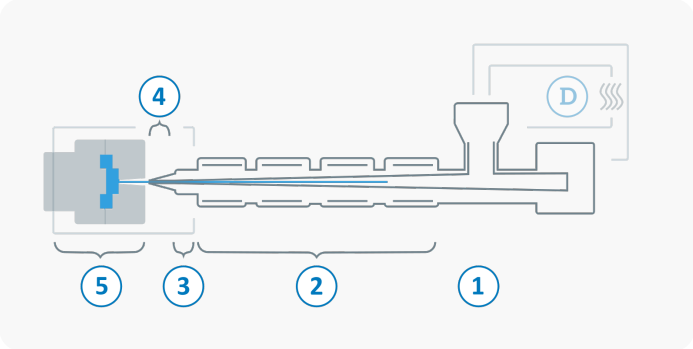
Processing

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	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