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

AKRO COMPOUNDS

Compound No.: **4732**

AKROMID®
B28 GF 50 1 GIT black (4732)

PA6 GF50

AKROMID® B28 GF 50 1 GIT black (4732) is a 50% glass fibre reinforced, heat stabilised, easy flowing polyamide 6 with very high stiffness and strength for gas injection technology.

Features

heat stabilised 130 | surface modified | easy flow | fluid injection (GIT/WIT/FIT)

Properties

Modulus	Strength	Impact
16.700 MPa	**235** MPa	**105** kJ/m²

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min | d.a.m. 1 mm/min | conditioned	**16700 MPa** **10500 MPa**
Tensile stress at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**235 MPa** **150 MPa**
Tensile strain at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**3 %** **4,5 %**
Charpy impact strength ISO 179-1/1eU	23°C | d.a.m. 23°C | conditioned	**105 kJ/m²** **105 kJ/m²**
Charpy notched impact strength ISO 179-1/1eA	23°C | d.a.m. 23°C | conditioned	**20 kJ/m²** **25 kJ/m²**

Thermal Properties

Melting temperature ISO 11357-3	DSC, 10K/min	**220 °C**

Flammability

Flammability UL 94	0,8 mm Wall thickness	**HB Class**
Burning rate (<100 mm/min) FMVSS 302	> 1 mm Thickness	+

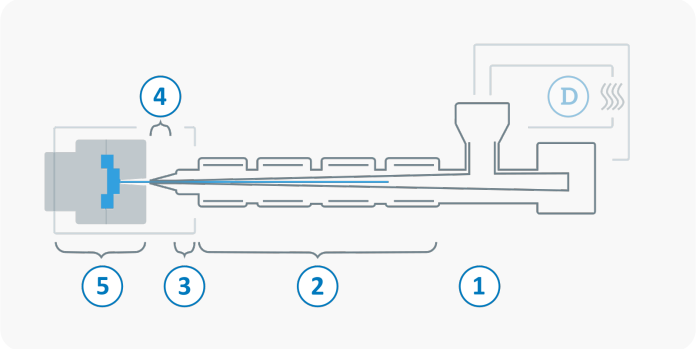
General Properties

Density ISO 1183	23°C	**1,55 g/cm³**
Humidity absorption ISO 1110	70°C, 62% r.H.	**1,55 - 1,75 %**
Molding shrinkage ISO 294-4	flow transverse	**0,1 - 0,3 %** **0,4 - 0,6 %**

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

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

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

Diagrams