

AKROMID®

B28 GF 60 1 natural (4775)

PA6 GF60

AKROMID® B28 GF 60 1 natural (4775) is a 60% glass fiber reinforced, heat stabilised polyamide 6. It is characterised by an improved flowability compared to a standard PA 6 GF 60. Furthermore, the material impresses with its high stiffness and strength. It is therefore perfectly suitable for technical applications in industrial engineering and in the automotive industry.

Features

heat stabilised 130 easy flow

Properties



Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min d.a.m.	22000 MPa
Tensile stress at break ISO 527-2	5 mm/min d.a.m.	260 MPa
Tensile strain at break ISO 527-2	5 mm/min d.a.m.	2,8 %
Charpy impact strength ISO 179-1/1eU	23°C d.a.m.	100 kJ/m ²
Charpy notched impact strength ISO 179-1/1eA	23°C d.a.m.	22 kJ/m ²

Thermal Properties

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

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

General Properties

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

Rheological Properties

Flowability AKRO	1 mm Thickness	120 mm
	2 mm Thickness	360 mm

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