

AKROMID®

B28 GM 10/20 1 LT black (7749)

PA6 (GF10+GB20)

AKROMID® B28 GM 10/20 1 LT black (7749) is a 10% glass fibre reinforced, 20% glass bead filled, heat stabilised, lasertransparent and laser markable polyamide 6 with good surface and low warpage

Features

heat stabilised 130 laser markable laser transparent surface modified low warpage

Properties

Modulus	Strength	Impact
6.300 MPa	110 MPa	40 kJ/m ²

Sustainability

Recycled content 20 %

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min d.a.m.	6300 MPa
Tensile stress at break ISO 527-2	5 mm/min d.a.m.	110 MPa
Tensile strain at break ISO 527-2	5 mm/min d.a.m.	2,5 %
Charpy impact strength ISO 179-1/1eU	23°C d.a.m.	40 kJ/m ²

Thermal Properties

Melting temperature ISO 11357-3	DSC, 10K/min	222 °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	1,35 g/cm³
Molding shrinkage ISO 294-4	flow	0,3 - 0,5 %
	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 liners, 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