

# AKROMID® B28 GF 30 2 black (7059)

PA6 GF30

AKROMID® B28 GF 30 2 black (7059) is a 30% glass fiber reinforced, easy flowing polyamide 6. It is characterised by a high stiffness and strength. Furthermore, the material is UV and heat stabilised and therefore perfectly suitable for technical components in outdoor applications.

## Features

heat stabilised 130   UV-stabilised   easy flow

## Properties

Modulus

10.000 MPa

Strength

180 MPa

Impact

70 kJ/m<sup>2</sup>

## Mechanical Properties

### Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

10000 MPa

1 mm/min | conditioned

6500 MPa

### Tensile stress at break

ISO 527-2

5 mm/min | d.a.m.

180 MPa

5 mm/min | conditioned

110 MPa

### Tensile strain at break

ISO 527-2

5 mm/min | d.a.m.

3 %

5 mm/min | conditioned

4,5 %

### Charpy impact strength

ISO 179-1/1eU

23°C | d.a.m.

70 kJ/m<sup>2</sup>

23°C | conditioned

80 kJ/m<sup>2</sup>

-40°C | d.a.m.

55 kJ/m<sup>2</sup>

### Charpy notched impact strength

ISO 179-1/1eA

-40°C | d.a.m.

9 kJ/m<sup>2</sup>

## Thermal Properties

### Temperature of deflection under load HDT/A

ISO 75

1,8 MPa

210 °C

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<b>Temperature of deflection under load HDT/B</b>	0,45 MPa	220 °C
ISO 75		

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## Flammability

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<b>Flammability</b>	1,6 mm Wall thickness	<b>HB Class</b>
UL 94		

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<b>Burning rate (&lt;100 mm/min)</b>	> 1 mm Thickness	<b>+</b>
FMVSS 302		

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## General Properties

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<b>Density</b>	23°C	<b>1,36 g/cm<sup>3</sup></b>
ISO 1183		

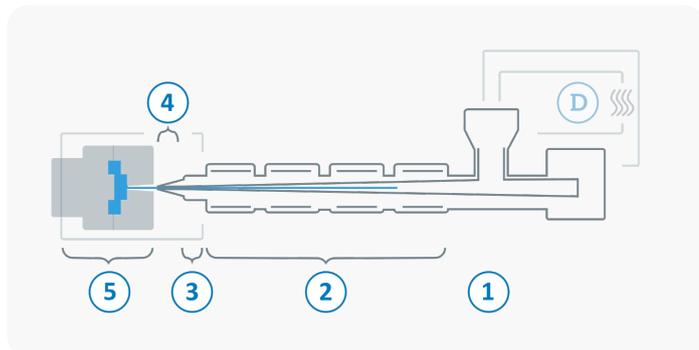
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<b>Molding shrinkage</b>	flow	<b>0,1 - 0,3 %</b>
	transverse	<b>0,5 - 0,7 %</b>
ISO 294-4		

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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.



<b>D</b>	Drying time	0 - 4 h
	Drying temperature ( $\tau \leq -30^{\circ}\text{C}$ )	80 °C
	Processing moisture	0,02 - 0,1 %
<b>1</b>	Feed section	60 - 80 °C
<b>2</b>	Temperature Zone 1 - Zone 4	240 - 290 °C
<b>3</b>	Nozzle temperature	260 - 300 °C
<b>4</b>	Melt temperature	270 - 290 °C
<b>5</b>	Mold temperature	80 - 100 °C
<b>→</b>	Holding pressure, spec.	300 - 800 bar
<b>←</b>	Back pressure, spec.	50 - 150 bar
	Injection speed	medium to high
	Screw speed	8 - 15 m/min

## Diagrams

