

# AKROMID®

## B28 GF 15 2 black (7060)

PA6 GF15

AKROMID® B28 GF 15 2 black (7060) is a 15% glass fiber reinforced, easy-flowing polyamide 6. It is characterized by medium rigidity and strength. In addition, the material is heat and UV stabilized and therefore ideally suited for technical components in outdoor applications. This product passed ISO 4892-2 with 1200h exposure time.

### Features

heat stabilised 160    UV-stabilised

### Properties

Modulus	Strength	Impact
6.100 MPa	108 MPa	32 kJ/m <sup>2</sup>

## Mechanical Properties

<b>Tensile modulus</b> ISO 527-2	1 mm/min   d.a.m.	<b>6100 MPa</b>
	1 mm/min   conditioned	<b>3300 MPa</b>
<b>Tensile stress at break</b> ISO 527-2	5 mm/min   d.a.m.	<b>108 MPa</b>
	5 mm/min   conditioned	<b>70 MPa</b>
<b>Tensile strain at break</b> ISO 527-2	5 mm/min   d.a.m.	<b>2,0 %</b>
	5 mm/min   conditioned	<b>9 %</b>
<b>Charpy impact strength</b> ISO 179-1/1eU	23°C   d.a.m.	<b>32 kJ/m<sup>2</sup></b>

## Thermal Properties

<b>Temperature of deflection under load HDT/A</b> ISO 75	1,8 MPa	<b>205 °C</b>
<b>Temperature of deflection under load HDT/B</b> ISO 75	0,45 MPa	<b>220 °C</b>

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<b>Melting temperature</b>	DSC, 10K/min	<b>222 °C</b>
ISO 11357-3		

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## Flammability

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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>1,24 g/cm<sup>3</sup></b>
ISO 1183		

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<b>Humidity absorption</b>	70°C, 62% r.H.	<b>2,6 - 2,9 %</b>
ISO 1110		

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<b>Water absorption</b>	23°C, saturated	<b>7,7 - 8,3 %</b>
ISO 62		

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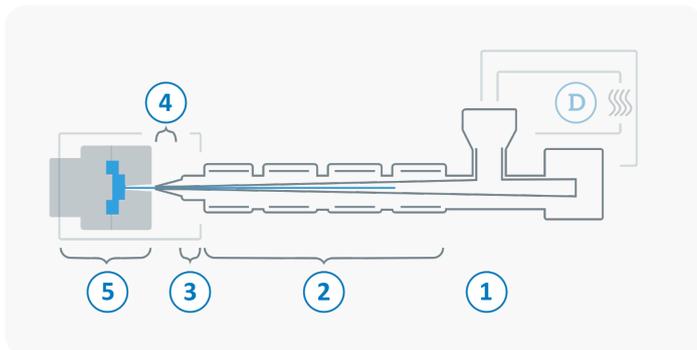
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<b>Molding shrinkage</b>	flow	<b>0,2 - 0,4 %</b>
	transverse	<b>0,6 - 0,8 %</b>
ISO 294-4		

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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