

AKROMID® PRELIMINARY

B28 GF 15 natural (6940)

PA6 GF 15

AKROMID B28 GF 15 natural (6940) is a 15% glass fibre reinforced, easy flowing PA6. Due to its very good flowability, this grade has a good surface. It complies with the bus fire standard ECE R 118.03 annex 6, 7, 8 and is suitable for panels and components in luggage racks where medium stiffness and strength is required. The material is easy to colour.

Features

easy flow public transportation

Regulatory

ECE118.03

Properties



Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min d.a.m.	5300 MPa
Tensile stress at break ISO 527-2	5 mm/min d.a.m.	120 MPa
Tensile strain at break ISO 527-2	5 mm/min d.a.m.	3 %
Flexural modulus ISO 178	2 mm/min d.a.m.	4500 MPa
Flexural strength ISO 178	2 mm/min d.a.m.	210 MPa
Charpy impact strength ISO 179-1/1eU	23°C d.a.m.	39 kJ/m²

Thermal Properties

Temperature of deflection under load HDT/A ISO 75	1,8 MPa	205 °C
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Temperature of deflection under load HDT/B ISO 75	0,45 MPa	220 °C
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Melting temperature ISO 11357-3	DSC, 10K/min	220 °C
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Flammability

Flammability UL 94	0,4 mm Wall thickness	HB Class
	0,8 mm Wall thickness	HB Class
	1,6 mm Wall thickness	HB Class
	3,2 mm Wall thickness	HB Class

Burning rate (<100 mm/min) FMVSS 302	> 1 mm Thickness	+
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Protection Bus ECE 118	Appendix 6, 7, 8	
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General Properties

Density ISO 1183	23°C	1,23 g/cm³
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Molding shrinkage ISO 294-4	flow	0,2 - 0,4 %
	transverse	0,6 - 0,8 %

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