

AKROMID® PRELIMINARY

B28 GM 10/20 6 black (8640)

PA6 (GF10+GB20)

AKROMID® B28 GM 10/20 6 black (8640) is a 10% glass fiber and 20% glass beads reinforced, easy flowing polyamide 6. Due to its good flowability, the material is not only easy to process but also shows good surface properties. Furthermore, the inorganic heat stabilisation as well as the dimensional stability make it the material of your choice for covers and housings in automotive interior applications.

Features

heat stabilised 160 low warpage easy flow

Properties

Modulus

5.500 MPa

Strength

100 MPa

Impact

50 kJ/m²

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

5500 MPa

Tensile stress at break

ISO 527-2

5 mm/min | d.a.m.

100 MPa

Tensile strain at break

ISO 527-2

5 mm/min | d.a.m.

3,2 %

Charpy impact strength

ISO 179-1/1eU

23°C | d.a.m.

50 kJ/m²

Thermal Properties

Melting temperature

ISO 11357-3

DSC, 10K/min

222 °C

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

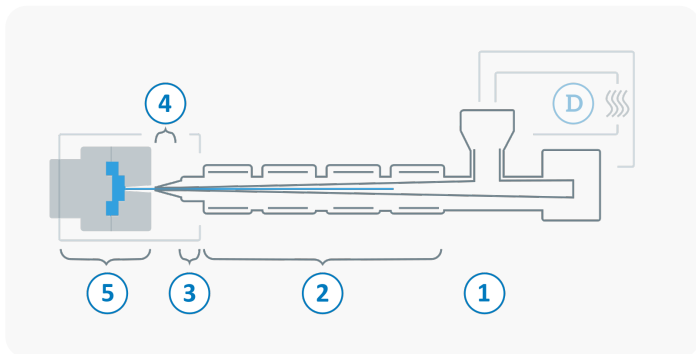
0,3 - 0,5 %

transverse

0,6 - 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