+135-3858-6433 (GuangDong)
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AKRO COMPOUNDS

Compound No.: **6846**

AKROMID®
B28 GF 33 1 GIT black (6846)

PA6 GF33

AKROMID® B28 GF 33 1 GIT black (6846) is a 33% glass fiber reinforced, heat-stabilized polyamide 6. It is characterized by high rigidity and strength. The material also impresses with its very good processability using the internal gas pressure process and a very good surface. It is therefore ideal for components in the furniture industry with high demands on the surface.

Features

heat stabilised 130 | surface modified | fluid injection (GIT/WIT/FIT)

Properties

Modulus	Strength	Impact
10.500 MPa	**190** MPa	**95** kJ/m²

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min | d.a.m. 1 mm/min | conditioned	**10500 MPa** **6600 MPa**
Tensile stress at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**190 MPa** **120 MPa**
Tensile strain at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**3 %** **4,5 %**
Flexural modulus ISO 178	2 mm/min | d.a.m.	**9000 MPa**
Flexural strength ISO 178	2 mm/min | d.a.m.	**275 MPa**
Charpy impact strength ISO 179-1/1eU	23°C | d.a.m. 23°C | conditioned	**95 kJ/m²** **105 kJ/m²**
Charpy notched impact strength ISO 179-1/1eA	23°C | d.a.m. 23°C | conditioned	**14 kJ/m²** **18 kJ/m²**

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Thermal Properties

Melting temperature ISO 11357-3	DSC, 10K/min	**220 °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	**1,38 g/cm³**
Humidity absorption ISO 1110	70°C, 62% r.H.	**1,8 %**
Molding shrinkage ISO 294-4	flow transverse	**0,1 - 0,3 %** **0,5 - 0,7 %**

Rheological Properties

MVR ISO 1133	275°C/5kg	**40 cm³/10 min**

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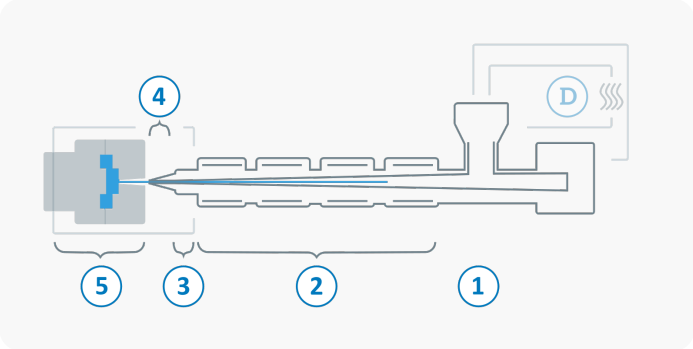
Processing

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.



D	Drying time	0 - 4 h
	Drying temperature (τ <= -30°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

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Diagrams