+135-3858-6433 (GuangDong)
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AKRO COMPOUNDS

Compound No.: **7514**

AKROMID®
B28 GF 15 1 S3 black (7514)

PA6-I GF15

Our AKROMID® B28 GF 15 1 S3 black (7514) is a 15% glass fibre reinforced, heat stabilised polyamide 6 which offers medium stiffness and strength, making it the go-to material for elevated tremperature applications, for example in industrial engineering or automotive industry. Furthermore, it is not only easy flowing, making it easy to process, but also impact modified, exceeding the impact resistance of standard PA GF 15.

Features

heat stabilised 130 | impact modified | easy flow | process improved

Properties

Modulus	Strength	Impact
5.000 MPa	**110** MPa	**70** kJ/m²

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min | d.a.m. 1 mm/min | conditioned	**5000 MPa** **2500 MPa**
Tensile stress at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**110 MPa** **75 MPa**
Tensile strain at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**4,4 %** **> 10 %**
Charpy impact strength ISO 179-1/1eU	23°C | d.a.m. 23°C | conditioned -30°C | d.a.m.	**70 kJ/m²** **95 kJ/m²** **45 kJ/m²**
Charpy notched impact strength ISO 179-1/1eA	23°C | d.a.m. -30°C | d.a.m.	**7 kJ/m²** **5 kJ/m²**

Thermal Properties

Temperature of deflection under load HDT/A ISO 75	1,8 MPa	**215 °C**
Melting temperature ISO 11357-3	DSC, 10K/min	**225 °C**

Flammability

Burning rate (<100 mm/min) FMVSS 302	> 1 mm Thickness	+

General Properties

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

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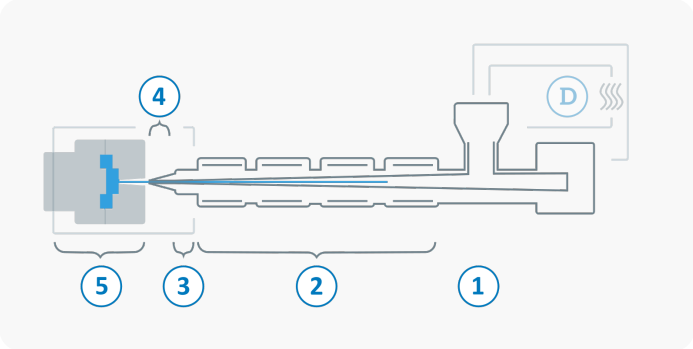
Processing

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