

AKROMID® B28 GF 30 natural (4826)

PA6 GF30

AKROMID® B28 GF 30 natural (4826) is a 30% glass fiber reinforced, easy flowing polyamide 6. It is characterised by a high stiffness and strength. The material is therefore perfectly suitable for technical parts not only in industrial engineering and in the automotive industry, but also for parts in the furniture industry. It has a light inherent color.

Features

easy flow

Properties

Modulus	Strength	Impact
9.500 MPa	180 MPa	90 kJ/m ²

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min d.a.m.	9500 MPa
Tensile stress at break ISO 527-2	5 mm/min d.a.m.	180 MPa
Tensile strain at break ISO 527-2	5 mm/min d.a.m.	3 %
Charpy impact strength ISO 179-1/1eU	23°C d.a.m.	90 kJ/m ²
Charpy notched impact strength ISO 179-1/1eA	23°C d.a.m.	13 kJ/m ²

Thermal Properties

Melting temperature ISO 11357-3	DSC, 10K/min	220 °C
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Flammability

Flammability

UL 94

0,8 mm Wall thickness

HB Class

GWFI

IEC 60695-2-12

1,6 mm Wall thickness

> 650 °C

GWIT

IEC 60695-2-13

1,6 mm Wall thickness

> 650 °C

General Properties

Density

ISO 1183

23°C

1,36 g/cm³

Electrical Properties

Comparative tracking index

IEC 60112

Test liquid A

600 V

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