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AKROMID®
B28 GF 30 6 LT black (8500)

PA6 GF30

AKROMID® B28 GF 30 6 LT black (8500) is a 30% glass fibre reinforced, easy flowing Polyamide 6. The material is characterised by high stiffness and strength. Furthermore, it is UV- and high heat stabilised and therefore perfectly suitable for automotive and industrial applications. The compound can be welded via laser welding.

Features

heat stabilised 160 | UV-stabilised | laser transparent

Properties

Modulus	Strength	Impact
9.800 MPa	185 MPa	90 kJ/m²

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min | d.a.m. 1 mm/min | conditioned	**9800 MPa** **6400 MPa**
Tensile stress at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**185 MPa** **100 MPa**
Tensile strain at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**3 %** **5,5 %**
Flexural modulus ISO 178	2 mm/min | d.a.m.	**8000 MPa**
Flexural strength ISO 178	2 mm/min | d.a.m.	**250 MPa**
Charpy impact strength ISO 179-1/1eU	23°C | d.a.m.	**90 kJ/m²**
Charpy notched impact strength ISO 179-1/1eA	23°C | d.a.m.	**12 kJ/m²**

Thermal Properties

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Temperature of deflection under load HDT/A ISO 75	1,8 MPa	**210 °C**
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	**1,35 g/cm³**
Humidity absorption ISO 1110	70°C, 62% r.H.	**2,1 - 2,3 %**
Molding shrinkage ISO 294-4	flow transverse	**0,1 - 0,3 %** **0,5 - 0,7 %**

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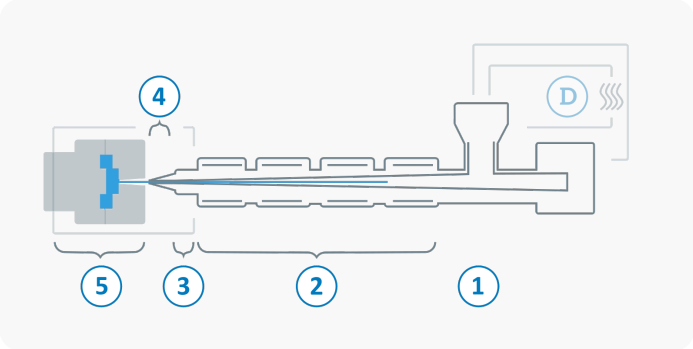
Processing

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