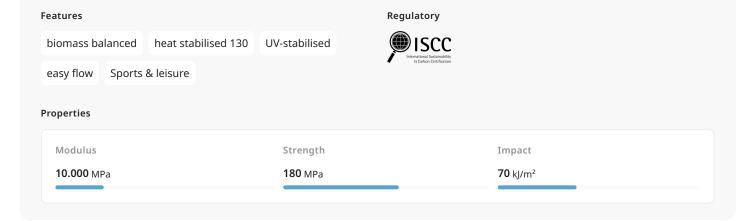


Compound No.: null

AKROMID® NEXT B28 GF 30 2 black (7059BMBCI)

PA6 GF30

AKROMID®NEXT B28 GF 30 2 black (7059BMBCI) is a 30% glass fiber reinforced, easy flowing polyamide 6. It is characterised by a high stiffness and strength. Furthermore, the material is UV and heat stabilised and therefore perfectly suitable for technical components in outdoor applications. The material is certified according to ISCC PLUS. 93 % of the fossil raw materials required for manufacturing this product were replaced by sustainable biomass-balanced PA (Y allocation factor)



Sustainability

Allocation factor	
only valid for ISCC PLUS/REDcert ² certified products	93 %

Mechanical Properties

Tensile modulus	1 mm/min d.a.m.	10000 MPa
ISO 527-2	1 mm/min conditioned	6500 MPa
Tensile stress at break	5 mm/min d.a.m.	180 MPa
ISO 527-2	5 mm/min conditioned	110 MPa
Tensile strain at break	5 mm/min d.a.m.	3 %
ISO 527-2	5 mm/min conditioned	4,5 %



Compound No.: null

Charpy impact strength ISO 179-1/1eU	23°C d.a.m. 23°C conditioned	70 kJ/m² 80 kJ/m²
	-40°C d.a.m.	9 kJ/m²

Thermal Properties

Temperature of deflection under load HDT/A ISO 75	1,8 MPa	210 °C
Temperature of deflection under load HDT/B	0,45 MPa	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

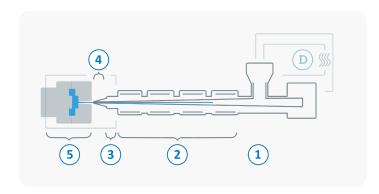
Density ISO 1183	23°C	1,36 g/cm³
Molding shrinkage	flow	0,1 - 0,3 %
ISO 294-4	transverse	0,5 - 0,7 %





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
\bigcirc	Holding pressure, spec.	300 - 800 bar
	Back pressure, spec.	50 - 150 bar
	Injection speed	medium to high
	Screw speed	8 - 15 m/min