

PA6 – Polyamide 6 PA6 GF50

AKROMID® B28 GF 50 1 GIT black (4732)

Tensile modulus

16700 MPa

1 mm/min

ISO 527-2

Stress at break

235 MPa

5 mm/min

ISO 527-2

Charpy impact strength

105 kJ/m²

23°C

ISO 179-1/1eU

AKROMID® B28 GF 50 1 GIT black (4732) is a 50% glass fibre reinforced, heat stabilised, easy flowing polyamide 6 with very high stiffness and strength for gas injection technology.

Typical applications

Engineering parts, which are produced by gas injection technology. Furthermore B28 GF 50 1 GIT black (4732) can be used for standard injection moulding for demanding surface quality.



Mechanical Properties

Tensile modulus (1 mm/min | ISO 527-2)

d.a.m.

16700 MPa

conditioned

10500 MPa

Stress at break (5 mm/min | ISO 527-2)

d.a.m.

235 MPa

conditioned

150 MPa

Strain at break (5 mm/min | ISO 527-2)

d.a.m.

3 %

conditioned

4,5 %

Charpy impact strength (23°C | ISO 179-1/1eU)

d.a.m.

105 kJ/m²

conditioned

105 kJ/m²

Charpy notched impact strength (23°C | ISO 179-1/1eA)

d.a.m.

20 kJ/m²

conditioned

25 kJ/m²



Thermal Properties

Melting temperature (DSC, 10K/min | DIN EN 11357-1)

220 °C



Flammability

Burning rate (UL 94)

0,8mm Wall thickness

HB Class

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

+



General properties

Density (23°C | ISO 1183)

1,55 g/cm³

Humidity absorption (70°C, 62% r.F. | ISO 1110)

1,65 %

Molding shrinkage (flow | ISO 294-4)

0,1-0,3 %

Molding shrinkage (transverse | ISO 294-4)

0,4-0,6 %

Disclaimer:

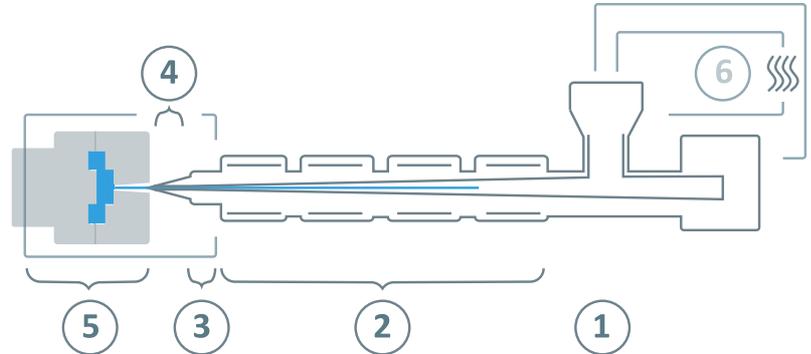
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Processing information

The listed values are recommendations. Higher values should be used for higher glass loadings. We recommend only dehumidifying or vacuum dryers. Extensive drying can cause filling problems and surface defects.



⑥	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	Melting 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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