

PA6.6 – Polyamide 6.6 PA66 GF50

**AKROMID® A28 GF 50 1 GIT black (5029)**

Tensile modulus

**17500 MPa**1 mm/min  
ISO 527-2

Stress at break

**270 MPa**5 mm/min  
ISO 527-2

Charpy impact strength

**100 kJ/m<sup>2</sup>**23°C  
ISO 179-1/1eU

AKROMID® A28 GF 50 1 GIT black (5029) is a 50% glass fibre reinforced, heat stabilised, easy flowing polyamide 6.6 with very high stiffness and strength, for gas injection technology

**Typical applications**

Engineering parts, which are produced by gas injection technology. Furthermore AKROMID® A28 GF 50 1 GIT black (5029) can be used for standard injection moulding for demanding surface quality.

**Mechanical Properties**

Tensile modulus (1 mm/min   ISO 527-2) d.a.m.	17500 MPa
Stress at break (5 mm/min   ISO 527-2) d.a.m.	270 MPa
Strain at break (5 mm/min   ISO 527-2) d.a.m.	3 %
Flexural modulus (2 mm/min   ISO 178) d.a.m.	16800 MPa
Flexural strength (2 mm/min   ISO 178) d.a.m.	380 MPa
Flexural strain at break (2 mm/min   ISO 178) d.a.m.	3 %
Charpy impact strength (23°C   ISO 179-1/1eU) d.a.m.	100 kJ/m <sup>2</sup>
Charpy notched impact strength (23°C   ISO 179-1/1eA) d.a.m.	20 kJ/m <sup>2</sup>

**Thermal Properties**

Temperature of deflection under load HDT/A (1,8 MPa   ISO 75)	260 °C
Temperature of deflection under load HDT/C (8 MPa   ISO 75)	225 °C
Melting temperature (DSC, 10K/min   DIN EN 11357-1)	260 °C
Coefficient of linear thermal expansion, parallel (23°C bis 80°C   ISO 11359-1/2)	0,15 1,0E-4/K
Coefficient of linear thermal expansion, transverse (23°C bis 80°C   ISO 11359-1/2)	0,78 1,0E-4/K

**Flammability**

Burning rate (UL 94) 1,6mm Wall thickness	HB Class
Burning rate (<100 mm/min) (> 1 mm Thickness   FMVSS 302)	+

**Disclaimer:**

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**General properties**

Density (23°C   ISO 1183)	1,57 g/cm <sup>3</sup>
Molding shrinkage (flow   ISO 294-4)	0,1 - 0,3 %
Molding shrinkage (transverse   ISO 294-4)	0,5 - 0,7 %

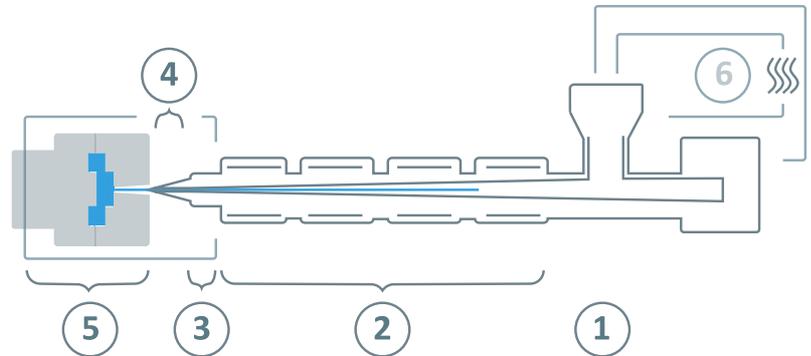
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**AKROMID® A28 GF 50 1 GIT black (5029)****Processing information**

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	260 - 300°C
③	Nozzle temperature	270 - 310°C
④	Melt temperature	280 - 300°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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