

PA6 + PP LGF50

AKROMID® B28 LGF 50 1 L black (5928)

Tensile modulus

14500 MPa

1 mm/min

ISO 527-2

Stress at break

210 MPa

5 mm/min

ISO 527-2

Charpy impact strength

95 kJ/m²

23°C

ISO 179-1/1eU

AKROMID® B28 LGF 50 1 L black (5928) is a 50% long glass fibre reinforced easy flowing polyamide 6 with extraordinary high stiffness and strength even at high temperature and very high impact and notched impact strength at elevated and low temperature as well as a reduced density compared to standard PA6 LGF 50. B28 LGF 50 1 L black (5928) distinguish due to isotrop mechanical properties, low shrinkage, higher heat deflection temperature and very good fatigue performance.

Typical applications

Technical components in the automotive and electronic industry, where a weight and cost reduction is required.



Mechanical Properties

Tensile modulus (1 mm/min ISO 527-2) d.a.m.	14500 MPa
Stress at break (5 mm/min ISO 527-2) d.a.m.	210 MPa
Strain at break (5 mm/min ISO 527-2) d.a.m.	2,2 %
Charpy impact strength (23°C ISO 179-1/1eU) d.a.m.	95 kJ/m ²
Charpy notched impact strength (23°C ISO 179-1/1eA) d.a.m.	38 kJ/m ²



Thermal Properties

Temperature of deflection under load HDT/A (1,8 MPa ISO 75)	218 °C
Glass transition temperature (DSC, 2nd heating DIN EN 11357-1)	58 °C
Melt temperature (DSC, 10K/min DIN EN 11357-1)	220 °C



Flammability

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



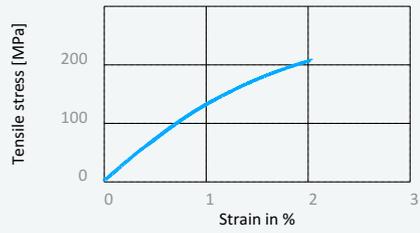
General properties

Density (23°C ISO 1183)	1,42 g/cm ³
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Disclaimer:

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Stress strain chart at 23°C



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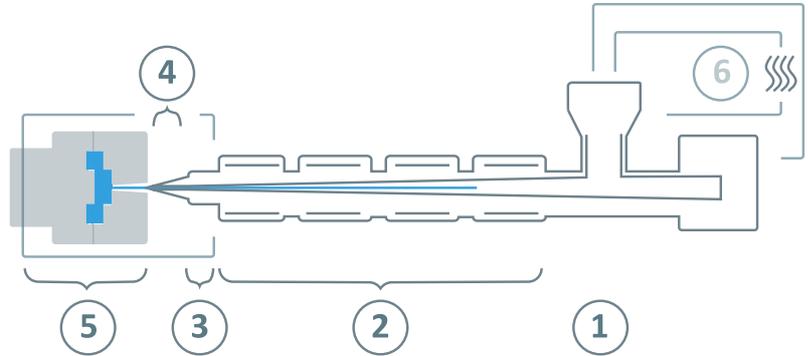
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Processing information

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	260 - 290°C
③	Nozzle temperature	270 - 300°C
④	Melt temperature	270 - 290°C
⑤	Mold temperature	80 - 100°C
→	Holding pressure, spec.	300 - 800 bar
←	Back pressure, spec.	10 - 30 bar
	Injection speed	slow to medium
	Screw speed	5 - 15 m/min

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