

PA6 – Polyamide 6 PA6 GF33

AKROMID® B28 GF 33 1 GIT black (6846)

Tensile modulus

10500 MPa

 1 mm/min
 ISO 527-2

Stress at break

190 MPa

 5 mm/min
 ISO 527-2

Charpy impact strength

95 kJ/m²

 23°C
 ISO 179-1/1eU

AKROMID® B28 GF 33 1 GIT black (6846) is a 33% 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 33 1 GIT black (6846) can be used for standard injection moulding for demanding surface quality.



Mechanical Properties

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

d.a.m.

10500 MPa

conditioned

6600 MPa

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

d.a.m.

190 MPa

conditioned

120 MPa

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

d.a.m.

3 %

conditioned

4,5 %

Flexural modulus (2 mm/min | ISO 178)

d.a.m.

9000 MPa

Flexural strength (2 mm/min | ISO 178)

d.a.m.

275 MPa

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

d.a.m.

95 kJ/m²

conditioned

105 kJ/m²

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

d.a.m.

14 kJ/m²

conditioned

18 kJ/m²

Thermal Properties

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)

1,38 g/cm³

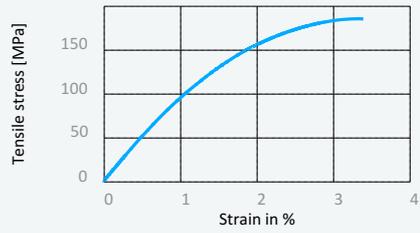
Humidity absorption (70°C, 62% r.H. | ISO 1110)

1,8 %

Disclaimer:

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Stress strain chart at 23°C



Rheological Properties

MVR (275°C/5kg | ISO 1133)

40 cm³/10min

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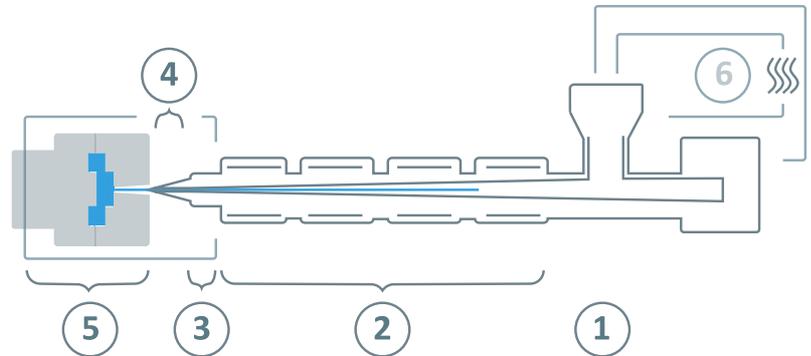
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Processing information

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	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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