AKROMID® A28 GF 30 1 GIT black (4619)

PA66-GF30 Akro-Plastic GmbH

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	**0.2 / ***	%	ISO 294-4, 2577
Molding shrinkage, normal	**0.8 / ***	%	ISO 294-4, 2577

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	**9500 / 7000**	MPa	ISO 527
Stress at break	**195 / 130**	MPa	ISO 527
Strain at break	**3.5 / 7**	%	ISO 527
Flexural modulus, 23°C	**8700 / -**	MPa	ISO 178
Flexural strength	**300 / -**	MPa	ISO 178
Charpy impact strength, +23°C	**90 / 100**	kJ/m²	ISO 179/1eU
Charpy impact strength, -30°C	**70 / -**	kJ/m²	ISO 179/1eU
Charpy notched impact strength, +23°C	**15 / 19**	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	**13 / -**	kJ/m²	ISO 179/1eA

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
Melting temperature, 10°C/min	**255 / ***	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	**255 / ***	°C	ISO 75-1/-2
Temp. of deflection under load, 8.00 MPa	**180 / ***	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	**19 / ***	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	**95 / ***	E-6/K	ISO 11359-1/-2
Burning behav. at thickness h	**HB / ***	class	IEC 60695-11-10
Thickness tested	**0.8 / ***	mm	-

Other properties	dry / cond	Unit	Test Standard
Density	**1360 / -**	kg/m³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Melt temperature	**320**	°C	-
Mold temperature	**100**	°C	-
Injection pressure	**75**	MPa	-

Characteristics

Processing
Injection Molding

Special Characteristics
Heat stabilized or stable to heat

Delivery form
Black

Regional Availability
Europe, Asia Pacific