

AKROMID® A28 GF 30 1 GIT black (4619)

Polyamide 66
AKRO-PLASTIC GmbH

Message:

AKROMID® A28 GF 30 1 GIT black (4619) is a 30% glass fibre reinforced, heat stabilised, easy flowing polyamide 66 with high stiffness and strength for gas injection technology.
Applications are engineering parts, which are produced by gas injection technology. Furthermore A28 GF 30 1 GIT black (4619) can be used for standard injection moulding for demanding surface quality.

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Additive	Heat Stabilizer		
Features	Good Flow		
	Heat Stabilized		
	High Stiffness		
	High Strength		
Uses	Engineering Parts		
Appearance	Black		
Processing Method	Gas-Assisted Injection Molding		
	Injection Molding		
Resin ID (ISO 1043)	PA66 GF30		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.36	g/cm ³	ISO 1183
Spiral Flow	110	cm	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	9500	MPa	ISO 527-2/1
Tensile Stress (Break)	195	MPa	ISO 527-2/5
Tensile Strain (Break)	3.5	%	ISO 527-2/5
Flexural Modulus ¹	8700	MPa	ISO 178
Flexural Stress ²	300	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	13	kJ/m ²	
23°C	15	kJ/m ²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	70	kJ/m ²	
23°C	90	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method

Heat Deflection Temperature (8.0 MPa, Unannealed)	180	°C	ISO 75-2/C
Melting Temperature ³	255	°C	DIN EN 11357-1
Flammability	Nominal Value	Unit	Test Method
Burning Rate ⁴ (1.00 mm)	< 100	mm/min	FMVSS 302
Flame Rating (0.800 mm)	HB		UL 94
Additional Information	Nominal Value	Unit	Test Method
Reinforcement Content	30	%	ISO 1172
NOTE			
1.	2.0 mm/min		
2.	2.0 mm/min		
3.	10 K/min, DSC		
4.	>1 mm		

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