

AKROMID® PRELIMINARY

B25 GF 40 L black (8452)

PA6+PP GF40

AKROMID® B25 GF 40 L black (8452) is a 40% glass fibre reinforced, very easy flowing polyamide blend with reduced density compared to standard PA6 GF 40.

Features

reduced density easy flow

Properties

Modulus

11.500 MPa

Strength

150 MPa

Impact

60 kJ/m²

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

11500 MPa

1 mm/min | conditioned

8500 MPa

Tensile stress at break

ISO 527-2

5 mm/min | d.a.m.

150 MPa

5 mm/min | conditioned

115 MPa

Tensile strain at break

ISO 527-2

5 mm/min | d.a.m.

2,2 %

5 mm/min | conditioned

3,9 %

Charpy impact strength

ISO 179-1/1eU

23°C | d.a.m.

60 kJ/m²

23°C | conditioned

62 kJ/m²

Charpy notched impact strength

ISO 179-1/1eA

23°C | d.a.m.

13 kJ/m²

23°C | conditioned

15 kJ/m²

Thermal Properties

Temperature of deflection under load HDT/A

ISO 75

1,8 MPa

200 °C

Melting temperature

ISO 11357-3

DSC, 10K/min

220 °C

Flammability

Flammability	0,8 mm Wall thickness	HB Class
UL 94		

General Properties

Density	23°C	1,36 g/cm³
ISO 1183		

Humidity absorption	70°C, 62% r.H.	1,2 %
ISO 1110		

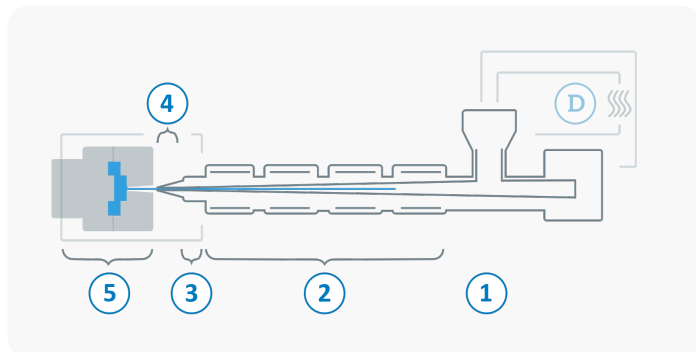
Molding shrinkage	flow	0,3 - 0,5 %
ISO 294-4	transverse	0,8 - 1,0 %

Rheological Properties

MVR	275°C/5kg	31 cm³/10 min
ISO 1133		

Processing

The values mentioned are recommendations. We only recommend desiccant / dry air dryers or vacuum dryers. Too long a drying time and the resulting residual moisture content below the lower limit can lead to filling problems and surface defects. The specified drying time refers to closed and undamaged bagged material. When processing from previously opened bags or from octabins with polyolefin inliners, a longer drying time may be necessary. It is recommended to check the residual moisture content after the drying process.



D	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	220 - 290 °C
3	Nozzle temperature	240 - 300 °C
4	Melt temperature	240 - 290 °C
5	Mold temperature	70 - 100 °C
→	Holding pressure, spec.	300 - 800 bar
←	Back pressure, spec.	50 - 150 bar
	Injection speed	medium to high
	Screw speed	5 - 15 m/min