

AKROMID® PRELIMINARY

B25 GF 30 1 FR natural (8954)

PA6 GF30 FR(40)

AKROMID® B25 GF 30 1 FR natural (8954) is a flame-retardant, heat-stabilised, 30% glass fibre-reinforced PA6. The material is based on a flame-retardant system that is free of red phosphorus, halogens, melamine and PFAS. It achieves a V0 classification from a thickness of 0.4 mm and complies with IEC 60335 GWEPT requirements. This product is designed for high flowability for thin walled parts. Suitable applications are in the appliance industry, E&E market and E-mobility sector.

Features

heat stabilised 130 flame retardant easy flow process improved E&E household appliances E-Mobility

Properties

Modulus

11.000 MPa

Strength

145 MPa

Impact

65 kJ/m²

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

11000 MPa

Tensile stress at break

ISO 527-2

5 mm/min | d.a.m.

145 MPa

Tensile strain at break

ISO 527-2

5 mm/min | d.a.m.

3,0 %

Charpy impact strength

ISO 179-1/1eU

23°C | d.a.m.

65 kJ/m²

Thermal Properties

Melting temperature

ISO 11357-3

DSC, 10K/min

220 °C

Flammability

Flammability UL 94	0,4 mm Wall thickness	V-0 Class
	0,8 mm Wall thickness	V-0 Class
	1,6 mm Wall thickness	V-0 Class
	3,2 mm Wall thickness	V-0 Class
GWFI IEC 60695-2-12	0,4 mm Wall thickness	960 °C
	0,8 mm Wall thickness	960 °C
	1,6 mm Wall thickness	960 °C
	3,2 mm Wall thickness	960 °C
GWIT IEC 60695-2-13	0,4 mm Wall thickness	800 °C
	0,8 mm Wall thickness	800 °C
	1,6 mm Wall thickness	800 °C
	3,2 mm Wall thickness	775 °C

General Properties

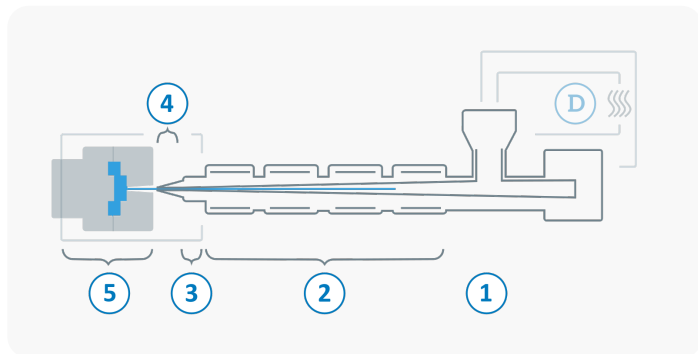
Density ISO 1183	23°C	1,4 g/cm³
Molding shrinkage ISO 294-4	flow	0,1 - 0,3 %
	transverse	0,5 - 0,7 %

Electrical Properties

Comparative tracking index IEC 60112	Test liquid A	600 V
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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	2 - 4 h
	Drying temperature ($\tau \leq -30^{\circ}\text{C}$)	80 °C
	Processing moisture	0,02 - 0,08 %
1	Feed section	60 - 80 °C
2	Temperature Zone 1 - Zone 4	220 - 280 °C
3	Nozzle temperature	240 - 280 °C
4	Melt temperature	240 - 280 °C
5	Mold temperature	60 - 100 °C
→	Holding pressure, spec.	300 - 800 bar
←	Back pressure, spec.	30 - 100 bar
	Injection speed	medium
	Screw speed	5 - 10 m/min