AKROMID®
B28 GM 5/25 FR black (7492)

PA6 (GF5+GB25) FR(40)

AKROMID® B28 GM 5/25 FR black (7492) is a flame retardant PA6, reinforced with 5% glass fibres and 25% glass beads. The flame retardant system is free of halogens, red phosphorus, PFAS and melamine. Due to its good flowability, it is characterised by easy processability as well as good surface properties. The product is suitable for enclosure applications in the E&E industry due to its low warpage, high stiffness and strength.

Features

flame retardant | recycled content | low warpage | easy flow | E&E

Properties

Modulus	Strength	Impact
5.000 MPa	**55** MPa	**30** kJ/m²

Sustainability

Recycled content	**25 %**

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min | d.a.m. 1 mm/min | conditioned	**5000 MPa** **3000 MPa**
Tensile stress at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**55 MPa** **35 MPa**
Tensile strain at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**3,6 %** **5 %**
Charpy impact strength ISO 179-1/1eU	23°C | d.a.m.	**30 kJ/m²**

Thermal Properties

+135-3858-6433 (GuangDong)
+188-1699-6168 (ShangHai)
+852-6957-5415 (HongKong)

Melting temperature ISO 11357-3	DSC, 10K/min	**220 °C**

Flammability

Flammability UL 94	1,6 mm Wall thickness	**V-0 Class**
	3,2 mm Wall thickness	**V-0 Class**

General Properties

Density ISO 1183	23°C	**1,39 g/cm³**
Humidity absorption ISO 1110	70°C, 62% r.H.	**1,4 - 1,6 %**
Molding shrinkage ISO 294-4	flow	**0,65 - 0,85 %**
	transverse	**0,75 - 0,95 %**

Electrical Properties

Comparative tracking index IEC 60112	Test liquid A	**600 V**

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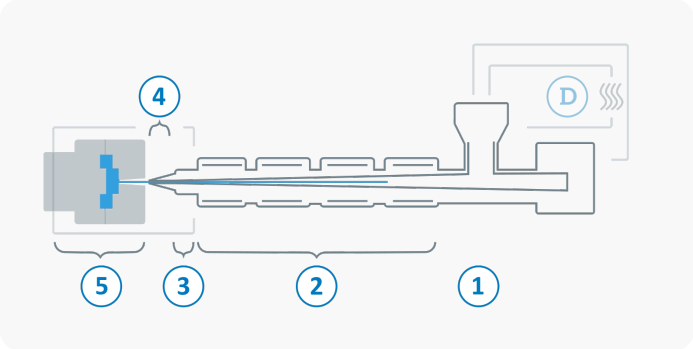
Processing

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 (τ <= -30°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