+135-3858-6433 (GuangDong)
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+852-6957-5415 (HongKong)

AKRO COMPOUNDS

Compound No.: **8994**

AKROMID® UL PRELIMINARY
B28 GM 15/15 1 FR grey (8994)

PA6 (GF15+GB15) FR(40)

AKROMID® B28 GM 15/15 1 FR grey (8894) is an UL listed flame retardant PA6, reinforced with 15% glass fibres and 15% glass beads. The flame retardant system is free of halogens, red phosphorus, PFAS zinc borate 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. This grade is colored similar to RAL 7035.

Features

flame retardant | laser markable | surface modified | recycled content | low warpage | easy flow | E&E

Regulatory

Properties

Modulus	Strength	Impact
8.200 MPa	**85** MPa	**30** kJ/m²

Sustainability

Recycled content	**15 %**

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min | d.a.m.	**8200 MPa**
Tensile stress at break ISO 527-2	5 mm/min | d.a.m.	**85 MPa**
Tensile strain at break ISO 527-2	5 mm/min | d.a.m.	**1,9 %**
Charpy impact strength ISO 179-1/1eU	23°C | d.a.m.	**30 kJ/m²**

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Thermal Properties

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

Flammability

Flammability UL 94	UL 0,8 mm Wall thickness	**V-0 Class**
	UL 1,6 mm Wall thickness	**V-0 Class**
	UL 3,2 mm Wall thickness	**V-0 Class**
Burning rate (<100 mm/min) FMVSS 302	> 1 mm Thickness	+

General Properties

Density ISO 1183	23°C	**1,44 g/cm³**
Humidity absorption ISO 1110	70°C, 62% r.H.	**1,4 - 1,6 %**
Molding shrinkage ISO 294-4	flow	**0,7 - 0,9 %**
	transverse	**0,8 - 1,0 %**

Electrical Properties

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

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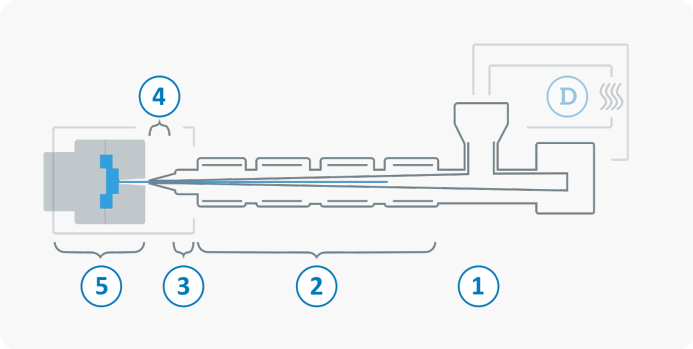
Processing

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