AKROMID®
B25 GF 60 1 LA black (8281)

PA6 GF60

AKROMID® B25 GF 60 1 LA black (8281) is a 60% glass fibre reinforced, slightly heat stabilised, easy flowing polyamide 6 with very high stiffness and strength, lasermarkable.

Features

laser markable | easy flow

Properties

Modulus	Strength	Impact
21.000 MPa	**255** MPa	**95** kJ/m²

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min | d.a.m. 1 mm/min | conditioned	**21000 MPa** **14200 MPa**
Tensile stress at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**255 MPa** **175 MPa**
Tensile strain at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**2,4 %** **4 %**
Flexural modulus ISO 178	2 mm/min | d.a.m.	**20000 MPa**
Flexural strength ISO 178	2 mm/min | d.a.m.	**400 MPa**
Charpy impact strength ISO 179-1/1eU	23°C | d.a.m. 23°C | conditioned	**95 kJ/m²** **105 kJ/m²**
Charpy notched impact strength ISO 179-1/1eA	23°C | d.a.m. 23°C | conditioned	**20 kJ/m²** **26 kJ/m²**

Thermal Properties

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Temperature of deflection under load HDT/A ISO 75	1,8 MPa	**220 °C**
Temperature of deflection under load HDT/B ISO 75	0,45 MPa	**220 °C**
Temperature of deflection under load HDT/C ISO 75	8 MPa	**190 °C**
Melting temperature ISO 11357-3	DSC, 10K/min	**220 °C**
Coefficient of linear thermal expansion ISO 11359-1/2	23°C to 80°C | parallel 23°C to 80°C | transverse	**0,13 10^{-4}/K** **0,60 10^{-4}/K**

Flammability

Flammability UL 94	1,6 mm Wall thickness	**HB Class**
GWFI IEC 60695-2-12	1,6 mm Wall thickness	**650 °C**
GWIT IEC 60695-2-13	1,6 mm Wall thickness	**675 °C**
Burning rate (<100 mm/min) FMVSS 302	> 1 mm Thickness	+

General Properties

Density ISO 1183	23°C	**1,7 g/cm³**
Humidity absorption ISO 1110	70°C, 62% r.H.	**0,9 - 1,2 %**
Molding shrinkage ISO 294-4	flow transverse	**0,1 - 0,3 %** **0,3 - 0,5 %**

Electrical Properties

Volume resistivity IEC 62631-3-1	d.a.m.	**10^{13} Ω x cm**
	conditioned	**10^{10} Ω x cm**
Surface resistivity IEC 62631-3-2	d.a.m.	**10^{12} Ω**
	conditioned	**10^{10} Ω**

Rheological Properties

Flowability AKRO	1 mm Thickness	**120 mm**
	2 mm Thickness	**420 mm**

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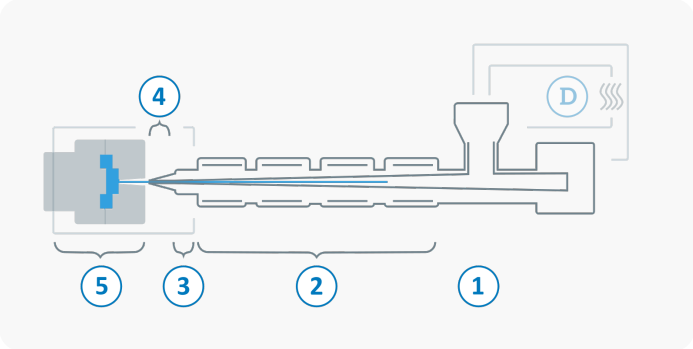
Processing

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	0 - 4 h
	Drying temperature (τ <= -30°C)	80 °C
	Processing moisture	0,02 - 0,1 %
1	Feed section	60 - 80 °C
2	Temperature Zone 1 - Zone 4	240 - 290 °C
3	Nozzle temperature	260 - 300 °C
4	Melt temperature	270 - 290 °C
5	Mold temperature	80 - 100 °C
→	Holding pressure, spec.	300 - 800 bar
←	Back pressure, spec.	50 - 150 bar
	Injection speed	medium to high
	Screw speed	8 - 15 m/min

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Diagrams