

AKROMID®

B28 GM 15/15 1 FR natural (8861)

PA6 (GF15+GB15) FR(40)

AKROMID® B28 GM 15/15 1 FR natural (8861) 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 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 surface modified recycled content

low warpage easy flow E&E

Regulatory



Properties

Modulus

8.400 MPa

Strength

105 MPa

Impact

50 kJ/m²

Sustainability

Recycled content 15 %

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

8400 MPa

Tensile stress at break

ISO 527-2

5 mm/min | d.a.m.

105 MPa

Tensile strain at break

ISO 527-2

5 mm/min | d.a.m.

2,8 %

Charpy impact strength

ISO 179-1/1eU

23°C | d.a.m.

50 kJ/m²

Thermal Properties

Temperature of deflection under load HDT/A ISO 75	1,8 MPa	200 °C
Temperature of deflection under load HDT/B ISO 75	0,45 MPa	217 °C
Temperature of deflection under load HDT/C ISO 75	8 MPa	102 °C
Melting temperature ISO 11357-3	DSC, 10K/min	220 °C

Flammability

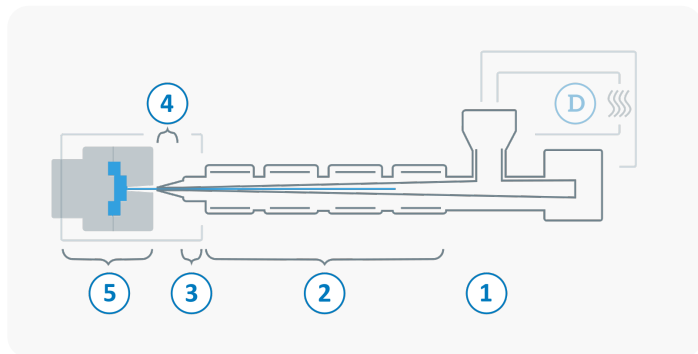
Flammability UL 94	UL 0,8 mm Wall thickness	V-0 Class
	UL 1,6 mm Wall thickness	V-0 Class
	UL 3,2 mm Wall thickness	V-0 Class
GWFI IEC 60695-2-12	0,8 mm Wall thickness	960 °C
	1,6 mm Wall thickness	960 °C
	3,2 mm Wall thickness	960 °C
GWIT IEC 60695-2-13	1,6 mm Wall thickness	775 °C
Burning rate (<100 mm/min) FMVSS 302	> 1 mm Thickness	+

General Properties

Density ISO 1183	23°C	1,44 g/cm ³
Molding shrinkage ISO 294-4	flow	0,65 - 0,85 %
	transverse	0,75 - 0,95 %

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