

AKROMID®

B3 GF 25 1 natural (2463)

PA6 GF25

AKROMID® B3 GF 25 1 natural (2463) is a 25% glass fibre reinforced, heat stabilised polyamide 6 with high stiffness and strength and light inherent color

Features

heat stabilised 130

Properties

Modulus

8.500 MPa

Strength

160 MPa

Impact

85 kJ/m²

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

8500 MPa

1 mm/min | conditioned

5100 MPa

Tensile stress at break

ISO 527-2

5 mm/min | d.a.m.

160 MPa

5 mm/min | conditioned

100 MPa

Tensile strain at break

ISO 527-2

5 mm/min | d.a.m.

3,5 %

5 mm/min | conditioned

6,5 %

Flexural modulus

ISO 178

2 mm/min | d.a.m.

7000 MPa

Flexural strength

ISO 178

2 mm/min | d.a.m.

245 MPa

Charpy impact strength

ISO 179-1/1eU

23°C | d.a.m.

85 kJ/m²

23°C | conditioned

90 kJ/m²

-30°C | d.a.m.

80 kJ/m²

Charpy notched impact strength

ISO 179-1/1eA

23°C | d.a.m.

12 kJ/m²

23°C | conditioned

16 kJ/m²

-30°C | d.a.m.

10 kJ/m²

Ball indentation hardness

ISO 2039-1

961N/30s | d.a.m.

215 MPa

Thermal Properties

Temperature of deflection under load HDT/A

ISO 75

1,8 MPa

210 °C

Temperature of deflection under load HDT/B

ISO 75

0,45 MPa

220 °C

Melting temperature

ISO 11357-3

DSC, 10K/min

220 °C

Flammability

Flammability

UL 94

0,8 mm Wall thickness

HB Class

GWFI

IEC 60695-2-12

1,6 mm Wall thickness

650 °C

Burning rate (<100 mm/min)

FMVSS 302

> 1 mm Thickness

+

General Properties

Density

ISO 1183

23°C

1,31 g/cm³

Humidity absorption

ISO 1110

70°C, 62% r.H.

2,2 - 2,5 %

Water absorption

ISO 62

23°C, saturated

6,8 - 7,4 %

Molding shrinkage

ISO 294-4

flow

0,1 - 0,3 %

transverse

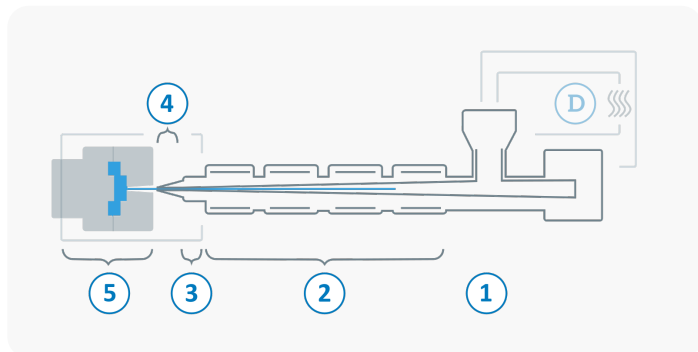
0,55 - 0,75 %

Electrical Properties

Volume resistivity	d.a.m.	$10^{13} \Omega \times \text{cm}$
IEC 62631-3-1	conditioned	$10^{10} \Omega \times \text{cm}$
Surface resistivity	d.a.m.	$10^{12} \Omega$
IEC 62631-3-2	conditioned	$10^{10} \Omega$
Comparative tracking index	Test liquid A	600 V
IEC 60112		

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 ($\tau \leq -30^{\circ}\text{C}$)	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

Diagrams

