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

AKRO COMPOUNDS

Compound No.: **8515**

AKROLOY® UL PRELIMINARY

PARA GF 40 HU black (8515)

PARA GF40

AKROLOY® PARA GF 40 HU black (8515) is a 40% glass fibre reinforced polyarylamid with very high stiffness and strength, even in conditioned state it impresses with very high stiffness and strength owing to its lower moisture uptake. Furthermore, the material shows very good flowability and surface properties. It is perfectly suitable for parts where dimensional stabilitiy is required. Besides, it can be used as an alternative for aluminium and zinc diecast alloys. The material is listed at UL in all colors.

Features

reduced moisture | easy flow | metal substitution

Regulatory

Properties

Modulus	Strength	Impact
16.000 MPa	260 MPa	Na

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min | d.a.m.	16000 MPa
Tensile stress at break ISO 527-2	5 mm/min | d.a.m.	260 MPa
Tensile strain at break ISO 527-2	5 mm/min | d.a.m.	2,3 %

Thermal Properties

RTI electrical UL 746B	UL 0,8mm Wall thickness	65 °C
	UL 1,6mm Wall thickness	65 °C
	UL 3,2mm Wall thickness	65 °C
RTI impact UL 746B	UL 0,8mm Wall thickness	65 °C
	UL 1,6mm Wall thickness	65 °C
	UL 3,2mm Wall thickness	65 °C

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RTI strength UL 746B	UL 0,8mm Wall thickness	65 °C
	UL 1,6mm Wall thickness	65 °C
	UL 3,2mm Wall thickness	65 °C
Melting temperature ISO 11357-3	DSC, 10K/min	238 °C

Flammability

Flammability UL 94	UL 0,8 mm Wall thickness	HB Class
	UL 1,6 mm Wall thickness	HB Class
	UL 3,2 mm Wall thickness	HB Class
HWI UL 746A	UL 0,8 mm Wall thickness	4 PLC
	UL 1,6 mm Wall thickness	2 PLC
	UL 3,2 mm Wall thickness	2 PLC
HAI UL 746A	UL 0,8 mm Wall thickness	0 PLC
	UL 1,6 mm Wall thickness	0 PLC
	UL 3,2 mm Wall thickness	0 PLC
Burning rate (<100 mm/min) FMVSS 302	> 1 mm Thickness	+

Electrical Properties

Comparative tracking index IEC 60112	UL Test liquid A	600 V

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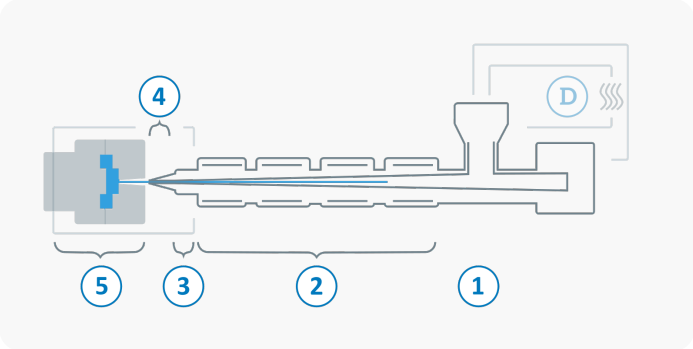
Processing

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	4 - 12 h
	Drying temperature (τ <= -30°C)	80 - 90 °C
	Processing moisture	0,02 - 0,1 %
1	Feed section	60 - 80 °C
2	Temperature Zone 1 - Zone 4	250 - 300 °C
3	Nozzle temperature	270 - 300 °C
4	Melt temperature	270 - 300 °C
5	Mold temperature	120 - 160 °C
→	Holding pressure, spec.	300 - 1500 bar
←	Back pressure, spec.	50 -150 bar
	Injection speed	high
	Screw speed	8 - 10 m/min