

AKROLEN®

PP GFM 25/15 natural (2118)

PP (GF25+MD15)

AKROLEN® PP GFM 25/15 natural (2118) is a 25% glass fibre reinforced, 15% mineral filled polypropylene with good surface, dimensional stability and light inherent color

Features

surface modified

Properties

Modulus

6.500 MPa

Strength

Na

Impact

45 kJ/m²

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

6500 MPa

Tensile stress at break

ISO 527-2

50 mm/min | d.a.m.

75 MPa

Tensile strain at break

ISO 527-2

50 mm/min | d.a.m.

3,5 %

Flexural modulus

ISO 178

2 mm/min | d.a.m.

6600 MPa

Flexural strength

ISO 178

2 mm/min | d.a.m.

105 MPa

Flexural strain at break

ISO 178

2 mm/min | d.a.m.

3,5 %

Charpy impact strength

ISO 179-1/1eU

23°C | d.a.m.

45 kJ/m²

-30°C | d.a.m.

45 kJ/m²

Charpy notched impact strength

ISO 179-1/1eA

23°C | d.a.m.

10 kJ/m²

Izod notched impact strength	23°C d.a.m.	10 kJ/m²
ISO 180/1A		

Ball indentation hardness	358N/30s d.a.m.	100 MPa
ISO 2039-1		

Thermal Properties

Temperature of deflection under load HDT/A	1,8 MPa	150 °C
ISO 75		

Temperature of deflection under load HDT/B	0,45 MPa	163 °C
ISO 75		

Melting temperature	DSC, 10K/min	167 °C
ISO 11357-3		

Flammability

Flammability	1,6 mm Wall thickness	HB Class
UL 94		

Burning rate (<100 mm/min)	> 1 mm Thickness	+
FMVSS 302		

General Properties

Density	23°C	1,21 g/cm³
ISO 1183		

Molding shrinkage	flow	0,1 - 0,3 %
ISO 294-4	transverse	0,4 - 0,6 %

Electrical Properties

Volume resistivity	d.a.m.	> 2 * 10¹¹ Ω x cm
IEC 62631-3-1		

Comparative tracking index	Test liquid A	600 V
IEC 60112		

Dielectric strength

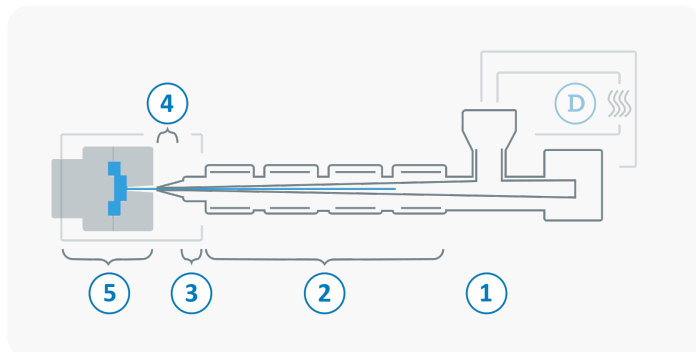
IEC 60243

3 mm

18 kV/mm

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 - 3 h
	Drying temperature ($\tau \leq -30^{\circ}\text{C}$)	80 °C
	Processing moisture	0,1 %
1	Feed section	40 - 80 °C
2	Temperature Zone 1 - Zone 4	200 - 255 °C
3	Nozzle temperature	200 - 255 °C
4	Melt temperature	215 - 265 °C
5	Mold temperature	30 - 80 °C
→	Holding pressure, spec.	300 - 800 bar
←	Back pressure, spec.	50 - 100 bar
	Injection speed	medium to high
	Screw speed	8 - 15 m/min