

**AKROMID® B3 GF 25 1 L black (4637)**

(PA6+PP)-GF25

Akro-Plastic GmbH

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Melt volume-flow rate, MVR	10 / *	cm <sup>3</sup> /10min	ISO 1133
Temperature	275 / *	°C	-
Load	5 / *	kg	-
Molding shrinkage, parallel	0.2 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7 / *	%	ISO 294-4, 2577

Mechanical properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	7500 / 5600	MPa	ISO 527
Stress at break	135 / 88	MPa	ISO 527
Strain at break	3.3 / 4.5	%	ISO 527
Charpy impact strength, +23°C	68 / 58	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength, -30°C	67 / 54	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	15 / 15	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	13 / 10	kJ/m <sup>2</sup>	ISO 179/1eA

Thermal properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Melting temperature, 10°C/min	220 / *	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	198 / *	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	217 / *	°C	ISO 75-1/-2
Burning behav. at thickness h	HB / *	class	IEC 60695-11-10
Thickness tested	0.8 / *	mm	-
Glow Wire Flammability Index (GWFI)	750	°C	IEC 60695-2-12
GWFI - thickness tested (1)	0.8	mm	-
Glow Wire Flammability Index (GWFI)	725	°C	IEC 60695-2-12
GWFI - thickness tested (2)	1.6	mm	-
Glow Wire Flammability Index (GWFI)	750	°C	IEC 60695-2-12
GWFI - thickness tested (3)	3.2	mm	-
Glow Wire Ignition Temperature (GWIT)	775	°C	IEC 60695-2-13
GWIT - thickness tested (1)	0.8	mm	-
Glow Wire Ignition Temperature (GWIT)	750	°C	IEC 60695-2-13
GWIT - thickness tested (2)	1.6	mm	-
Glow Wire Ignition Temperature (GWIT)	775	°C	IEC 60695-2-13
GWIT - thickness tested (3)	3.2	mm	-

Other properties	dry / cond	Unit	Test Standard
Density	1220 / -	kg/m <sup>3</sup>	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Melt temperature	270	°C	-
Mold temperature	80	°C	-
Injection pressure	75	MPa	-

**Characteristics****Processing**

Injection Molding

**Delivery form**

Black

**Special Characteristics**

Heat stabilized or stable to heat

**Applications**

Automotive, Electrical and Electronical

**Regional Availability**

Europe, Asia Pacific