

AKROMID® B3 GF 25 natural (2471)

PA6-GF25

Akro-Plastic GmbH

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.2 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.8 / *	%	ISO 294-4, 2577

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	8500 / 5100	MPa	ISO 527
Stress at break	160 / 100	MPa	ISO 527
Strain at break	3.5 / 6.5	%	ISO 527
Flexural modulus, 23°C	7000 / -	MPa	ISO 178
Flexural strength	245 / -	MPa	ISO 178
Charpy impact strength, +23°C	85 / 90	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	80 / -	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	12 / 16	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	10 / -	kJ/m ²	ISO 179/1eA
Ball indentation hardness	215 / -	MPa	ISO 2039-1

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
Melting temperature, 10°C/min	220 / *	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	210 / *	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	220 / *	°C	ISO 75-1/-2
Burning behav. at 1.5 mm nom. thickn.	HB / *	class	IEC 60695-11-10
Thickness tested	1.6 / *	mm	-
Glow Wire Flammability Index (GWFI)	650	°C	IEC 60695-2-12
GWFI - thickness tested (1)	1.6	mm	-

Electrical properties	dry / cond	Unit	Test Standard
ISO Data			
Volume resistivity	1E11 / 1E8	Ohm*m	IEC 62631-3-1
Surface resistivity	* / 1E10	Ohm	IEC 62631-3-2
Comparative tracking index	600 / -	-	IEC 60112

Other properties	dry / cond	Unit	Test Standard
Water absorption	7.4 / *	%	Sim. to ISO 62
Density	1310 / -	kg/m ³	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

Applications

Automotive

Delivery form

Natural Color

Regional Availability

Europe, Asia Pacific