

**AKROMID® A28 GF 15 1 natural (4382)**

PA66-GF15

Akro-Plastic GmbH

<b>Processing/Physical Characteristics</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Melt volume-flow rate, MVR	<b>68</b>	cm <sup>3</sup> /10min	ISO 1133
Temperature	<b>275</b>	°C	-
Load	<b>5</b>	kg	-
Molding shrinkage, parallel	<b>0.4</b>	%	ISO 294-4, 2577
Molding shrinkage, normal	<b>1.4</b>	%	ISO 294-4, 2577

<b>Mechanical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Tensile Modulus	<b>6000</b>	MPa	ISO 527
Stress at break	<b>130</b>	MPa	ISO 527
Strain at break	<b>2.5</b>	%	ISO 527
Charpy impact strength, +23°C	<b>40</b>	kJ/m <sup>2</sup>	ISO 179/1eU

<b>Thermal properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Melting temperature, 10°C/min	<b>262</b>	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	<b>245</b>	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	<b>260</b>	°C	ISO 75-1/-2
Burning behav. at 1.5 mm nom. thickn.	<b>HB</b>	class	IEC 60695-11-10
Thickness tested	<b>1.6</b>	mm	-
Glow Wire Flammability Index (GWFI)	<b>650</b>	°C	IEC 60695-2-12
GWFI - thickness tested (1)	<b>1.6</b>	mm	-

<b>Electrical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Volume resistivity	<b>1E10</b>	Ohm*m	IEC 62631-3-1
Comparative tracking index	<b>600</b>	-	IEC 60112

<b>Other properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Density	<b>1240</b>	kg/m <sup>3</sup>	ISO 1183

<b>Processing Recommendation Injection Molding</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Melt temperature	<b>320</b>	°C	-
Mold temperature	<b>100</b>	°C	-
Injection pressure	<b>75</b>	MPa	-

**Characteristics**

**Processing**  
Injection Molding

**Applications**  
Automotive

**Delivery form**  
Natural Color

**Regional Availability**  
Europe, Asia Pacific

**Special Characteristics**  
Heat stabilized or stable to heat