

**AKROMID® B3 GF 25 1 black (2484)**

PA6-GF25

Akro-Plastic GmbH

<b>Processing/Physical Characteristics</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Molding shrinkage, parallel	<b>0.2 / *</b>	%	ISO 294-4, 2577
Molding shrinkage, normal	<b>0.8 / *</b>	%	ISO 294-4, 2577
<b>Mechanical properties</b>			
<b>ISO Data</b>			
Tensile Modulus	<b>8500 / 5100</b>	MPa	ISO 527
Stress at break	<b>160 / 100</b>	MPa	ISO 527
Strain at break	<b>3.5 / 6.5</b>	%	ISO 527
Flexural modulus, 23°C	<b>7000 / -</b>	MPa	ISO 178
Flexural strength	<b>245 / -</b>	MPa	ISO 178
Charpy impact strength, +23°C	<b>85 / 90</b>	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength, -30°C	<b>80 / -</b>	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	<b>12 / 16</b>	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	<b>10 / -</b>	kJ/m <sup>2</sup>	ISO 179/1eA
Ball indentation hardness	<b>215 / -</b>	MPa	ISO 2039-1
<b>Thermal properties</b>			
<b>ISO Data</b>			
Melting temperature, 10°C/min	<b>220 / *</b>	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	<b>210 / *</b>	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	<b>220 / *</b>	°C	ISO 75-1/-2
Burning behav. at thickness h	<b>HB / *</b>	class	IEC 60695-11-10
Thickness tested	<b>0.8 / *</b>	mm	-
Yellow Card available	<b>yes / *</b>	-	-
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>ISO Data</b>			
Volume resistivity	<b>1E11 / 1E8</b>	Ohm*m	IEC 62631-3-1
Surface resistivity	<b>* / 1E10</b>	Ohm	IEC 62631-3-2
Comparative tracking index	<b>600 / -</b>	-	IEC 60112
<b>Other properties</b>			
Water absorption	<b>7.4 / *</b>	%	Sim. to ISO 62
Density	<b>1310 / -</b>	kg/m <sup>3</sup>	ISO 1183
<b>Processing Recommendation Injection Molding</b>			
Melt temperature	<b>270</b>	°C	-
Mold temperature	<b>80</b>	°C	-
Injection pressure	<b>75</b>	MPa	-

**Characteristics**

**Processing**  
Injection Molding

**Applications**  
Automotive

**Delivery form**  
Black

**Regional Availability**  
Europe, Asia Pacific

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