

## Datasheet

### Description:

AKROMID® B3 GF 25 1 L black (4637) is a 25% glass fibre reinforced and heat stabilised polyamide-blend with a reduced density compared to standard PA6 GF 25

### Applications

Applications are mainly technical components in the automotive and electronic industry, where a weight and cost reduction is required

Typical values	Test specification	Method	Unit	Value	
				d.a.m.	moist.*

### Mechanical Properties

Tensile modulus	1 mm/min	ISO 527-2	MPa	7500	5600
Stress at break	5 mm/min	ISO 527-2	MPa	135	88
Strain at break	5 mm/min	ISO 527-2	%	3,3	4,5
Charpy impact strength	23°C	ISO 179-1/1eU	kJ/m <sup>2</sup>	68	58
Charpy impact strength	-30°C	ISO 179-1/1eU	kJ/m <sup>2</sup>	67	54
Charpy notched impact strength	23°C	ISO 179-1/1eA	kJ/m <sup>2</sup>	15	15
Charpy notched impact strength	-30°C	ISO 179-1/1eA	kJ/m <sup>2</sup>	13	10

### Thermal Properties

Melting temperature	DSC, 10K/min	DIN EN 11357-1	°C	220	
Temp. of deflection under load HDT/A	1,8 MPa	ISO 75	°C	198	
Temp. of deflection under load HDT/B	0,45 MPa	ISO 75	°C	217	

### Flammability

Flammability	0,8 mm	UL 94	class	HB	
Burning rate (< 100 mm/min)	> 1 mm thickness	FMVSS 302		+	
GWFI	0,8 mm	IEC 60695-2-12	°C	750	
GWFI	3,2 mm	IEC 60695-2-12	°C	750	
GWIT	0,8 mm	IEC 60695-2-13	°C	775	
GWIT	3,2 mm	IEC 60695-2-13	°C	775	

### General Properties

Density	23°C	ISO 1183	g/cm <sup>3</sup>	1,22	
Content reinforcement/Content Filler		ISO 1172	%	25	
Humidity absorption	70°C, 62% r.h.	ISO 1110	%	1,5	

### Rheological Properties

MVR	275/5	ISO 1133	cm <sup>3</sup> /10min	10	
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### Processing

Flowability	Spiral flow**	AKRO	mm	860	
Molding shrinkage	flow	ISO 294-4	%	0,3	
Molding shrinkage	transverse	ISO 294-4	%	0,8	

\* = specimen acc. ISO 1110 stored

\*\* = mould temperature: 80°C, melt temperature: 270°C, injection pressure: 750 bar, cross section of flow spiral: 7 mm x 3,5 mm