

PA6 – Polyamide 6 PA6 GF 25 FR

**AKROMID® B3 GF 25 FRT black (7148)**

Tensile modulus

**9700 MPa**

1 mm/min

ISO 527-2

Stress at break

**135 MPa**

5 mm/min

ISO 527-2

Charpy impact strength

**65 kJ/m<sup>2</sup>**

23°C

ISO 179-1/1eU

AKROMID® B3 GF 25 FRT black (7148) is a 25% glass fibre reinforced, halogenfree flame retardant polyamide 6 with high stiffness and strength.

**Typical applications**

Special applications in the railway sector, e.g. Armrests, removable headrests or small-volume non-listed components

**Mechanical Properties**

Tensile modulus (1 mm/min | ISO 527-2)

d.a.m.

9700 MPa

conditioned

5500 MPa

Stress at break (5 mm/min | ISO 527-2)

d.a.m.

135 MPa

conditioned

90 MPa

Strain at break (5 mm/min | ISO 527-2)

d.a.m.

2,6 %

conditioned

7 %

Charpy impact strength (23°C | ISO 179-1/1eU)

d.a.m.

65 kJ/m<sup>2</sup>**Thermal Properties**

Melt temperature (DSC, 10K/min | DIN EN 11357-1)

222 °C

**Flammability**

Burning rate (UL 94)

0,8mm Wall thickness

V-1 Class

1,6mm Wall thickness

V-0 Class

3,2mm Wall thickness

V-0 Class

GWFI (IEC 60695-2-12)

0,8mm Wall thickness

960 °C

1,6mm Wall thickness

960 °C

3,2mm Wall thickness

960 °C

Oxygen index (ISO 4589-2)

&gt;32 %

Burning rate (&lt;100 mm/min) (&gt; 1 mm Thickness | FMVSS 302)

+

Protection Train (EN 45545-2)

R21/23/24 HL3 R22 HL2

**General properties**

Density (23°C | ISO 1183)

1,39 g/cm<sup>3</sup>

Molding shrinkage (flow | ISO 294-4)

0,2-0,4 %

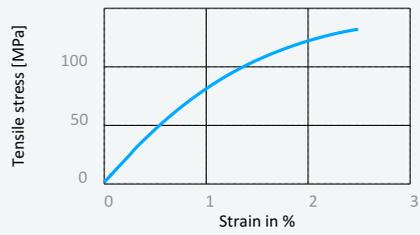
Molding shrinkage (transverse | ISO 294-4)

0,6-0,8 %

**Disclaimer:**

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Stress strain chart at 23°C



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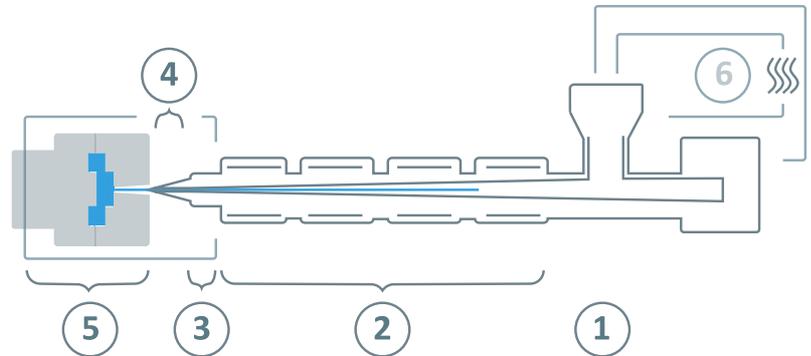
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### Processing information

The listed values are recommendations. Higher values should be used for higher glass loadings. We recommend only dehumidifying or vacuum dryers. Extensive drying can cause filling problems and surface defects.



⑥	Drying time	2 - 4 h
	Drying temperature ( $\tau \leq -30^\circ\text{C}$ )	80°C
	Processing moisture	0,02 - 0,08%
①	Feed section	60 - 80°C
②	Temperature zone 1 - Zone 4	220 - 280°C
③	Nozzle temperature	240 - 280°C
④	Melt temperature	240 - 280°C
⑤	Mold temperature	60 - 100°C
→	Holding pressure, spec.	300 - 800 bar
←	Back pressure, spec.	30 - 100 bar
	Injection speed	medium
	Screw speed	5 - 10 m/min

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