

PA6 – Polyamide 6 PA-Blend

## AKROMID® C28 GF 25 FRT natural (7332)

Tensile modulus

### 10800 MPa

1 mm/min

ISO 527-2

Stress at break

### 157 MPa

5 mm/min

ISO 527-2

Charpy impact strength

### 64 kJ/m<sup>2</sup>

23°C

ISO 179-1/1eU

C28 GF 25 FRT natural (7332) is a 25% glass fiber reinforced, halogen-free flame retardant and easy flowing polyamide blend with a light inherent color

### Typical applications

Public-Transportation, especially train seats



### Mechanical Properties

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

d.a.m.

10800 MPa

conditioned

11000 MPa

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

d.a.m.

157 MPa

conditioned

152 MPa

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

d.a.m.

2,6 %

conditioned

2,7 %

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

d.a.m.

64 kJ/m<sup>2</sup>

### Thermal Properties

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

238 °C

Coefficient of linear thermal expansion, parallel  
(23°C bis 80°C | ISO 11359-1/2)

0,2 1,0E-4/K

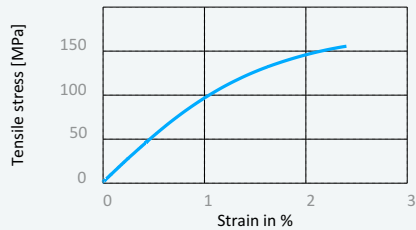
Coefficient of linear thermal expansion, transverse  
(23°C bis 80°C | ISO 11359-1/2)

0,66 1,0E-4/K

#### Disclaimer:

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Stress strain chart at 23°C



**Flammability**

Burning rate (UL 94)	
0,4mm Wall thickness	V-0 Class
0,8mm Wall thickness	V-0 Class
1,6mm Wall thickness	V-0 Class
3,2mm Wall thickness	V-0 Class

Burning rate 5V (UL 94)	
1,6mm Wall thickness	5VA Class
3,2mm Wall thickness	5VA Class

GWFI (IEC 60695-2-12)	
0,4mm Wall thickness	960 °C
0,8mm Wall thickness	960 °C
1,6mm Wall thickness	960 °C
3,2mm Wall thickness	960 °C

GWIT (IEC 60695-2-13)	
0,4mm Wall thickness	825 °C
0,8mm Wall thickness	800 °C
1,6mm Wall thickness	800 °C
3,2mm Wall thickness	850 °C

Burning rate (<100 mm/min) (> 1 mm Thickness | FMVSS 302) +

Protection Train (EN 45545-2) R1/6/7 HL2



**General properties**

Density (23°C | ISO 1183) 1,43 g/cm<sup>3</sup>

Humidity absorption (70°C, 62% r.H. | ISO 1110) 0,9-1,1 %

Molding shrinkage (flow | ISO 294-4) 0,3-0,5 %

Molding shrinkage (transverse | ISO 294-4) 0,5-0,7 %



**Electrical Properties**

Comparative tracking index (Test liquid A | IEC 60112) >600 V

**Disclaimer:**

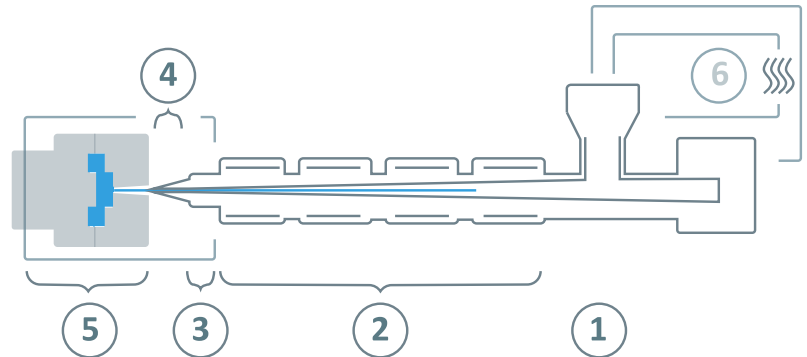
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### Processing information

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	4 - 12 h
	Drying temperature ( $\tau \leq -30^\circ\text{C}$ )	80 - 90°C
	Processing moisture	0,02 - 0,1%
①	Feed section	60 - 80°C
②	Temperature zone 1 - Zone 4	250 - 300°C
③	Nozzle temperature	270 - 300°C
④	Melt temperature	270 - 300°C
⑤	Mold temperature	120 - 160°C
→	Holding pressure, spec.	300 - 1500 bar
←	Back pressure, spec.	50 - 150 bar
	Injection speed	high
	Screw speed	8 - 10 m/min

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