

PARA – Polyamide PARA GF 35 FR (40)

AKROLOY® PARA GF 35 FR black (7496)

Tensile modulus

14600 MPa

1 mm/min
ISO 527-2

Stress at break

200 MPa

5 mm/min
ISO 527-2

Charpy impact strength

55 kJ/m²

23°C
ISO 179-1/1eU

AKROLOY PARA GF 35 FR black (7496) is a flame-retarded, 35% glass-fiber reinforced Polyarylamide with very high flow, highest modulus and strength and low

creep. Small water-absorption and very small change of properties due to water-absorption.

Typical applications

Components in Electrical Industry which need low creep even in conditioned state.



Mechanical Properties

Tensile modulus (1 mm/min ISO 527-2) d.a.m.	14600 MPa
Stress at break (5 mm/min ISO 527-2) d.a.m.	200 MPa
Strain at break (5 mm/min ISO 527-2) d.a.m.	2,2 %
Charpy impact strength (23°C ISO 179-1/1eU) d.a.m.	55 kJ/m ²
Charpy notched impact strength (23°C ISO 179-1/1eA) d.a.m.	13 kJ/m ²



Thermal Properties

Temperature of deflection under load HDT/A (1,8 MPa ISO 75)	230 °C
Melt temperature (DSC, 10K/min DIN EN 11357-1)	235 °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
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	825 °C



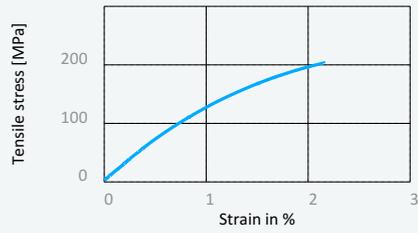
General properties

Density (23°C ISO 1183)	1,48 g/cm ³
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Disclaimer:

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Stress strain chart at 23°C



Electrical Properties

Comparative tracking index (Test liquid A | IEC 60112)

> 600 V

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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.

Drying time	4 - 12 h
Drying temperature ($\tau \leq -30^{\circ}\text{C}$)	80 - 90°C
Processing moisture	0,02 - 0,1%
Feed section	60 - 80°C
Temperature zone 1 - Zone 4	250 - 300°C
Nozzle temperature	270 - 300°C
Melt temperature	270 - 300°C
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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