

PA6 – Polyamide 6 PA6 GF 25 FR(40)

AKROMID® C28 GF 25 FRG natural (7566)

Tensile modulus

9300 MPa

1 mm/min

ISO 527-2

Stress at break

135 MPa

5 mm/min

ISO 527-2

Charpy impact strength

n.b. kJ/m²

23°C

ISO 179-1/1eU

AKROMID C28 GF 25 FRG is a halogenfree flame retardant, 25 % glass fiber reinforced PA6 with easy flowing and improved performance at glow wire test.

Typical applications

Components in the electric industry

**Mechanical Properties**Tensile modulus (1 mm/min | ISO 527-2)
d.a.m.

9300 MPa

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

d.a.m.

135 MPa

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

d.a.m.

3,0 %

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

d.a.m.

n.b. kJ/m²**Thermal Properties**

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

222 °C

**Flammability**

Burning rate (UL 94)

0,8mm Wall thickness

1,6mm Wall thickness

3,2mm Wall thickness

V-0 Class

V-0 Class

V-0 Class

GWFI (IEC 60695-2-12)

0,4mm Wall thickness

0,8mm Wall thickness

1,6mm Wall thickness

3,2mm Wall thickness

960 °C

960 °C

960 °C

960 °C

GWIT (IEC 60695-2-13)

0,4mm Wall thickness

0,8mm Wall thickness

1,6mm Wall thickness

3,2mm Wall thickness

800 °C

800 °C

800 °C

800 °C

**General properties**

Density (23°C | ISO 1183)

1,35 g/cm³

Molding shrinkage (flow | ISO 294-4)

0,1-0,3 %

Molding shrinkage (transverse | ISO 294-4)

0,5-0,7 %

Disclaimer:

All specifications and information given on this website are based on our current knowledge and experience. A legally binding promise of certain characteristics or suitability for a concrete individual case cannot be derived from this information. The information supplied here is not intended to release processors and users from the responsibility of carrying out their own tests and inspections in each concrete individual case. AKRO®, AKROMID®, AKROLEN®, AKROLOY®, AKROTEK®, ICX® and PRECITE® are registered trademarks of the Feddersen Group.



Rheological Properties

Flowability (1mm Thickness | AKRO)

140 mm

Flowability (2mm Thickness | AKRO)

420 mm

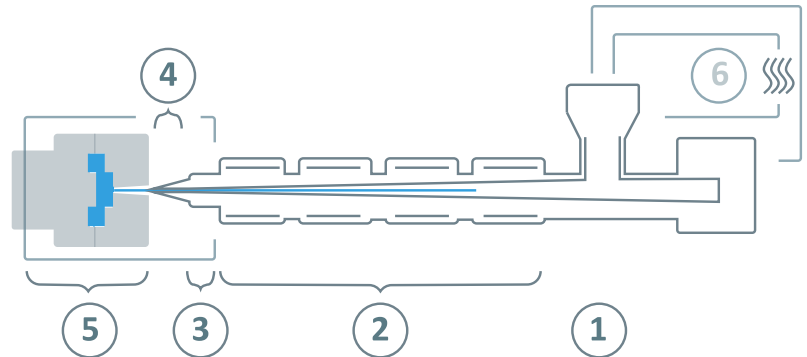
Disclaimer:

All specifications and information given on this website are based on our current knowledge and experience. A legally binding promise of certain characteristics or suitability for a concrete individual case cannot be derived from this information. The information supplied here is not intended to release processors and users from the responsibility of carrying out their own tests and inspections in each concrete individual case. AKRO®, AKROMID®, AKROLEN®, AKROLOY®, AKROTEK®, ICX® and PRECITE® are registered trademarks of the Feddersen Group.

PA6 – Polyamide 6 PA6 GF 25 FR(40)

AKROMID® C28 GF 25 FRG natural (7566)**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

Disclaimer:

All specifications and information given on this website are based on our current knowledge and experience. A legally binding promise of certain characteristics or suitability for a concrete individual case cannot be derived from this information. The information supplied here is not intended to release processors and users from the responsibility of carrying out their own tests and inspections in each concrete individual case. AKRO®, AKROMID®, AKROLEN®, AKROLOY®, AKROTEK®, ICX® and PRECITE® are registered trademarks of the Feddersen Group.