

PA6 – Polyamide 6 PA6 GF25

AKROMID® B28 GF 25 9 natural (6360)

Tensile modulus

8000 MPa

1 mm/min

ISO 527-2

Stress at break

168 MPa

5 mm/min

ISO 527-2

Charpy impact strength

23°C

ISO 179-1/1eU

AKROMID® B28 GF 25 9 natural (6360) is a 25% glass fibre reinforced, processing optimised polyamide 6 with high rigidity and strength and light inherent color.

Typical applications

Exclusive product



Mechanical Properties

Tensile modulus (1 mm/min | ISO 527-2)
d.a.m. 8000 MPa

Stress at break (5 mm/min | ISO 527-2)
d.a.m. 168 MPa

Strain at break (5 mm/min | ISO 527-2)
d.a.m. 3,4 %



Thermal Properties

Melting temperature (DSC, 10K/min | DIN EN ISO 11357-3) 220 °C



Flammability

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

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

Protection Bus (ECE 118) Appendix 6, 7, 8



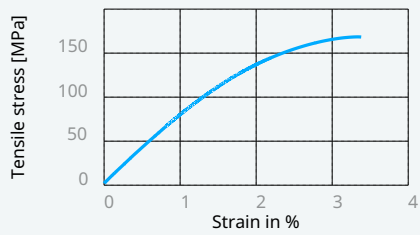
General properties

Density (23°C | ISO 1183) 1,3 g/cm³

Disclaimer:

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Stress strain chart at 23°C

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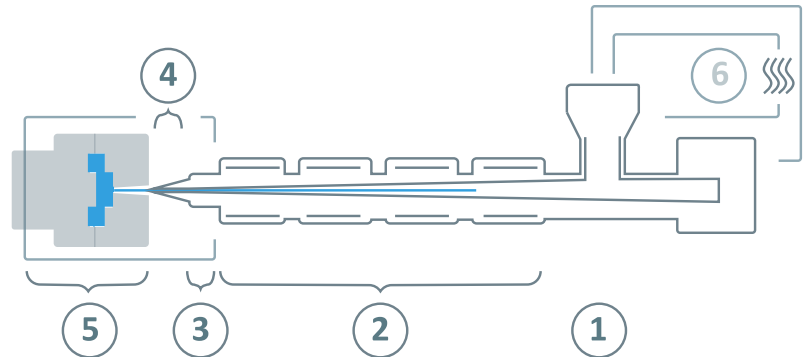
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Processing information

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	0 - 4 h
	Drying temperature ($\tau \leq -30^{\circ}\text{C}$)	80°C
	Processing moisture	0,02 - 0,1%
①	Feed section	60 - 80°C
②	Temperature zone 1 - Zone 4	240 - 290°C
③	Nozzle temperature	260 - 300°C
④	Melt temperature	270 - 290°C
⑤	Mold temperature	80 - 100°C
→	Holding pressure, spec.	300 - 800 bar
←	Back pressure, spec.	50 - 150 bar
	Injection speed	medium to high
	Screw speed	8 - 15 m/min

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