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AKROMID®
C28 GF 25 FRT grey (7530)

PA-Blend

AKROMID® C28 GF 25 FRT grey (7530) is a 25 % glass fiber reinforced, flame retardant and easy flowing PA blend, colored in grey similar to RAL Design 000 65 00. The material is based on a flame retardant system that is free of red phosphorus and halogens. This grade is suitable for railroad applications and certified to EN 45545-2 R6 and EN 45545-2 R1. To achieve an excellent surface quality a mould temperature of at least 120°C is necessary.

Features

flame retardant | surface modified | easy flow | public transportation

Regulatory

EN45545-2

Properties

Modulus	Strength	Impact
11.000 MPa	**135** MPa	**Na**

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min | d.a.m.	**11000 MPa**
Tensile stress at break ISO 527-2	5 mm/min | d.a.m.	**135 MPa**
Tensile strain at break ISO 527-2	5 mm/min | d.a.m.	**2,1 %**

Flammability

Flammability UL 94	0,4 mm Wall thickness	**V-0 Class**
	0,8 mm Wall thickness	**V-0 Class**
	1,6 mm Wall thickness	**V-0 Class**
	3,2 mm Wall thickness	**V-0 Class**

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GWFI IEC 60695-2-12	0,4 mm Wall thickness	**960 °C**
	0,8 mm Wall thickness	**960 °C**
	1,6 mm Wall thickness	**960 °C**
	3,2 mm Wall thickness	**960 °C**
Protection Train EN 45545-2		**R1/6/7 HL2**

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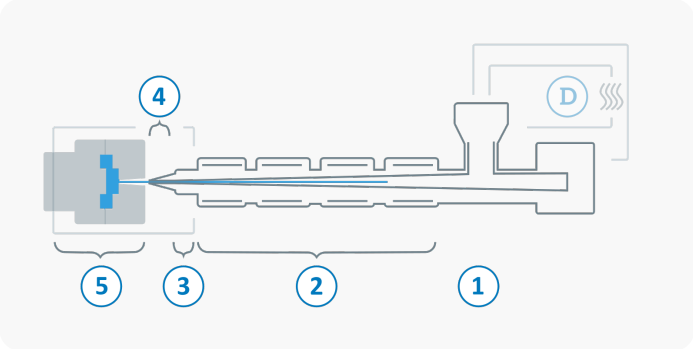
Processing

The values mentioned are recommendations. We only recommend desiccant / dry air dryers or vacuum dryers. Too long a drying time and the resulting residual moisture content below the lower limit can lead to filling problems and surface defects. The specified drying time refers to closed and undamaged bagged material. When processing from previously opened bags or from octabins with polyolefin inliners, a longer drying time may be necessary. It is recommended to check the residual moisture content after the drying process.



D	Drying time	4 - 12 h
	Drying temperature (τ <= -30°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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Diagrams