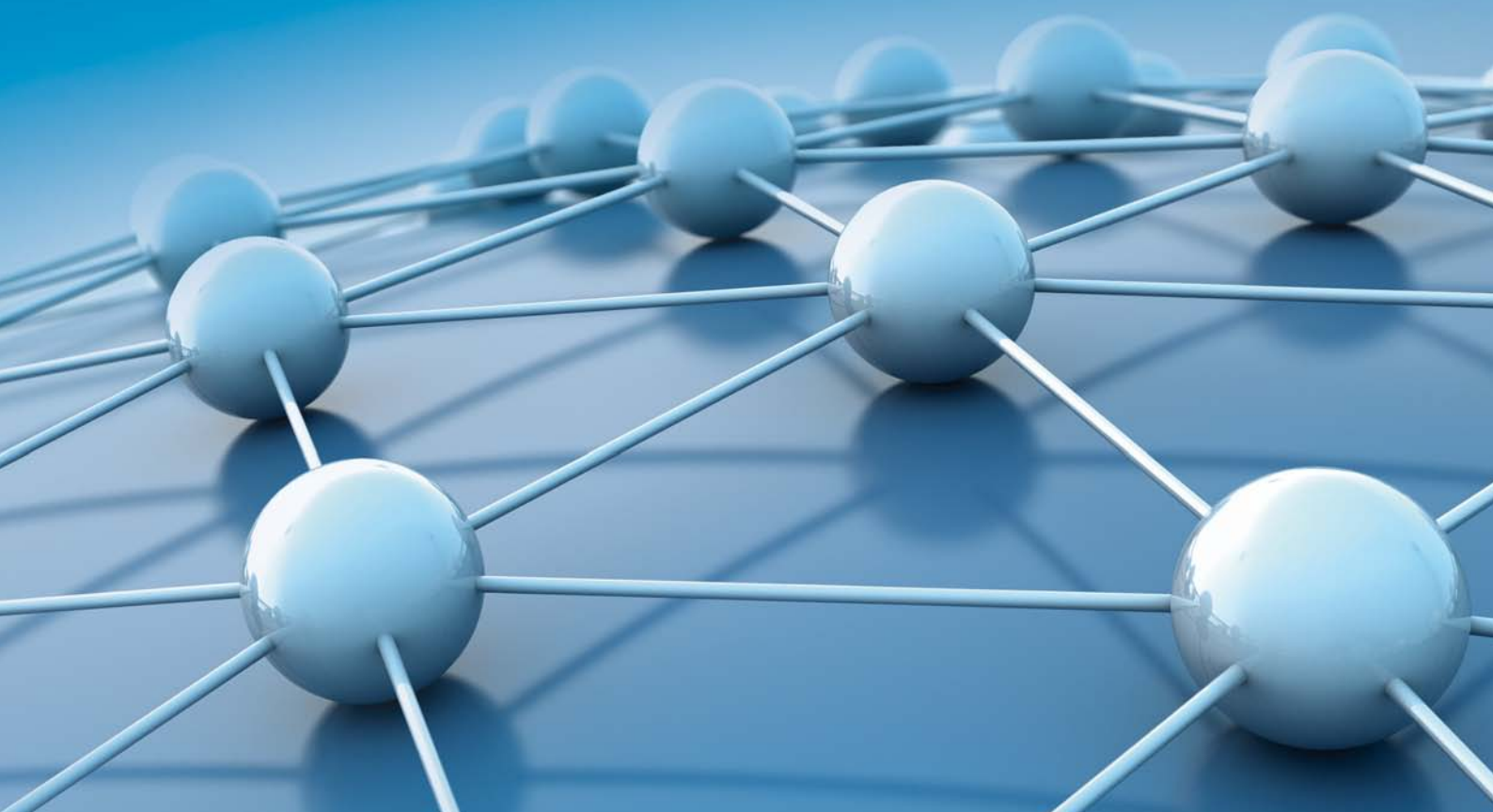


PRODUCT INFORMATION BASIC PROGRAM

AKROMID® A (PA 6.6)

AKROMID® B (PA 6)

AKROMID® C (PA 6.6/PA 6 Blend)



AKRO-PLASTIC 
Think Polyamide

AKRO-PLASTIC GmbH
Member of the Feddersen Group

Dear AKRO-PLASTIC customers,

with our brochure AKROMID® Basic Program we would like to give you a compact overview of our range of products AKROMID® A, B and C and associated application information. Since this information represents only partial aspects of our production possibilities and special demands are often made on compounds, you should always consult our application engineering department for questions or individual needs. Our engineers are able to offer competent advice on specific subjects, questions and problem solutions.

At AKRO-PLASTIC GmbH, we see ourselves not only as a producer, but also as a service provider. We constantly refine existing successful products, continually adapting them to the growing demands of the market. We set new standards with our certified quality management and our inhouse accredited test lab. In this endeavour, you the customer are an important interface. It is your needs, questions and demands that drive our efforts to continue this successful development.

And this joint effort should continue into the future.

AKROMID® A3 (PA 6.6)

Typical values for natural color material at 23 °C	Test Specification	Test Method	Unit	A3 ¹ (2414)	A3 GF 15 (2418)	A3 GF 25 (2420)	A3 GF 30 (2397)	A3 GF 35 (2421)	A3 GF 40 (1258)	A3 GF 50 (2423)	A3 GF 60 (2424)	A 28 GF 30 1 GIT (4619)	A3 GM 20/10 4 WIT (4529)										
				d.a.m.	cond.	d.a.m.	cond.	d.a.m.	cond.	d.a.m.	cond.	d.a.m.	cond.										
Mechanical Properties																							
Tensile modulus	1 mm/min	ISO 527-1/2	MPa	3,200	1,100	6,400	3,700	8,500	6,000	10,000	7,100	11,600	8,400	13,100	9,800	16,700	12,600	20,500	15,800	9,200		8,200	
Yield stress ¹ /Tensile stress at break	5 mm/min	ISO 527-1/2	MPa	85/	50/	/140	/80	/185	/115	/200	/130	/215	/145	/225	/160	/250	/180	/260	/190	190		175	
Elongation at break	5 mm/min	ISO 527-1/2	%	>20	>50	3.5	12	3.6	6.5	3	5.5	3	5	3	4	2.5	3.5	2	2.5	3.5		3.7	
Flexural modulus	2 mm/min	ISO 178	MPa	2,800		6,100		7,600	6,200	8,800	7,200	10,000	8,000	12,000		15,200	13,600	19,800				7,600	
Flexural stress	2 mm/min	ISO 178	MPa	110		200		260	200	285	220	300	245	360		380	310	400				260	
Charpy impact strength	23 °C	ISO 179-1/1eU	kJ/m ²	n.b.	n.b.	45	88	70	90	85	95	92	102	100	105	105	110	102	105			65	
Charpy impact strength	-30 °C	ISO 179-1/1eU	kJ/m ²	n.b.		43		64		80		90		95		105		97				50	
Charpy notched impact strength	23 °C	ISO 179-1/1eA	kJ/m ²	3	13	7	8	10	13	12	16	15	19	17	20	19	23	19	22			9	
Charpy notched impact strength	-30 °C	ISO 179-1/1eA	kJ/m ²	2		6		9		11		13		15		16		19				7	
Ball indentation hardness	HB 961/30	ISO 2039-1	MPa			200		225		240		255		270		290		330					
Electrical Properties																							
Volume resistivity		IEC 60093	Ohm x cm	10 ¹³	10 ¹⁰	10 ¹³	10 ¹⁰	10 ¹³	10 ¹⁰	10 ¹³	10 ¹⁰	10 ¹³	10 ¹⁰	10 ¹³	10 ¹⁰	10 ¹³	10 ¹⁰	10 ¹³	10 ¹⁰	10 ¹³	10 ¹⁰	10 ¹³	10 ¹⁰
Surface resistivity		IEC 60093	Ohm	10 ¹³	10 ¹⁰	10 ¹²	10 ¹⁰	10 ¹²	10 ¹⁰	10 ¹²	10 ¹⁰	10 ¹²	10 ¹⁰	10 ¹²	10 ¹⁰	10 ¹²	10 ¹⁰	10 ¹²	10 ¹⁰	10 ¹²	10 ¹⁰	10 ¹²	10 ¹⁰
Comparative tracking index, CTI	Test solution A	IEC 60112		600		600		600		600		600		600		600		600					
Thermal Properties				d.a.m.	d.a.m.	d.a.m.	d.a.m.	d.a.m.	d.a.m.	d.a.m.	d.a.m.	d.a.m.	d.a.m.										
Melting point	DSC, 10 K/min	ISO 11357-1/3	°C	262		262		262		262		262		262		262		262		255		262	
Heat distortion temperature, HDT/A	1.8 MPa	ISO 75-2	°C	75		245		255		255		255		260		260		260				240	
Heat distortion temperature, HDT/B	0.45 MPa	ISO 75-2	°C	215		260		260		260		260		260		260		260				260	
Heat distortion temperature, HDT/C	8 MPa	ISO 75-2	°C					210		220		225		235		235		235					
CLTE, flow	23°C - 80°C	ISO 11359-1/2	10 ⁻⁴ /K	0.71		0.34				0.19						0.17							
CLTE, transverse	23°C - 80°C	ISO 11359-1/2	10 ⁻⁴ /K	1.1		1.11				0.95						0.88							
Temp.index for 50% loss of tens.strength ²	5,000 h	IEC 216	°C	115 - 145		160 - 175		160 - 175		160 - 175		160 - 175		160 - 175		160 - 175		160 - 175					
Temp.index for 50% loss of tens.strength ²	20,000 h	IEC 216	°C	100 - 120		130 - 150		130 - 150		130 - 150		130 - 150		130 - 150		130 - 150		130 - 150					
Flammability																							
Flammability acc.UL 94	1.6 mm	UL 94	Class	V - 2		HB		HB		HB		HB		HB		HB		HB		HB		HB	
Rate acc. FMVSS 302 (<100 mm/min)	>1 mm thickness	FMVSS 302	mm/min	+		+		+		+		+		+		+		+		+		+	
GWFI	1.6 mm	IEC 60695-12	°C	750		650		650		650		650		650		650		650					
General Properties																							
Density	23 °C	ISO 1183	g/cm ³	1.14		1.24		1.32		1.36		1.40		1.46		1.57		1.71		1.36		1.36	
Content minerals/reinforcement		ISO 1172	%	-		15		25		30		35		40		50		60		30		30	
Moisture absorption	70 °C/62 % r. h.	ISO 1110	%	2.9 - 3.1		2.5 - 2.7		2.0 - 2.2		1.9 - 2.1		1.8 - 2.0		1.7 - 1.9		1.3 - 1.5		1.0 - 1.2					
Water absorption	23 °C/satur.	ISO 62	%	8.0 - 9.0		6.7 - 7.3		5.7 - 6.3		5.2 - 5.8		4.7 - 5.3		4.3 - 4.7		3.7 - 4.3		3.2 - 3.7					
Processing																							
Flowability	Flowspiral ³	AKRO	mm	1,040		990		890		830		770		720		600		530					
Processing shrinkage, flow		ISO 294-4	%	1.9		0.4		0.2		0.2		0.2		0.2		0.3		0.4				0.4	
Processing shrinkage, transverse		ISO 294-4	%	2.3		1.4		1.3		1.3		1.3		1.2		1.2		0.8				0.8	

Despite identical nomenclature the AKROMID® materials produced by AKRO in China are identified by differential batch numbering.

Test values „cond.“ = conditioned, have been determined on test specimens stored according to ISO 1110.
Test values „dry“ = residual moisture < 0.1 %
n.b. = not broken + = passed

¹ = yield stress and elongation at break: test speed 50 mm/min for non-reinforced compounds
² = depending on selected stabilization, see application examples
³ = mould temperature: 100 °C, melt temperature: 320 °C, injection pressure: 750 bar, cross section of flow spiral: 7 mm x 3.5 mm

AKROMID® B3 (PA 6)

Unit	B3 ¹ (2500)		B3 GF 15 (2469)		B3 GF 20 (2470)		B3 GF 25 (2471)		B3 GF 30 (2472)		B3 GF 35 (2473)		B3 GF 40 (2474)		B3 GF 50 (2475)		B3 GF 60 (2476)		B3 GF 30 2 GIT (4618)	
	d.a.m.	cond.	d.a.m.	cond.	d.a.m.	cond.	d.a.m.	cond.	d.a.m.	cond.	d.a.m.	cond.	d.a.m.	cond.	d.a.m.	cond.	d.a.m.	cond.	d.a.m.	cond.
MPa	3,600	1,200	6,100	3,300	6,800	4,200	8,500	5,100	10,300	6,200	11,500	7,300	12,800	8,200	17,000	10,300	21,000	15,500	9,100	5,500
MPa	85/	45/	/120	/75	/150	/85	/160	/100	/185	/110	/195	/120	/205	/130	/230	/145	/240	/150	175	110
%	>20	>50	3	9.5	3.5	7.5	3.5	6.5	3	5.5	3	5	3	5	2.5	4.5	2.5	3.5	3	5
MPa	3,100		5,200		6,100		7,000		8,500		10,000		10,300		14,900		19,000			
MPa	120		180		230		245		270		285		300		340		370			
kJ/m ²	n.b.	n.b.	52	95	73	88	85	90	95	105	100	110	100	110	100	110	90	95	75	80
kJ/m ²	n.b.		43		65		80		85		90		90		90		88			
kJ/m ²	3	12	7	11	9	14	12	16	13	18	15	21	17	23	20	26	20	25	12	17
kJ/m ²	2		6		8		10		12		13		14		16		19			
MPa			180		200		215		230		240		250		270		290			
Ohm x cm	10 ¹³	10 ¹⁰	10 ¹³	10 ¹⁰	10 ¹³	10 ¹⁰	10 ¹³	10 ¹⁰	10 ¹³	10 ¹⁰	10 ¹³	10 ¹⁰	10 ¹³	10 ¹⁰	10 ¹³	10 ¹⁰	10 ¹³	10 ¹⁰	10 ¹³	10 ¹⁰
Ohm	10 ¹²	10 ¹⁰	10 ¹²	10 ¹⁰	10 ¹²	10 ¹⁰	10 ¹²	10 ¹⁰	10 ¹²	10 ¹⁰	10 ¹²	10 ¹⁰	10 ¹²	10 ¹⁰	10 ¹²	10 ¹⁰	10 ¹²	10 ¹⁰	10 ¹²	10 ¹⁰
	600		600		600		600		600		600		600		600		600		600	
	d.a.m.		d.a.m.		d.a.m.		d.a.m.		d.a.m.		d.a.m.		d.a.m.		d.a.m.		d.a.m.		d.a.m.	
°C	220		220		220		220		220		220		220		220		220		220	
°C	60		205		210		210		210		215		215		220		220		220	
°C	180		220		220		220		220		220		220		220		220		220	
°C									150		165		170		185		190			
10 ⁻⁴ /K									0,16						0.11					
10 ⁻⁴ /K									0,95						0.94					
°C	100 - 140		160 - 175		160 - 175		160 - 175		160 - 175		160 - 175		160 - 175		160 - 175		160 - 175		160 - 175	
°C	90 - 120		130 - 150		130 - 150		130 - 150		130 - 150		130 - 150		130 - 150		130 - 150		130 - 150		130 - 150	
Class	V - 2		HB		HB		HB		HB		HB		HB		HB		HB		HB	
mm/min	+		+		+		+		+		+		+		+		+		+	
°C	750		650		650		650		650		650		650		650		650		650	
g/cm ³	1.13		1.23		1.27		1.31		1.36		1.41		1.46		1.56		1.70		1.36	
%	-		15		20		25		30		35		40		50		60		30	
%	2.6 - 3.4		2.6 - 2.9		2.4 - 2.7		2.2 - 2.5		2.1 - 2.3		1.8 - 2.1		1.5 - 1.8		1.3 - 1.6		0.9 - 1.2		2.2	
%	9.0 - 10.0		7.7 - 8.3		7.4 - 7.7		6.8 - 7.4		6.3 - 6.9		5.9 - 6.5		5.2 - 5.7		4.5 - 5.1		3.9 - 4.4			
mm	1,070		870		800		720		660		610		540		430		350			
%	1.1		0.3		0.2		0.2		0.1		0.1		0.1		0.2		0.3			
%	1.0		0.7		0.8		0.8		0.8		0.8		0.9		0.9		0.7			

"cond." test values = conditioned, measured on test specimens stored according to ISO 1110
"d.a.m." = dry as moulded test values = residual moisture content < 0.10 %
n.b. = not broken + = passed

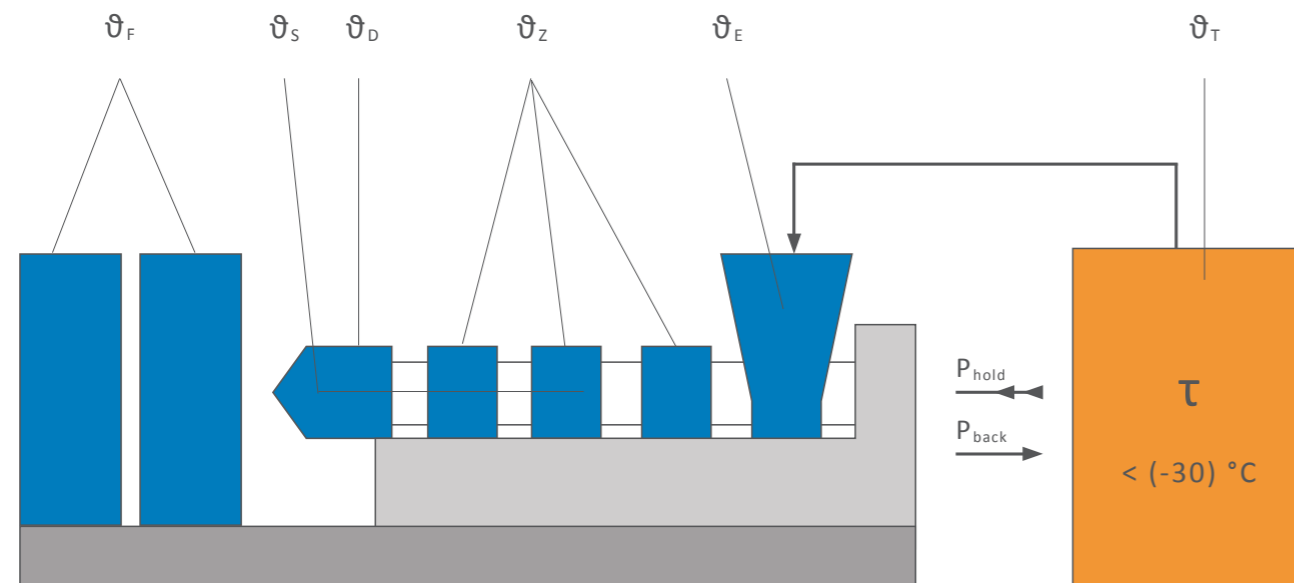
¹ = yield stress and elongation at break: test speed 50 mm/min for non-reinforced compounds
² = depending on selected stabilization, see application examples
³ = mould temperature: 80 °C, melt temperature: 270 °C, injection pressure: 750 bar, cross section of flow spiral: 7 mm x 3.5 mm

Processing/Applications

AKROMID® A, B and C can be processed on commercially available injection moulding machines with

standard screws according to the recommendations of the machine manufacturer. Please refer to the

tables below for our recommended machine, mould and dryer settings (see sketch):

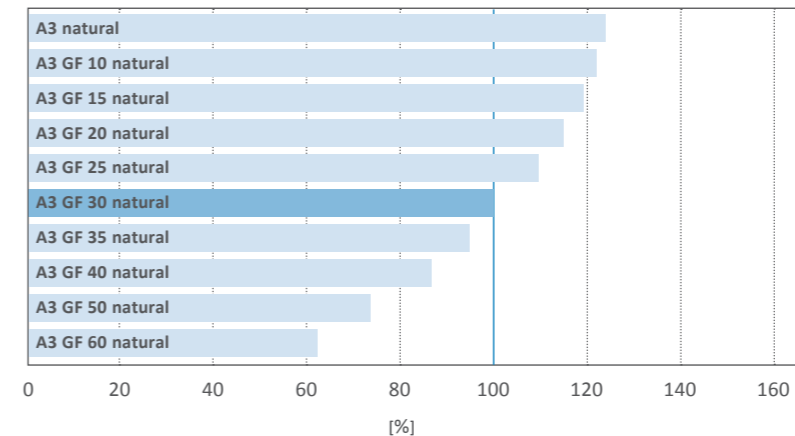


		AKROMID® A	AKROMID® B	AKROMID® C
Feed section	ϑ_E	60 - 80 °C	60 - 80 °C	60 - 80 °C
Sector 1 – Sector 4	ϑ_Z	260 - 300 °C	225 - 300 °C	225 - 300 °C
Nozzle	ϑ_D	280 - 295 °C	240 - 280 °C	280 - 295 °C
Melt temperature	ϑ_S	280 - 310 °C	260 - 300 °C	280 - 310 °C
Mould surface	ϑ_F	80 - 100 °C	80 - 100 °C	80 - 100 °C
Drying	ϑ_T	80 °C, 2 h	80 °C, 2 h	80 °C, 2 h
Holding pressure, spec.	P_{hold}	300 - 800 bar	300 - 800 bar	300 - 800 bar
Back pressure, spec.	P_{back}	50 - 100 bar	50 - 100 bar	50 - 100 bar

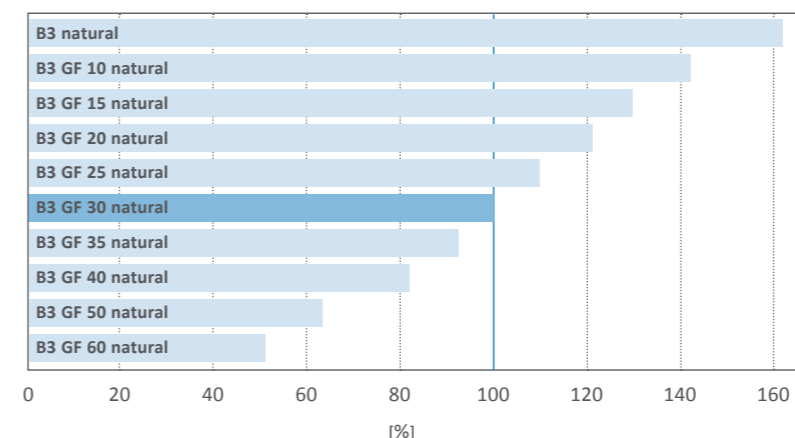
The specified values are for reference values. For increasing filling contents the higher values should be used. For drying, we recommend using only dry air or a vacuum dryer. Processing moisture levels between 0.02 and 0.1 % are recommended. The drying time of freshly-opened bags is up to 4 h. It is recommended to use opened bags completely. Material processed from silo or boxes requires a minimum drying time of 4 h.

Disclaimer: All specifications and information given in this brochure 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® and AKROTEK® are registered trademarks of the Feddersen Group.

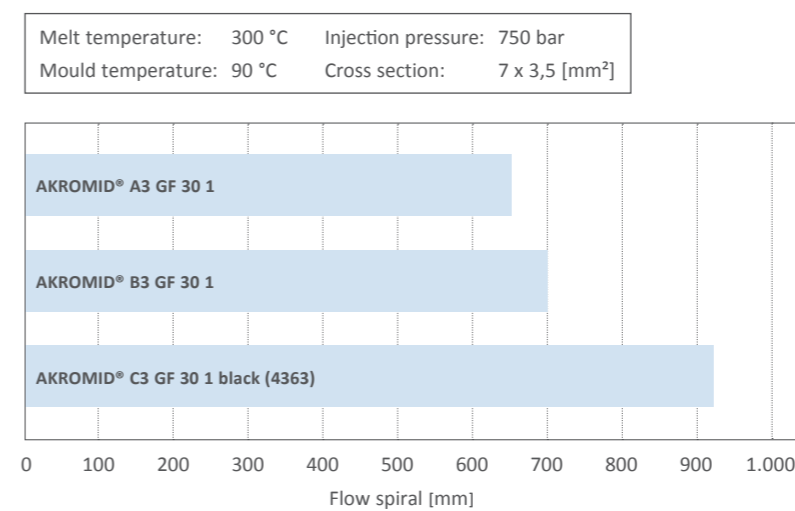
Flow length AKROMID® A



Flow length AKROMID® B

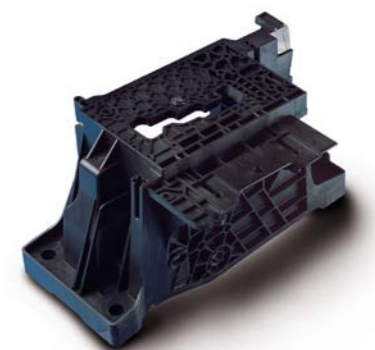


Comparison of AKROMID® C GF flow length



Taking account of the processing conditions listed here, AKROMID® A, B and C can be used to make a number of sophisticated engineering parts, depending on the achievable flow paths. Here are a few examples which show that different industries are already successfully using this material in their innovative products.

Due to their excellent surface quality, AKROMID® B compounds (PA 6) are choice materials in the sports and leisure sector. Since the temperature level for many automotive applications (shift gates, for instance) requires materials with a higher heat distortion temperature, PA 6.6-based AKROMID® A compounds have become well-established here, unless lower loads allow the use of other AKROMID® compounds.



Gear shift gate made from AKROMID® A3 GF 30 1*

* Thermal aging stabilization 1 (long term stability up to 130 °C)
Thermal aging stabilization 5 (long term stability up to 150 °C), subdued colours only



Lambda sensor holder made from AKROMID® B3 GF 30

Applications

In order to expand the range of possible applications with AKROMID® A, B and C to include specific production methods, materials have been developed which are specifically suited to fluid injection technology (FIT). This technology is used to manufacture components with relatively thick walls as well as components with hollow spaces. The fluid used can be either gas (GIT) or water (WIT). Materials designated as "WIT" are used when special attention is required for the formation of particularly high-quality surface finishes in the interior.

Thus components which are used in the engine cooling circuit of a number of different motor vehicles are made of our AKROMID® A3 GM 20/10 4 WIT black (4529). The advantages of this material lie in the extremely easy processability of our AKROMID®, which was optimised specifically for the water-injection process. The material is used in both the reverse-pressure mass process and the overflow cavity process.

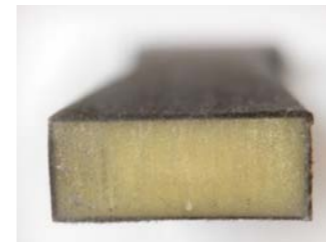
The most important step, irrespective of the selected method, remains the use of an appropriate design of the component and, of course, the material. We are happy to assist you in choosing a process and material suitable for your application. Because one thing is certain when dealing with custom processes: the process complexity increases. Our materials are produced within such narrow production tolerances that our AKROMID® WIT and GIT blends guarantee a stable process. But it isn't just the reproducibility which exceeds that of most of our competitors; so too does our process window. A sophisticated polymer technology enables us to lower the recrystallisation point of the GIT and WIT blends without negatively impacting the crystallinity. In the DSC curve shown here, the AKROMID® GIT variant demonstrates a nearly 15 K lower recrystallisation temperature with the same recrystallisation enthalpy (see Fig. 1).

The result of this modification is useful not only for gas-injection applications but also for standard injection-moulding applications. The illustrated component section shows the high surface quality which can be achieved with AKROMID® A3 GF 15 1 GIT black (4620).



Valve seat with AKROMID® A3 GF 15 1 GIT modification

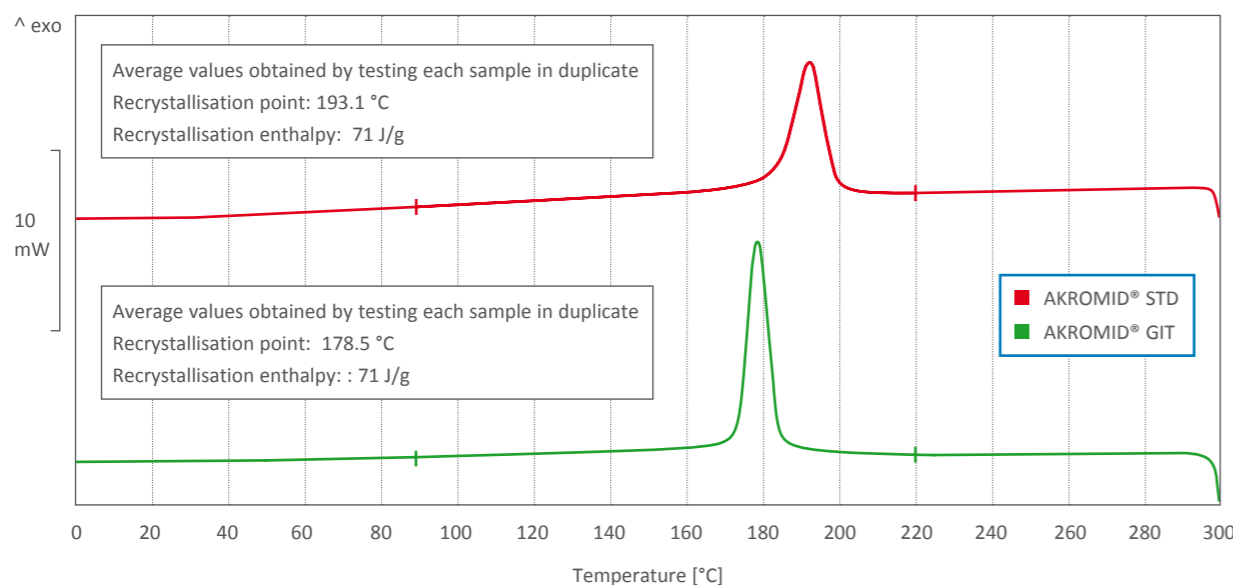
Stabilisation with shielding technology (Fig. 2)



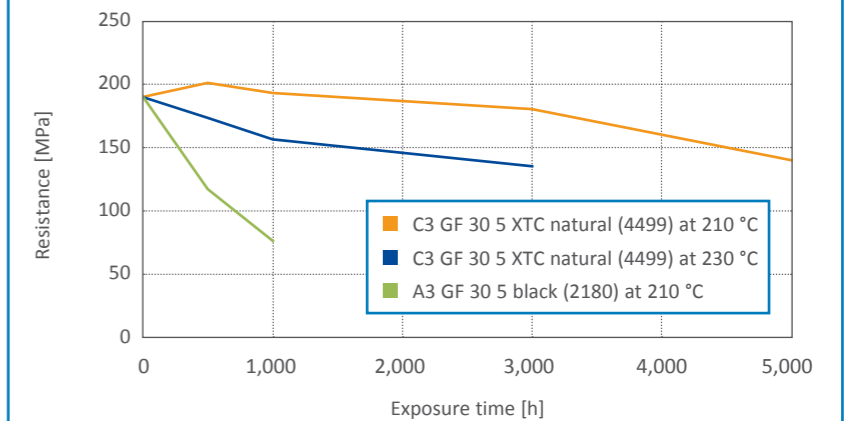
Tensile bar made of C3 GF 30 5 XTC colourless (4499) after 1,000 h at 210 °C

Rising to the challenge of meeting steadily increasing demands for cost-effective materials with greater heat resistance, AKRO-PLASTIC has developed AKROMID® C3 GF 30 5 XTC, a compound with an exceptional heat ageing resistance at temperatures of around 200 °C. Stabilisation in AKROMID® C3 GF 30 5 XTC is based on shielding technology (see Fig. 2) and is electrically neutral. Potential applications can be found primarily in the motorcar industry, where alternatives to conventional thermoplastics are sought due to increasing temperatures in the engine compartment. Even after an ageing treatment lasting 5,000 hours at 210 °C, hardly any decrease in tensile stress at break is observed (see Fig. 3). The strain following this conditioning is still significantly greater than 2 % (see Fig. 4). And AKROMID® C3 GF 30 5 XTC is just as easy to process as standard AKROMID® compounds. As with other polyamide compounds, the strengths are extremely dependent on the temperature (see Fig. 5).

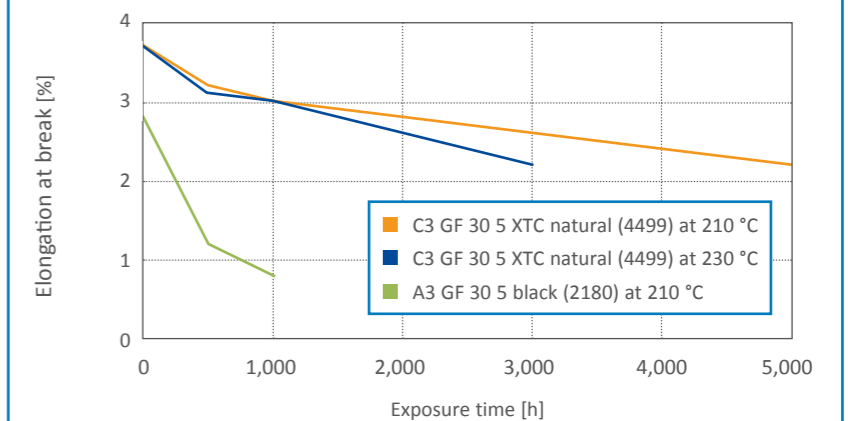
DSC – Comparison of AKROMID® STD / GIT (Fig. 1)



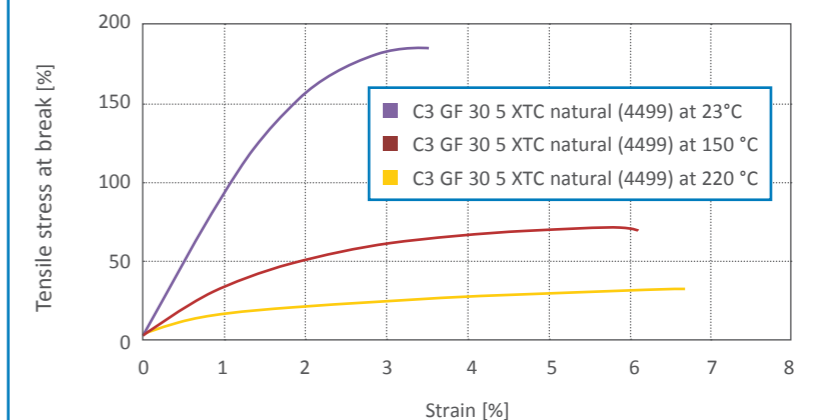
Resistance based on exposure time (Fig. 3)



Elongation at break based on exposure time (Fig. 4)



Stress-strain curves at temperature (Fig. 5)



Trouble Shooting

For effective trouble shooting it is desirable to be able to clearly attribute a defect to a certain symptom.

We have listed the most frequent cases alphabetically in the table below. Corrective actions are divided

ded into the areas of processing and mould/finished part and listed in order of probability.

Symptom	Description	Process and processing optimization	Mould and part optimization
Flaking, scaling, lamination, delamination	Surface layers can be pulled off due to delamination	Check material for contamination, reduce or graduate injection speed, increase back pressure, increase mould and melt temperature	Smooth gate transitions with radius
Weld line	Line marks formed by the meeting of melting fronts	Increase mould and melt temperature, increase back and holding pressure, increase injection speed	Check mould ventilation, move gate, increase surface roughness
Diesel effect	Discolouration (Burning) at the point of fill	Decrease injection speed and pressure, gradually towards the point of fill Reduce or avoid screw retraction entirely	Check mould venting and, if required, increase
Sink marks	Surface recesses on the reverse side of ribs, domes or changes of wall thickness	If applicable, increase metering stroke, increase holding pressure and time, optimize injection speed	Enlarge or move gate, improve mould temperature control, optimize wall thickness or rib ratio, shorten flow paths
Colour streaks (with use of MB)	Locally limited colour changes on the surface	Local surface colour variations Increase back pressure and screw speed, change pigment size. If necessary use polymer specific masterbatch.	Change gate size, use shear/mixing charge
Moisture streaks	Silvery streaks in the direction of flow	Dry material sufficiently, increase mould temperature, degas through the cylinder (vented)	

Symptom	Description	Process and processing optimization	Mould and part optimization
Jetting	Meandering surface pattern due to lack of wall adhesion of melt	Reduce injection speed in first stage significantly, increase mould temperature, decrease melting temperature	Change location or geometry of gate, inject against rebounding surface
Glass fibre streak	Rough surface, glass fibres visible on the surface, greying	Increase holding pressure and time, increase injection speed, increase mould and melt temperature, increase back pressure and screw speed	
Flash	Over-injection at the parting line and valves, inserts and ejectors	Increase mould clamping force, reduce dwell pressure and time, stage injection speed	Improve rigidity of mould, check for wear
Air streaks	Silvery streaks at ribs, domes and wall thickness changes	Reduce injection speed, increase back pressure and screw speed, reduce or avoid screw retraction entirely	Round off sharp edges, change location of gate, check contact of nozzle with mould and contact surface of nozzle in cylinder
Voids	Vacuum inclusions inside the part	Increase back pressure, increase holding pressure and time, reduce injection speed, increase metering distance and melt cushion	Enlarge gate, move closer to mass accumulation, reduce material accumulation
Matt areas	Dull surface in the gate area	Reduce injection speed, graduate quicker towards end of filling	Enlarge gate, round off sharp edges at gate
Burn streaks	Dark streaks due to thermally damaged material	Reduce injection speed, reduce back pressure and screw speed, reduce melt temperature (hot runner temperature)	Enlarge flow cross-section, optimize gates

Resistance to Media

The information regarding chemical resistance are subjective ratings based on resistance experiments

according to standards ISO 175, ISO 11403-3, ISO 4599, ISO 4600, ISO 6252 etc.

The information is intended for an initial assessment only.

Medium	Temp. (°C)	Conc. (%)	pass	fail
Acetaldehyde	23	40		•
Acetone	23	100	•	
Acetonitrile	23	100	•	
Acrylonitrile	23	100	•	
Allyl alcohol	23	96		•
Formic acid	23	2		•
Aqueous Ammonia	23	10	•	
Amyl alcohol	23	100	•	
Benzine	23	100	•	
Benzine	40	100		•
Benzene	23	100	•	
Boric acid	23	10	•	
Boric acid	23	100		•
Brake fluid (DOT 4)	130	100		•
Brake fluid (DOT 4)	23	100	•	
Biodiesel	23	100	•	
Calcium chloride, aqueous	23	10	•	
Calcium chloride, alcoholic	23	10		•
Chlorine	23	100		•
Chlorace/c acid	23	50		•
Hydrogen chloride, gas	23	100		•
Chlorine water	23	100		•
Chromic acid	23	10		•
Cyclohexane	23	100	•	
Cyclohexanol	23	100	•	
Dichloro-Ace/c acid	23	50		•
Diesel fuel (DIN 51601)	23	100	•	
Naturalal gas	23	100	•	
Ace/c Acid	23	20	•	
Ethanol	23	96	•	
Ethyl acetate	23	100	•	
Ethylene glycol/water	120	50		•
Formaldehyde, aqueous	23	10	•	
Transmission oil (ATF m 1375.4)	150	100	•	
Glycerin	23	100	•	
Urea, aqueous	23	20	•	

Medium	Temp. (°C)	Conc. (%)	pass	fail
Hydraulic oil H and HL (DIN 51524)	100	100	•	
Iso-octanol	23	100	•	
Isopropanol	23	100	•	
Caus/c potash solu/on, aqueous	23	50	•	
Potassium chloride, aqueous	23	10	•	
Potassium permanganate, aqueous	23	10		•
Carbonic acid	60	100	•	
Methanol	23	100	•	
Methylene chloride	23	100		•
Motor oil (SAE 10W-40)	130	100	•	
Motor oil (SAE 10W-40)	23	100	•	
Sodium chloride, aqueous	23	10	•	
Sodium hydroxide solu/on, aqueous	23	1	•	
Sodium hypochlorite, aqueous	23	10		•
Oleic acid	23	100	•	
Ozone	23	100		•
Phenol	23	100		•
Phosphoric acid	23	30		•
Nitric acid	23	40		•
Hydrochloric acid	23	36		•
Carbon disulphide	23	100	•	
Sulphuric acid	23	96		•
Sulphuric acid	23	5		•
Seawater	23	100	•	
Silicone fluid	23		•	
Super-grade petrol (DIN 51600)	23	100	•	
Carbon tetrachloride	23	100	•	
Toluol	23	100	•	
Water	up to 50	100	•	
Hydrogen peroxide	23			•
Xylol	23	100	•	
Zinc chloride, aqueous	23	50		•
Citric acid	23	10	•	

Resistant means:

Unrestricted resistance under the specified conditions.

Not resistant means:

In spite of short-term resistance the material may be damaged, in case of prolonged contact there will be quickly visible chemical degradation. In any case, AKROMID® intended

for use with one of the listed media may only be used after practical testing.

We will be pleased to meet you!



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