+135-3858-6433 (GuangDong)
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AKRO COMPOUNDS

Compound No.: **8001**

AKROMID® PRELIMINARY
T5 GF 50 9 black (8001)

PPA GF50

AKROMID® T5 GF 50 9 black (8001) is a 50% glass fibre reinforced polyphthalamide with very high rigidity and strength, as well as high temperature and chemical resistance. This aromatic PPA keeps mechanical performance even at elevated temperatures or moisture pic-up. This product was optimized and provides a very good surface quality.

Features

surface modified

Properties

Modulus	Strength	Impact
18.500 MPa	**255** MPa	**65** kJ/m²

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min | d.a.m. 1 mm/min | conditioned	**18500 MPa** **18500 MPa**
Tensile stress at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**255 MPa** **255 MPa**
Tensile strain at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**1,9 %** **1,9 %**
Charpy impact strength ISO 179-1/1eU	23°C | d.a.m. 23°C | conditioned	**65 kJ/m²** **58 kJ/m²**
Charpy notched impact strength ISO 179-1/1eA	23°C | d.a.m.	**13 kJ/m²**

Thermal Properties

Temperature of deflection under load HDT/C ISO 75	8 MPa	**220 °C**

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Glass transition temperature ISO 11357-2	DSC, 2nd heating	**135 °C**
Melting temperature ISO 11357-3	DSC, 10K/min	**325 °C**

Flammability

Flammability UL 94	1,6 mm Wall thickness	**HB Class**

General Properties

Density ISO 1183	23°C	**1,65 g/cm³**
Molding shrinkage ISO 294-4	flow transverse	**0,1 - 0,3 %** **0,4 - 0,6 %**

Rheological Properties

Flowability AKRO	2 mm Thickness	**400 mm**

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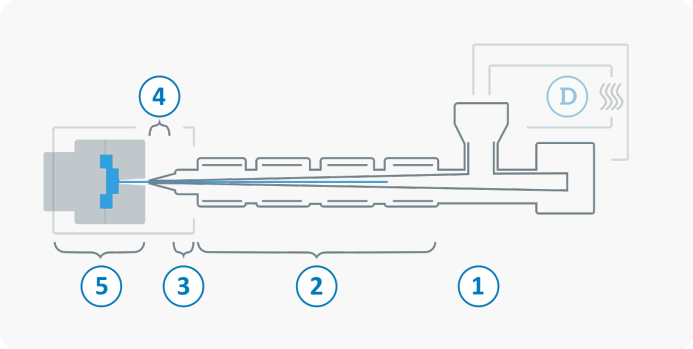
Processing

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	0 - 4 h
	Drying temperature (τ <= -30°C)	120 °C
	Processing moisture	0,02 - 0,1 %
1	Feed section	60 - 90 °C
2	Temperature Zone 1 - Zone 4	320 - 350 °C
3	Nozzle temperature	330 - 350 °C
4	Melt temperature	330 - 350 °C
5	Mold temperature	120 - 160 °C
→	Holding pressure, spec.	300 - 800 bar
←	Back pressure, spec.	50 - 150 bar
	Injection speed	medium to high
	Screw speed	8 - 15 m/min