

Compound No.: 8315

# AKROMID® PRELIMINARY T9 GF 30 1 black (8315)

PPA GF30

AKROMID® T9 GF 30 1 black (8315) is a 30% glass fibre reinforced and heat stabilization polyphthalamide with high rigidity and strength, as well as high temperature and chemical resistance. The compound is based on PA9T and has lower moisture uptake than conventional PA6T variants. This leads to a significantly higher consistency of the glass transition temperature and higher strength at elevated temperatures especially in conditioned state.

#### Properties

Modulus Strength	Impact
9.500 MPa 190 MPa	<b>75</b> kJ/m²

#### **Mechanical Properties**

1 mm/min   d.a.m.	9500 MPa
1 mm/min   conditioned	9400 MPa
5 mm/min   d.a.m.	190 MPa
5 mm/min   conditioned	155 MPa
5 mm/min   d.a.m.	3 %
5 mm/min   conditioned	2 %
23°C   d.a.m.	75 kJ/m²
-30°C   d.a.m.	65 kJ/m²
23°C   d.a.m.	10 kJ/m²
-30°C   d.a.m.	9 kJ/m²
	1 mm/min   conditioned  5 mm/min   d.a.m. 5 mm/min   conditioned  5 mm/min   d.a.m. 5 mm/min   conditioned  23°C   d.a.m30°C   d.a.m.

### **Thermal Properties**

Melting temperature	DSC. 10K/min	305 °C
ISO 11357-3	200, 1010	



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## **Flammability**

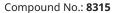
Flammability UL 94	1,6 mm Wall thickness	HB Class
OL 94		

## **General Properties**

<b>Density</b> ISO 1183	23°C	1,38 g/cm³
Humidity absorption ISO 1110	70°C, 62% r.H.	0,8 - 1,0 %
Molding shrinkage	flow	0,2 - 0,4 %
ISO 294-4	transverse	0,7 - 0,9 %

## **Electrical Properties**

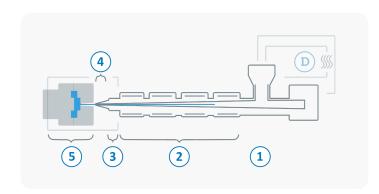
Comparative tracking index  IEC 60112	Test liquid A	600 V
120 00112		





#### **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	<0,05 %
1	Feed section	60 - 90 °C
2	Temperature Zone 1 - Zone 4	300 - 340 °C
3	Nozzle temperature	310 - 350 °C
4	Melt temperature	310 - 340 °C
5	Mold temperature	>135 °C
$\bigcirc$	Holding pressure, spec.	300 - 800 bar
	Back pressure, spec.	50 - 150 bar
	Injection speed	medium to high
	Screw speed	8 - 15 m/min