+135-3858-6433 (GuangDong)
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AKRO COMPOUNDS

Compound No.: **8056**

AKROMID® PRELIMINARY
T5 GF 50 6 natural (8056)

PPA GF50

Standard Grade with good surface quality. AKROMID® T5 GF 50 6 natural (8056) is a 50% glass fibre reinforced polyphthalamide with anorganic heat stabilization, very high rigidity and strength, as well as high temperature and chemical resistance. This aromatic PPA keeps its mechanical performance even at elevated temperatures or moisture pick-up

Features

heat stabilised 160

Properties

Modulus	Strength	Impact
18.000 MPa	**270** MPa	**90** kJ/m²

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min | d.a.m. 1 mm/min | conditioned	**18000 MPa** **18000 MPa**
Tensile stress at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**270 MPa** **270 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	**90 kJ/m²** **95 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	**230 °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	0,8 mm Wall thickness	**HB Class**
	1,6 mm Wall thickness	**HB Class**
	3,2 mm Wall thickness	**HB Class**

General Properties

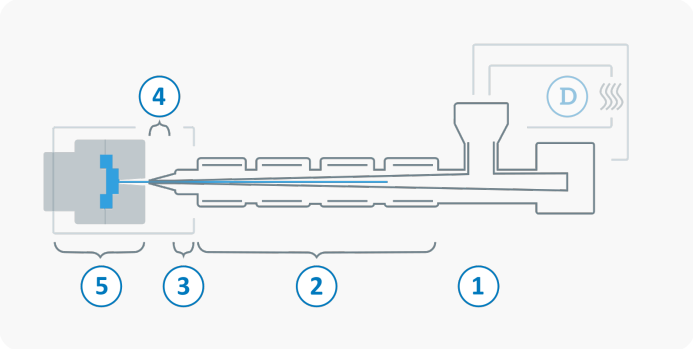
Density ISO 1183	23°C	**1,65 g/cm³**
Humidity absorption ISO 1110	70°C, 62% r.H.	**0,7 - 0,9 %**
Molding shrinkage ISO 294-4	flow	**0,1 - 0,3 %**
	transverse	**0,4 - 0,6 %**

Rheological Properties

Flowability AKRO	2 mm Thickness	**400 mm**

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