

Compound No.: 7873

AKROMID® PRELIMINARY T9 GF 30 S1 black (7873)

PPA-I GF30

8.700 MPa

AKROMID® T9 GF 30 S1 black (7873) is a 30% glass fibre reinforced, cold impact strength polyphthalamide with medium stiffness and strength, as well as high 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.

heat stabilised 160 Properties Modulus Strength Impact

95 kJ/m²

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min d.a.m.	8700 MPa
Tensile stress at break ISO 527-2	5 mm/min d.a.m.	165 MPa
Tensile strain at break ISO 527-2	5 mm/min d.a.m.	3,5 %
Charpy impact strength ISO 179-1/1eU	23°C d.a.m.	95 kJ/m²
Charpy notched impact strength ISO 179-1/1eA	23°C d.a.m.	16 kJ/m²

165 MPa

Thermal Properties

Glass transition temperature	DSC, 2nd heating	125 °C
ISO 11357-2	55c, 2nd ricating	123 C



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Melting temperature	DSC. 10K/min	305 °C
ISO 11357-3	550, 1010111111	505 €

Flammability

General Properties

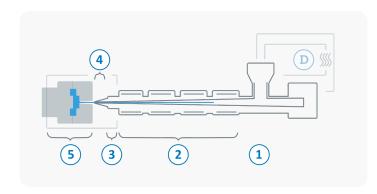
Density ISO 1183	23°C	1,33 g/cm³
Humidity absorption ISO 1110	70°C, 62% r.H.	0,7 - 1,0 %





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 ($\tau \le -30$ °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