

Compound No.: 8908

AKROMID® PRELIMINARY T9 GF 35 4 LA black (8908)

PPA GF35

AKROMID® T9 GF 35 4 LA black (8908) is a 35% glass fibre reinforced 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 hydrolysis / chemically stabilised electrically neutral Properties Modulus Strength Impact 11.000 MPa 210 MPa 80 kJ/m²

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min d.a.m.	11000 MPa
Tensile stress at break ISO 527-2	5 mm/min d.a.m.	210 MPa
Tensile strain at break ISO 527-2	5 mm/min d.a.m.	2,7 %
Charpy impact strength ISO 179-1/1eU	23°C d.a.m.	80 kJ/m²
Charpy notched impact strength ISO 179-1/1eA	23°C d.a.m.	12 kJ/m²

Thermal Properties

Temperature of deflection under load HDT/A	1.8 MPa	270 °C
ISO 75	1,0 1111 0	270 €



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Glass transition temperature ISO 11357-2	DSC, 2nd heating	125 °C
Melting temperature ISO 11357-3	DSC, 10K/min	300 °C

Flammability

Flammability UL 94	1,6 mm Wall thickness	HB Class
01.54		

General Properties

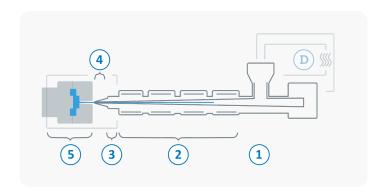
Density ISO 1183	23°⊂	1,41 g/cm³
Humidity absorption ISO 1110	70°C, 62% r.H.	0,1 - 0,3 %
Molding shrinkage ISO 294-4	flow transverse	0,2 - 0,4 % 0,6 - 0,8 %





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
\ominus	Holding pressure, spec.	300 - 800 bar
	Back pressure, spec.	50 - 150 bar
	Injection speed	medium to high
	Screw speed	8 - 15 m/min