+135-3858-6433 (GuangDong)
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AKRO COMPOUNDS

Compound No.: **8888**

AKROMID® PRELIMINARY
T9 CGM 15/20 LA black (8888)

PPA (CF15+GF20)

AKROMID® T9 CGM 15/20 1 LA black (8888) is a 15% carbon fiber and 20% glass fiber reinforced polyphthalamide with high stiffness and strength, as well as high chemical resistance. The compound impresses with its electrical conductivity and is therefore ideal for applications in the automotive sector and industry. The product is based on PA9T and therefore has significantly lower moisture absorption compared to conventional PA6T types. As a result, the glass transition region is significantly more constant and strength remains at a higher level even at higher temperatures, even in the conditioned state.

Features

heat stabilised 160 | recycled content | reduced density | metal substitution

Properties

Modulus	Strength	Impact
15.800 MPa	**215** MPa	**65** kJ/m²

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min | d.a.m.	**15800 MPa**
Tensile stress at break ISO 527-2	5 mm/min | d.a.m.	**215 MPa**
Tensile strain at break ISO 527-2	5 mm/min | d.a.m.	**2,1 %**
Charpy impact strength ISO 179-1/1eU	23°C | d.a.m.	**65 kJ/m²**

Thermal Properties

Melting temperature ISO 11357-3	DSC, 10K/min	**300 °C**

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Flammability

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

General Properties

Density ISO 1183	23°C	**1,4 g/cm³**

Electrical Properties

Surface resistivity IEC 62631-3-2	d.a.m.	**< 10^3 Ω**

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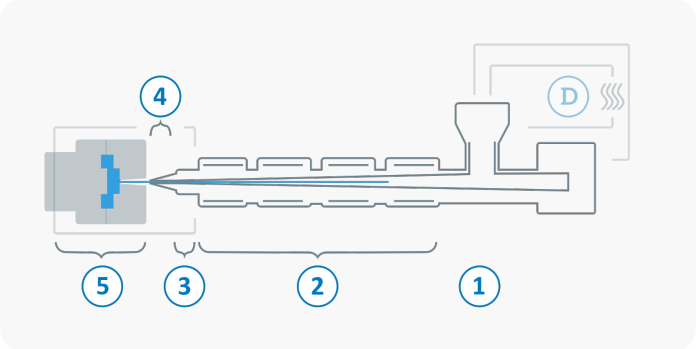
Processing

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	<0,05 %
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
→	Holding pressure, spec.	300 - 800 bar
←	Back pressure, spec.	50 - 150 bar
	Injection speed	medium to high
	Screw speed	8 - 15 m/min