

Amodel® A-4133 HH
PPA-GF35

Syensqo

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Mold Shrinkage, MD	0.003	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.01	mm/mm	ASTM D 955
Water Absorption, 24hr	0.5	%	ASTM D 570

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	12600	MPa	ISO 527
Stress at Break	214	MPa	ISO 527
Strain at Break	2.1	%	ISO 527
Impact Strength (Charpy), +23°C	60	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	8	kJ/m²	ISO 179/1eA
Flexural Modulus (23°C)	11100	MPa	ISO 178
Flexural strength	279	MPa	ISO 178
Notched Impact Strength (Izod), 23°C	9	kJ/m²	ISO 180/1A
Impact Strength (Izod), 23°C	52	kJ/m²	ISO 180/1U
ASTM Data			
Compressive Strength	161	MPa	ASTM D 695

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	327	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	285	°C	ISO 75-1/-2

Other Properties	Value	Unit	Test Standard
ISO Data			
Density	1490	kg/m³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	120	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.045	%	-
Melt temperature	330 - 335	°C	-
Mold temperature	66 - 140	°C	-
Zone 1	318 - 324	°C	-
Zone 2	318 - 324	°C	-
Zone 3	327 - 332	°C	-
Injection speed	76 - 102	mm/s	-

Characteristics
Processing

Injection Molding

Features

Creep Resistance, Weldable

Delivery form

Pellets

Chemical Resistance

General Chemical Resistance

Special Characteristics

Heat aging stabilized

Applications

Automotive, Electrical and Electronical