

Amodel® A-1133 HS BK 324
PPA-GF33

Syensqo

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Mold Shrinkage, MD	0.004	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.008	mm/mm	ASTM D 955
Water Absorption, 24hr	0.23	%	ASTM D 570

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	13400 / -	MPa	ISO 527
Stress at Break	233 / -	MPa	ISO 527
Strain at Break	2.5 / -	%	ISO 527
Impact Strength (Charpy), +23°C	73 / -	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	9.5 / -	kJ/m²	ISO 179/1eA
Flexural Modulus (23°C)	11600 / -	MPa	ISO 178
Flexural Modulus	3600 / -	MPa	ISO 178
Flexural Modulus Temperature	175	°C	-
Notched Impact Strength (Izod), 23°C	8.8 / -	kJ/m²	ISO 180/1A
Impact Strength (Izod), 23°C	49 / -	kJ/m²	ISO 180/1U
ASTM Data			
Tensile Modulus	13100 / 13100	MPa	ASTM D 638
Tensile Strength	221 / 193	MPa	ASTM D 638
Elongation at Break	2.5 / 2.1	%	ASTM D 638
Compressive Strength	185 / -	MPa	ASTM D 695
Flexural Modulus	11400 / 11400	MPa	ASTM D 790
Flexural Strength	317 / 254	MPa	ASTM D 790
Rockwell Hardness	R125 /	-	ASTM D 785
Notched Impact Strength (Izod), 1/8 in	80.1 / 59	J/m	ASTM D 256
Impact Strength (Izod), 1/8 in	770 / -	J/m	ASTM D 256

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	313 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	280 / *	°C	ISO 75-1/-2
Burning Behav. at thickness h	HB / *	class	UL 94
Thickness tested	3.2 / *	mm	-
ASTM Data			
Melting Temperature	313	°C	ASTM D 3418

Electrical Properties	dry / cond	Unit	Test Standard
ASTM Data			
Dielectric Strength, Short Time	21 / 21	kV/mm	ASTM D 149
Dissipation Factor, 60 Hz	0.005 / 0.009	-	ASTM D 150
Dissipation Factor, 1 MHz	0.017 / 0.022	-	ASTM D 150
Dielectric Constant, 60 Hz	4.4 / 4.7	-	ASTM D 150
Dielectric Constant, 1 MHz	4.2 / 4.3	-	ASTM D 150
Volume Resistivity	>1E15 / 0	Ohm*cm	ASTM D 257
Arc Resistance	140 / 120	s	ASTM D 495

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Density	1480 / -	kg/m³	ISO 1183

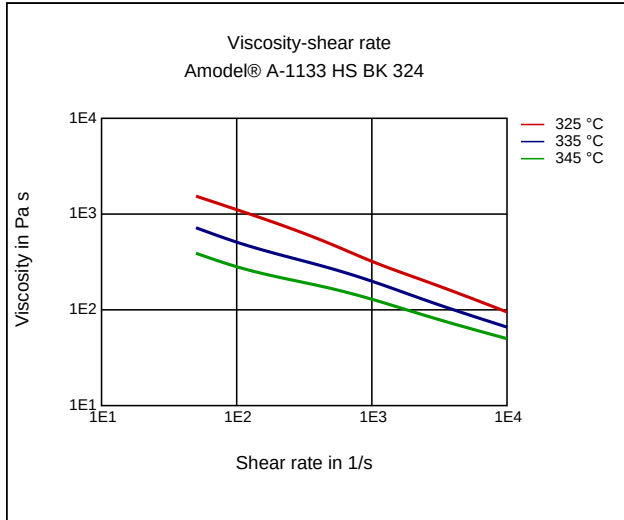
Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	120	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.045	%	-
Melt temperature	321 - 343	°C	-
Mold temperature	135	°C	-
Zone 1	304 - 318	°C	-
Zone 2	316 - 329	°C	-

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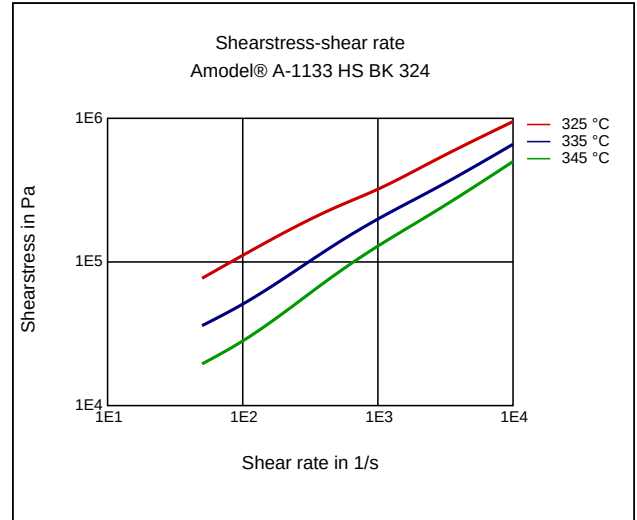
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Diagrams

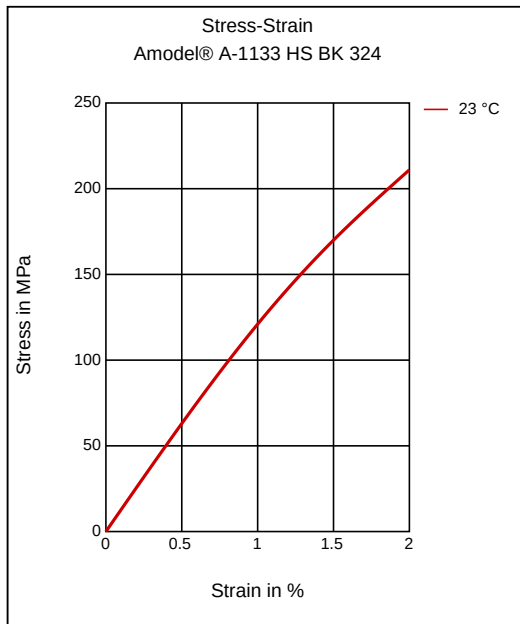
Viscosity-shear rate



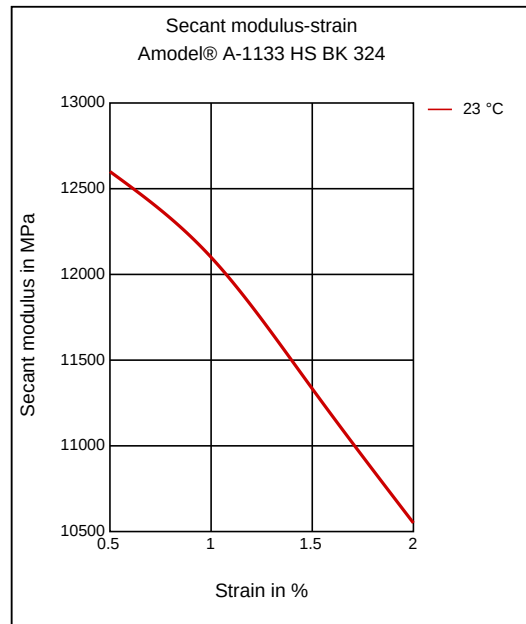
Shearstress-shear rate



Stress-strain



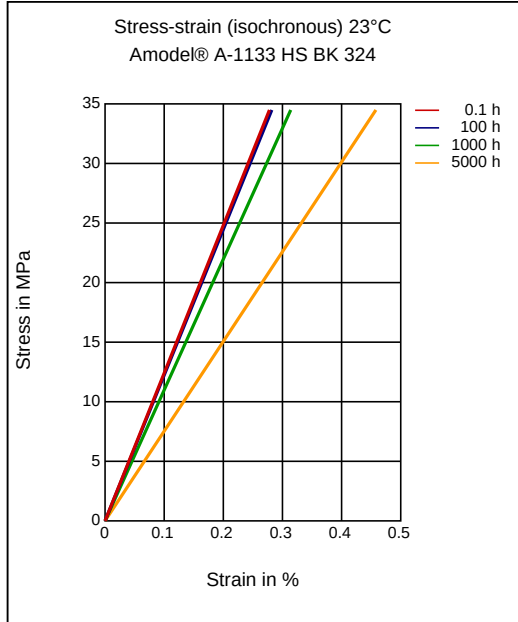
Secant modulus-strain



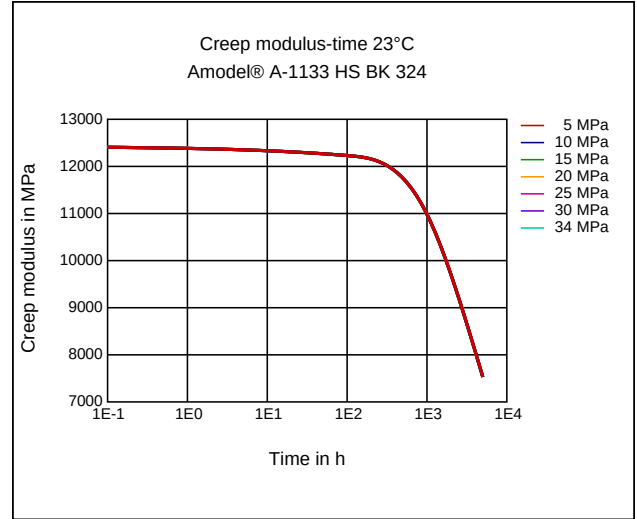
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Stress-strain (isochronous) 23°C



Creep modulus-time 23°C



Characteristics

Processing

Injection Molding

Delivery form

Pellets, Black

Special Characteristics

Heat aging stabilized

Features

Creep Resistance

Chemical Resistance

General Chemical Resistance