

Amodel® AT-6115 HS

PPA-GF15

Syensqo

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Mold Shrinkage, MD	0.01	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.011	mm/mm	ASTM D 955
Water Absorption, 24hr	0.2	%	ASTM D 570

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	5200 / -	MPa	ISO 527
Stress at Break	126 / -	MPa	ISO 527
Strain at Break	4.1 / -	%	ISO 527
Impact Strength (Charpy), +23°C	76 / -	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	11 / -	kJ/m²	ISO 179/1eA
Flexural Modulus (23°C)	4270 / -	MPa	ISO 178
Flexural Modulus	2340 / -	MPa	ISO 178
Flexural Modulus Temperature	100	°C	-
Notched Impact Strength (Izod), 23°C	12 / -	kJ/m²	ISO 180/1A
Impact Strength (Izod), 23°C	55 / -	kJ/m²	ISO 180/1U
ASTM Data			
Tensile Modulus	5380 / 4200	MPa	ASTM D 638
Tensile Strength	122 / 95.8	MPa	ASTM D 638
Elongation at Break	3.4 / 5.3	%	ASTM D 638
Compressive Strength	100 / -	MPa	ASTM D 695
Flexural Modulus	4410 / 3450	MPa	ASTM D 790
Flexural Strength	165 / 115	MPa	ASTM D 790
Notched Impact Strength (Izod), 1/8 in	91 / 80	J/m	ASTM D 256
Impact Strength (Izod), 1/8 in	850 / -	J/m	ASTM D 256

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	305 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	251 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	298 / *	°C	ISO 75-1/-2
ASTM Data			
Melting Temperature	305	°C	ASTM D 3418

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Density	1220 / -	kg/m³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	110	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.045	%	-
Melt temperature	321 - 335	°C	-
Mold temperature	66 - 93	°C	-
Zone 1	316 - 324	°C	-
Zone 2	327 - 332	°C	-
Injection speed	76 - 102	mm/s	-

Characteristics

Processing

Injection Molding

Delivery form

Pellets, Black

Additives

Lubricants, Release agent

Special Characteristics

Impact modified, Heat aging stabilized

Applications

Automotive, IT / Business Machine, Electrical and Electronical, General Purpose