

InStruc® PPAGF10HWMD

Americhem - Polyphthalamide

General Information
Product Description

 10% GLASS FIBER REINFORCED, HOT WATER MOLDABLE, POLYPHTHALAMIDE
 (LOCKED MEDICAL FORMULATION)

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Filler / Reinforcement	• Glass Fiber, 10% Filler by Weight		
Features	• E-beam Sterilizable	• Good Dimensional Stability	• Hot Water Moldability
	• Ethylene Oxide Sterilizable	• High Stiffness	• Radiation Sterilizable
	• Filled	• High Strength	• Steam Sterilizable
Uses	• Connectors	• Housings	• Metal Replacement
	• Electrical/Electronic Applications	• Industrial Parts	• Semiconductor Applications
	• Engineering Parts	• Medical/Healthcare Applications	• Surgical Instruments
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.26		ASTM D792
Molding Shrinkage - Flow	7.0E-3 to 0.012	in/in	ASTM D955
Water Absorption (24 hr)	0.28	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	800000	psi	ASTM D638
Tensile Strength	13500	psi	ASTM D638
Tensile Elongation (Yield)	1.0 to 3.0	%	ASTM D638
Flexural Modulus	800000	psi	ASTM D790
Flexural Strength	21000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.70	ft-lb/in	ASTM D256
Unnotched Izod Impact (0.125 in)	4.0	ft-lb/in	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	470	°F	ASTM D648

Processing Information

	Nominal Value	Unit
Injection		
Drying Temperature	275	°F
Drying Time	4.0	hr
Processing (Melt) Temp	625	°F
Mold Temperature	150 to 200	°F
Back Pressure	50.0 to 100	psi
Screw Speed	40 to 70	rpm
Vent Depth	5.0E-4 to 1.0E-3	in

