

PPA – Polyphthalamide PPA GF40

AKROMID® T5 GF 40 4 black (7585)

Tensile modulus

14100 MPa

1 mm/min

ISO 527-2

Stress at break

245 MPa

5 mm/min

ISO 527-2

Charpy impact strength

70 kJ/m²

23°C

ISO 179-1/1eU

AKROMID® T5 GF 40 black (7585) is a 40% glass fibre reinforced polyphthalamide with anorganic heat stabilization, very high rigidity and strength, designed for hydrolysis resistance.

This aromatic PPA keeps mechanical performance even at elevated temperatures or moisture pic-up

Typical applications

Heavy duty components in the automotive cooling circuit or other dimensionally stable and rigid parts for engineered applications in the automotive or electrical industry requiring strength and durability even at high temperatures or moist conditions.



Mechanical Properties

Tensile modulus (1 mm/min ISO 527-2) d.a.m.	14100 MPa
Stress at break (5 mm/min ISO 527-2) d.a.m.	245 MPa
Strain at break (5 mm/min ISO 527-2) d.a.m.	2,5 %
Charpy impact strength (23°C ISO 179-1/1eU) d.a.m.	70 kJ/m ²
Charpy notched impact strength (23°C ISO 179-1/1eA) d.a.m.	11 kJ/m ²



Thermal Properties

Melt temperature (DSC, 10K/min DIN EN 11357-1)	325 °C
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Flammability

Burning rate (UL 94) 1,6mm Wall thickness	HB Class
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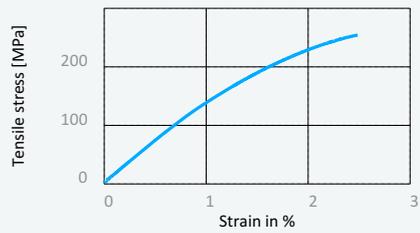
General properties

Density (23°C ISO 1183)	1,5 g/cm ³
Molding shrinkage (flow ISO 294-4)	0,2 %
Molding shrinkage (transverse ISO 294-4)	0,6 %

Disclaimer:

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Stress strain chart at 23°C



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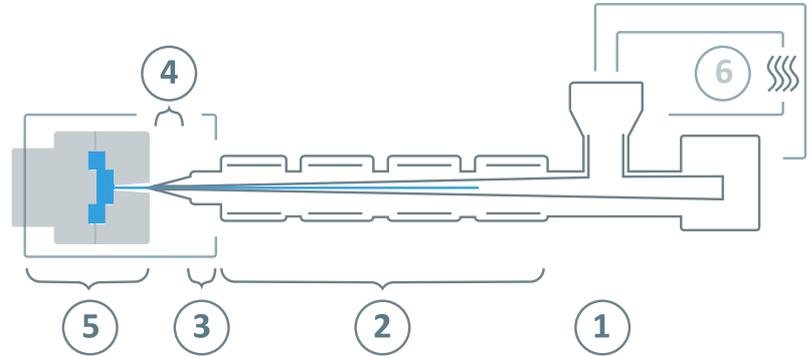
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Processing information

The listed values are recommendations. Higher values should be used for higher glass loadings. We recommend only dehumidifying or vacuum dryers. Extensive drying can cause filling problems and surface defects.



⑥	Drying time	0 - 4 h
	Drying temperature ($\tau \leq -30^\circ\text{C}$)	120°C
	Processing moisture	0,02 - 0,1%
①	Feed section	60 - 90°C
②	Temperature zone 1 - Zone 4	320 - 350°C
③	Nozzle temperature	330 - 350°C
④	Melt temperature	330 - 350°C
⑤	Mold temperature	120 - 160°C
→	Holding pressure, spec.	300 - 800 bar
←	Back pressure, spec.	50 - 150 bar
	Injection speed	medium to high
	Screw speed	8 - 15 m/min

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