

PPA – Polyphthalamide PPA GF50

AKROMID® T5 GF 50 6 black (8000)

Tensile modulus

18500 MPa1 mm/min
ISO 527-2

Stress at break

260 MPa5 mm/min
ISO 527-2

Charpy impact strength

65 kJ/m²23°C
ISO 179-1/1eU

Standard Grade with good surface quality.

AKROMID® T5 GF 50 6 black (8000) is a 50% glass fibre reinforced polyphthalamide with anorganic heat stabilization, very high rigidity and strength, as well as high temperature and chemical resistance.

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

Typical applications

Dimensionally stable and rigid parts for engineered automotive, industrial or electrical applications requiring strength and durability even at high temperatures or moist conditions.

**Mechanical Properties**

Tensile modulus (1 mm/min | ISO 527-2)

d.a.m.

18500 MPa

conditioned

18500 MPa

Stress at break (5 mm/min | ISO 527-2)

d.a.m.

260 MPa

conditioned

260 MPa

Strain at break (5 mm/min | ISO 527-2)

d.a.m.

1,9 %

conditioned

1,9 %

Charpy impact strength (23°C | ISO 179-1/1eU)

d.a.m.

65 kJ/m²

conditioned

58 kJ/m²

Charpy notched impact strength (23°C | ISO 179-1/1eA)

d.a.m.

13 kJ/m²**Thermal Properties**

Temperature of deflection under load HDT/C (8 MPa | ISO 75)

230 °C

Glass transition temperature (DSC, 2nd heating | DIN EN 11357-1)

135 °C

Melt temperature (DSC, 10K/min | DIN EN 11357-1)

325 °C

**Flammability**

Burning rate (UL 94)

1,6mm Wall thickness

HB Class

**General properties**

Density (23°C | ISO 1183)

1,65 g/cm³

Molding shrinkage (flow | ISO 294-4)

0,1-0,3 %

Molding shrinkage (transverse | ISO 294-4)

0,4-0,6 %

**Rheological Properties**

Flowability (2mm Thickness | AKRO)

400 mm

Disclaimer:

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Notes

Standard Grade with good surface quality

Disclaimer:

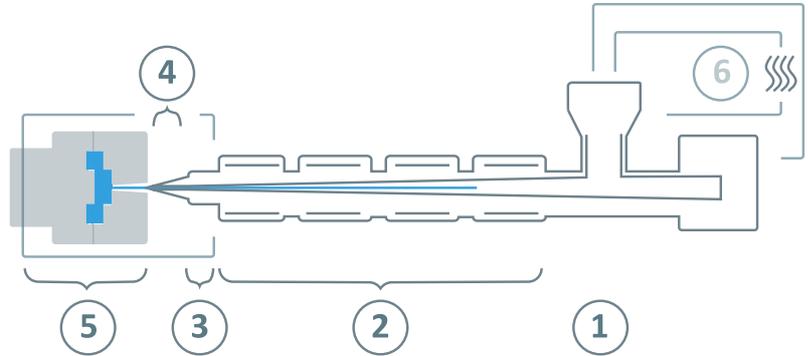
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Processing information

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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