

Witcom PPA 6LC-HS

Polyphthalamide

Witcom Engineering Plastics B.V.

Message:

Witcom PPA 6LC-HS is a polyxylene amide (PPA) product that contains 30% long carbon fiber as filler. It can be processed by injection molding and is available in Europe. The main characteristics are: flame retardant/rated flame.

General Information			
Filler / Reinforcement	Long carbon fiber, 30% filler by weight		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.30	g/cm ³	ISO 1183
Molding Shrinkage - Flow (3.00 mm)	0.10 - 0.30	%	ISO 2577
Water Absorption			ISO 62
Saturated, 23°C	5.6	%	ISO 62
Equilibrium, 23°C, 50% RH	1.8	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	28000	MPa	ISO 527-2
Tensile Stress (Yield)	< 290	MPa	ISO 527-2
Tensile Strain (Break)	1.0 - 2.0	%	ISO 527-2
Flexural Modulus	25000	MPa	ISO 178
Flexural Stress	440	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	10	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength	50	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	285	°C	ISO 75-2/A
CLTE - Flow	1.7E-5	cm/cm/°C	ISO 11359-2
RTI Imp (3.00 mm)	130	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	10 - 1.0E+3	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flammability Classification (3.00 mm)	HB		IEC 60695-11-10, -20
Glow Wire Flammability Index (1.60 mm)	750	°C	IEC 60695-2-12
Injection	Nominal Value	Unit	
Drying Temperature	130	°C	
Drying Time	4.0 - 8.0	hr	
Suggested Max Moisture	0.10	%	
Processing (Melt) Temp	320 - 345	°C	
Mold Temperature	135 - 165	°C	

Injection Rate	Fast	
Back Pressure	0.00 - 1.00	MPa
Injection instructions		

Screw speed: 0.1 - 0.2 m/sInjection pressure: Keep to a minimumHold pressure: Keep to a minimum

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