Amodel® LF-1630 L NT-7

Polyphthalamide

Solvay Specialty Polymers

Message:

Amodel® LF-1630 L NT-7 is 30% long carbon fiber reinforced, easy-flowing PPA which can be processed on most injection molding machines.
This material achieves extremely high mechanical and thermal properties, in combination with ease of processing and fast cycle times. It exhibits high strength, stiffness and impact strength at high temperatures; excellent creep and fatigue resistance; isotropic mechanical properties and reduced isotropic shrinkage; high shear strength and high burst pressure; and an excellent surface finish.

General Information			
Filler / Reinforcement	Long carbon fiber, 30% filler by weight		
Features	Low CLTE Low warpage Rigidity, high Rigidity, high High tensile strength Insulation Impact resistance, high Good creep resistance Fatigue resistance Hot water formability		
Uses	Gear Aircraft applications Application in Automobile Field Car dashboard		
Appearance	Natural color		
Forms	Particle		
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	1.30	g/cm³	ISO 1183
shrinkage-Flow [1]	0.25	%	Internal method
Water Absorption (Equilibrium, 23°C, 50% RH)	0.80	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus (23°C)	26000	MPa	ISO 527-2
Tensile Stress (Break, 23°C)	320	MPa	ISO 527-2
Tensile Strain (Break)	1.5	%	ISO 527-2
Flexural Modulus (23°C)	24500	MPa	ISO 178
Flexural Stress (23°C)	440	MPa	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**

Charpy Notched Impact Strength (23°C)	12	kJ/m²	ISO 179
Charpy Unnotched Impact Strength (23°C)	55	kJ/m²	ISO 179
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature			
0.45 MPa, not annealed	300	°C	ISO 75-2/B
1.8 MPa, not annealed	285	°C	ISO 75-2/A
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	100	ohms/sq	ASTM D257
Injection	**Nominal Value**	**Unit**	
Drying Temperature	120	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.080	%	
Suggested Max Regrind	20	%	
Rear Temperature	320 - 340	°C	
Middle Temperature	320 - 335	°C	
Front Temperature	320 - 335	°C	
Nozzle Temperature	325 - 340	°C	
Processing (Melt) Temp	< 340	°C	
Mold Temperature	135 - 165	°C	

Injection instructions
Pre-Drying -- Since polyamides are hygroscopic materials as well as sensitive to moisture during processing, this product should always be pre-dried.Regrind -- Regrind of highly filled thermoplastic materials, such as this material, should only be recycled with special care. The regrind content must never exceed 20% and only regrind of optimum quality should be used. In any case, part properties should be checked.

NOTE	
1.	Tested in accordance with S.O.P. methods

Recommended distributors for this material

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