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**NILAMID XT4 HH GF35 BK 9005/C - PPA**


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**Description**


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PPA, 35% glass fiber reinforced, high thermal performance

Nilamid XT4 compounds are designed for electrical and electronic applications requiring a maximum service temperature higher than that of standard polyamides. The most relevant characteristics are the following: High stiffness and strength at elevated temperatures V-0 according to the UL 94 flammability standard Excellent creep behavior Small influence on mechanical properties after moisture uptake Good dimensional stability Low warpage

<b>Physical properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
Density	1470 / -	kg/m <sup>3</sup>	ISO 1183
Molding shrinkage, parallel	0.3 - 0.4	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7 - 0.9	%	ISO 294-4, 2577
Humidity absorption, 23°C/50%RH	0.1 / *	%	ISO 62

<b>Mechanical properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
Tensile modulus	13000 / -	MPa	ISO 527-2/1A
Tensile stress at break, 5mm/min	185 / -	MPa	ISO 527-2/1A
Tensile strain at break, 5mm/min	1.8 / -	%	ISO 527-2/1A
Flexural modulus, 23°C	12000 / -	MPa	ISO 178
Flexural stress at max. force	295 / -	MPa	ISO 178
Charpy impact strength, 23°C	40 / -	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength, -30°C	35 / -	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, 23°C	9 / -	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	8 / -	kJ/m <sup>2</sup>	ISO 179/1eA
Izod impact notched, 23°C	8.5 / -	kJ/m <sup>2</sup>	ISO 180/1A

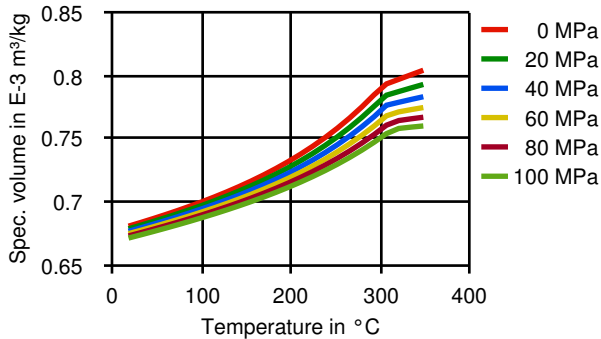
<b>Thermal properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
Melting point, peak	325	°C	ISO 3146
DTUL at 1.8 MPa	295 / *	°C	ISO 75-1, -2
Flammability @3.2mm nom. thickn.	HB / *	class	UL 94
Flammability @1.6mm nom. thickn.	HB / *	class	UL 94
Flammability @0.8mm nom. thickn.	HB / *	class	UL 94
Flammability @0.4mm nom. thickn.	HB / *	class	UL 94
Continuous service temperature	140 / *	°C	DIN/IEC 60216-1

<b>Electrical properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
Electric strength	21 / -	kV/mm	IEC 60243-1

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### Diagrams

#### Moldflow Specific volume-temperature (pvT)



#### Typical injection moulding processing conditions

Temperature	Value	Unit	Test Standard
Melt temperature	≤350	°C	-

#### Other text information

##### Injection Molding Preprocessing

Nilamid XT4 compound is supplied in moisture-proof packaging. The maximum moisture content allowed for the process of injection molding is 0.10%, but to get the maximum performance and reduce possible degradation phenomena is recommended molding with a moisture content <0.08%. The drying time depends on the initial moisture content and the drying conditions used. Typically 4-6h hours at 110C with dry air (dew point of <-30C) are sufficient for the material stored in unopened packs or with moisture content <0.20-0.25%.

##### Injection molding

The following conditions apply to the normal injection molding process of Nilamid XT4. Machine temperatures: barrel 310-325C, nozzle and hot runners 325-340C. Mold temperatures: 100C. Back pressure: typically <5 bar (hydraulic pressure). Temperatures exceeding 340C and long residence time could lead to degradation and brittleness of the material. In case of gas generation in the melt, please verify moisture content and processing temperatures. Usage of regrind is possible depending on the molded part characteristics. For further details, please contact our technical support team.

##### Injection Molding Postprocessing

Parts made by Nilamid XT4 compound, do not change significantly their performance depending on the moisture uptake. Normally, a conditioning cycle is not necessary. After molding, with favorable environmental conditions, a piece can absorb moisture up to 0,1-0,3% in 24h and reach the equilibrium during its lifetime. The post-treatment of the parts may include annealing at 100-110C in the oven, up to four hours. This treatment is useful to relax any internal stress.