

Amodel® A-4133 HH

polyphthalamide

Amodel® A-4133 HH BK is a 35% glass fiber reinforced heat stabilized grade of polyphthalamide (PPA) that has been designed to provide outstanding property retention to thermal oxidative degradation at temperatures of 230°C. Other features are fast cycling and hot water moldability. This product is particularly suitable to air induction applications within downsized automotive engines such as air induction charge air cooling and exhaust gas recirculation.

This grade features high heat deflection temperature, high flexural modulus and high tensile strength, as well as excellent creep resistance and low moisture absorption.

- Black: A-4133 HH BK 311

General

Material Status	• Commercial: Active
Availability	• Europe • North America
Filler / Reinforcement	• Glass Fiber, 35% Filler by Weight
Additive	• Heat Stabilizer
Features	<ul style="list-style-type: none"> • Chemical Resistant • Creep Resistant • Good Dimensional Stability • Good Stiffness • Heat Stabilized • High Heat Resistance • High Strength • Hot Water Moldability • Laser Weldable • Low Moisture Absorption
Uses	<ul style="list-style-type: none"> • Automotive Applications • Automotive Electronics • Connectors • Consumer Applications • Housings • Industrial Applications • Machine/Mechanical Parts • Metal Replacement
RoHS Compliance	• Contact Manufacturer
Appearance	• Black
Forms	• Pellets
Processing Method	• Water-Heated Mold Injection Molding

Physical	Typical Value	Unit	Test method
Density	1.49	g/cm ³	ISO 1183/A
Molding Shrinkage			ASTM D955
Flow	0.30	%	
Across Flow	1.0	%	
Water Absorption (24 hr)	0.50	%	ASTM D570

Mechanical	Typical Value	Unit	Test method
Tensile Modulus	12600	MPa	ISO 527-2

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Mechanical	Typical Value	Unit	Test method
Tensile Stress			ISO 527-2
Break, -40°C	245	MPa	
Break, 23°C	214	MPa	
Break, 80°C	138	MPa	
Break, 120°C	92.0	MPa	
Break, 180°C	64.0	MPa	
Break, 200°C	56.0	MPa	
Break, 220°C	49.0	MPa	
Break, 250°C	41.0	MPa	
Tensile Strain (Break, 23°C)	2.1	%	ISO 527-2
Flexural Modulus (23°C)	11100	MPa	ISO 178
Flexural Stress (23°C)	279	MPa	ISO 178
Compressive Strength	161	MPa	ASTM D695
Shear Strength	88.0	MPa	ASTM D732
Poisson's Ratio	0.39		ASTM E132
Impact	Typical Value	Unit	Test method
Charpy Notched Impact Strength (23°C)	8.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	60	kJ/m ²	ISO 179/1eU
Notched Izod Impact Strength (23°C)	9.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength (23°C)	52	kJ/m ²	ISO 180/1U
Thermal	Typical Value	Unit	Test method
Heat Deflection Temperature			ISO 75-2/A
1.8 MPa, Unannealed	285	°C	
Melting Temperature	327	°C	ISO 11357-3
Injection	Typical Value	Unit	
Drying Temperature	120	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.045	%	
Rear Temperature	318 to 324	°C	
Middle Temperature	318 to 324	°C	
Front Temperature	327 to 332	°C	
Processing (Melt) Temp	330 to 335	°C	
Mold Temperature	66 to 93	°C	

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Injection Notes

Injection Rate: 3 to 4 in/sec

Holding Pressure: 50% of injection pressure

Storage:

- Amodel® compounds are shipped in moisture-resistant packages at moisture levels according to specifications. Sealed, undamaged bags should be preferably stored in a dry room at a maximum temperature of 50°C (122°F) and should be protected from possible damage. If only a portion of a package is used, the remaining material should be transferred into a sealable container. It is recommended that Amodel® resins be dried prior to molding following the recommendations found in this datasheet and/or in the Amodel® processing guide.

Proper Ventilation:

- It is strongly recommended that the processing site be correctly ventilated during molding. The ventilation should be placed directly above the injection nozzle to prevent exposure to fumes and gases that may be generated.
- In the event of a barrel purge where a large melt patty may be generated, it is often advisable to draw the purge patty into a bucket of water to reduce fumes.

Hot Runners:

- Solvay does not encourage the use of hot runner technology with this product. For further clarification on hot runners, please contact your Solvay Specialty Polymers Technical Marketing representative.
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Notes

Typical properties: these are not to be construed as specifications.



Safety Data Sheets (SDS) are available by emailing us or contacting your sales representative. Always consult the appropriate SDS before using any of our products.

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