

**Amodel® AT-6115 HS**

PPA-GF15

Syensqo

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
Mold Shrinkage, MD	0.01	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.011	mm/mm	ASTM D 955

Mechanical properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	5200 / -	MPa	ISO 527
Stress at break	126 / -	MPa	ISO 527
Strain at break	4.1 / -	%	ISO 527
Flexural modulus, 23°C	4270 / -	MPa	ISO 178
Flexural modulus	2340 / -	MPa	ISO 178
Flexural modulus temperature	100	°C	-
Charpy impact strength, +23°C	76 / -	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	11 / -	kJ/m <sup>2</sup>	ISO 179/1eA
Izod impact strength, +23°C	55 / -	kJ/m <sup>2</sup>	ISO 180/1U
Izod notched impact strength, +23°C	12 / -	kJ/m <sup>2</sup>	ISO 180/1A

<b>ASTM Data</b>			
Tensile Modulus	5380 / 4200	MPa	ASTM D 638
Tensile Strength	122 / 95.8	MPa	ASTM D 638
Elongation at Break	3.4 / 5.3	%	ASTM D 638
Compressive Strength	100 / -	MPa	ASTM D 695
Flexural Modulus	4410 / 3450	MPa	ASTM D 790
Flexural Strength	165 / 115	MPa	ASTM D 790
Izod Impact notched, 1/8 in	91 / 80	J/m	ASTM D 256
Izod Impact unnotched, 1/8 in	850 / -	J/m	ASTM D 256

Thermal properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Melting temperature, 10°C/min	305 / *	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	251 / *	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	298 / *	°C	ISO 75-1/-2

<b>ASTM Data</b>			
Melting Temperature	305	°C	ASTM D 3418

Other properties	dry / cond	Unit	Test Standard
Density	1220 / -	kg/m <sup>3</sup>	ISO 1183
Water Absorption, 24hr	0.2	%	ASTM D 570

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	110	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.045	%	-
Melt temperature	321 - 335	°C	-
Mold temperature	66 - 93	°C	-
Zone 1	316 - 324	°C	-
Zone 2	327 - 332	°C	-
Injection speed	76 - 102	mm/s	-

**Characteristics****Processing**

Injection Molding

**Delivery form**

Pellets, Black

**Special Characteristics**

High impact or impact modified, Heat stabilized or stable to heat

**Additives**

Lubricants, Release agent

**Applications**

Automotive, IT / Business Machine, Electrical and Electronical,  
General Purpose

**Regional Availability**

North America, Europe, Asia Pacific, South and Central America,  
Near East/Africa