

# Amodel® AFA-6145 V0 Z

## polyphthalamide

Amodel® AFA-6145 V0 Z is a 45% glass-fiber reinforced, flame retardant grade of polyphthalamide (PPA) resin specifically formulated for connector applications requiring compatibility with both infrared and vapor phase soldering operations typically used by the electronics industry.

- Black: AFA-6145 V0 Z BK 324
- Natural: AFA-6145 V0 Z NT

Amodel® AFA-6145 V0 Z offers high flow and short molding cycles, thereby enhancing molding productivity and lowering costs.

### General

Material Status	• Commercial: Active	
Availability	• Africa & Middle East • Asia Pacific • Europe	• Latin America • North America
Filler / Reinforcement	• Glass Fiber, 45% Filler by Weight	
Additive	• Flame Retardant	
Features	• Chemical Resistant • Flame Retardant • Good Dimensional Stability • Good Electrical Properties	• Good Stiffness • High Flow • High Strength • Hot Water Moldability
Uses	• Automotive Applications • Automotive Electronics • Automotive Under the Hood • Cell Phones	• Connectors • Housings • Industrial Applications • Industrial Parts
RoHS Compliance	• RoHS Compliant	
Automotive Specifications	• ASTM D6779 PA104G45	
Appearance	• Black	• Natural Color
Forms	• Pellets	
Processing Method	• Water-Heated Mold Injection Molding	

Physical	Typical Value	Unit	Test method
Density	1.80	g/cm <sup>3</sup>	ISO 1183/A
Molding Shrinkage			ASTM D955
Flow	0.20	%	
Across Flow	0.40	%	

Mechanical	Typical Value	Unit	Test method
Tensile Strength (Break)	193	MPa	ASTM D638
Tensile Elongation (Break)	1.5	%	ASTM D638
Flexural Modulus	15500	MPa	ASTM D790
Flexural Strength	276	MPa	ASTM D790

Impact	Typical Value	Unit	Test method
Notched Izod Impact	110	J/m	ASTM D256

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Thermal	Typical Value	Unit	Test method
Deflection Temperature Under Load 1.8 MPa, Unannealed	277	°C	ASTM D648
Peak Melting Temperature	310	°C	ASTM D3418
Electrical	Typical Value	Unit	Test method
Surface Resistivity	1.0E+13	ohms	ASTM D257
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257
Dielectric Strength (1.59 mm)	23	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	4.10		ASTM D150
Dissipation Factor (1 MHz)	0.011		ASTM D150
Comparative Tracking Index (CTI)	PLC 1		UL 746
High Amp Arc Ignition (HAI)			UL 746
0.75 mm	PLC 1		
1.5 mm	PLC 1		
3.0 mm	PLC 1		
Hot-wire Ignition (HWI)			UL 746
0.75 mm	PLC 0		
1.5 mm	PLC 0		
3.0 mm	PLC 0		
Flammability	Typical Value	Unit	Test method
Flame Rating <sup>1</sup> (0.79 mm)	V-0		UL 94

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Injection	Typical Value	Unit
Drying Temperature	120	°C
Drying Time	4.0	hr
Suggested Max Moisture	0.030 to 0.060	%
Rear Temperature	316 to 324	°C
Front Temperature	327 to 332	°C
Processing (Melt) Temp	321 to 338	°C
Mold Temperature	66 to 93	°C
Injection Rate	Fast	

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### Injection Notes

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Injection Rate: 3 to 4 in/sec

Adjust holding pressure to 1/2 injection pressure.

Set hold time to maximize part weight.

A general purpose screw is recommended, with minimum back pressure.

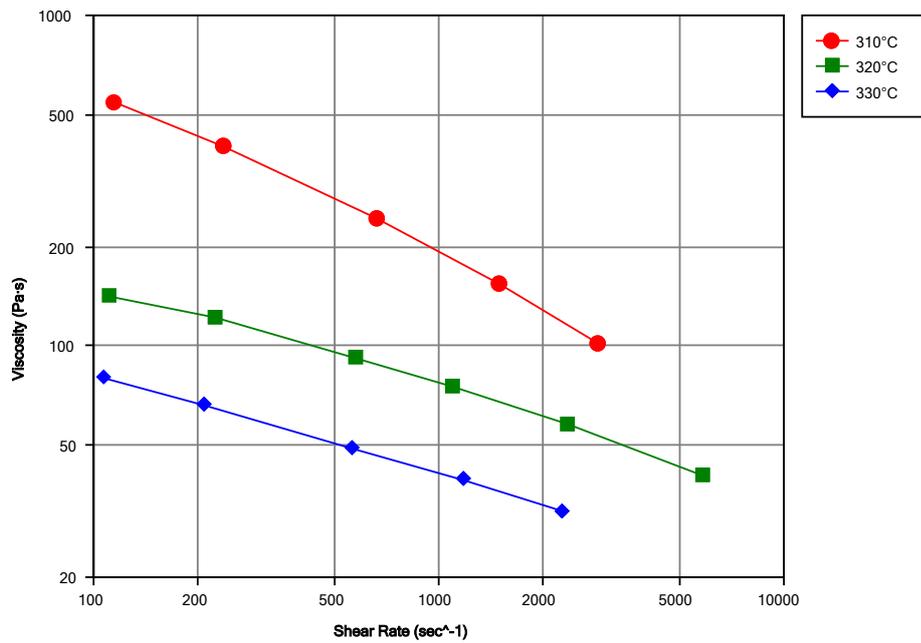
### Storage:

- 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.
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## Viscosity vs. Shear Rate (ISO 11403-2)



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### Notes

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

<sup>1</sup> This flammability rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

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**[www.solvay.com](http://www.solvay.com)**

[SpecialtyPolymers.EMEA@solvay.com](mailto:SpecialtyPolymers.EMEA@solvay.com) | Europe, Middle East and Africa

[SpecialtyPolymers.Americas@solvay.com](mailto:SpecialtyPolymers.Americas@solvay.com) | Americas

[SpecialtyPolymers.Asia@solvay.com](mailto:SpecialtyPolymers.Asia@solvay.com) | Asia and Australia

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