

## Amodel® FC-1140 L polyphthalamide

Amodel® FC-1140 L is an FDA compliant, 40% glass fiber reinforced resin designed for high strength, stiffness and improved demolding properties. This combines with its excellent thermal properties, low water absorption and good hydrolytic stability to make it particularly suited for components used in food service and consumer applications such as coffee machines and ovens.

- Black: FC-1140 L BK 946
- Black: FC-1140 L BK 302
- Natural: FC-1140 L NT
- Anthracite grey: FC-1140 L GY001

### General

Material Status	• Commercial: Active	
Availability	• Africa & Middle East • Asia Pacific • Europe	• Latin America • North America
Filler / Reinforcement	• Glass Fiber, 40% Filler by Weight	
Features	• Chemical Resistant • Chlorine Resistant • Creep Resistant • Good Dimensional Stability • High Stiffness	• High Strength • High Temperature Strength • Low Moisture Absorption • Lubricated
Uses	• Appliances • Consumer Applications • Filters • Housings	• Industrial Applications • Plumbing Parts • Pump Parts • Valves/Valve Parts
Agency Ratings	• EU 10/2011	• FDA 21 CFR 176.170(c)
RoHS Compliance	• RoHS Compliant	
Appearance	• Black	• Natural Color
Forms	• Pellets	
Processing Method	• Injection Molding	

Physical	Typical Value	Unit	Test method
Density	1.56	g/cm <sup>3</sup>	ISO 1183/A
Molding Shrinkage			ASTM D955
Flow : 1.00 mm <sup>1</sup>	0.18	%	
Flow : 1.00 mm <sup>2</sup>	0.16	%	
Flow : 2.00 mm <sup>1</sup>	0.25	%	
Flow : 2.00 mm <sup>2</sup>	0.21	%	
Across Flow : 1.00 mm <sup>1</sup>	0.57	%	
Across Flow : 1.00 mm <sup>2</sup>	0.50	%	
Across Flow : 2.00 mm <sup>1</sup>	0.54	%	
Across Flow : 2.00 mm <sup>2</sup>	0.48	%	

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Mechanical	Typical Value	Unit	Test method
Tensile Modulus	15300	MPa	ISO 527-1
Tensile Stress (Break, 23°C)	260	MPa	ISO 527-2
Tensile Strain (Break, 23°C)	2.2	%	ISO 527-2
Flexural Modulus (23°C)	14700	MPa	ISO 178
Flexural Stress	360	MPa	ISO 178
Flexural Strain (23°C)	2.60		ISO 178

Impact	Typical Value	Unit	Test method
Charpy Notched Impact Strength	10	kJ/m <sup>2</sup>	ISO 179
Charpy Unnotched Impact Strength	81	kJ/m <sup>2</sup>	ISO 179

Thermal	Typical Value	Unit	Test method
Deflection Temperature Under Load 1.8 MPa, Unannealed	297	°C	ISO 75-2/Af

Injection	Typical Value	Unit
Drying Temperature	120	°C
Drying Time	4.0	hr
Suggested Max Moisture	0.030 to 0.060	%
Rear Temperature	315 to 330	°C
Middle Temperature	320 to 340	°C
Front Temperature	325 to 345	°C
Processing (Melt) Temp	320 to 345	°C
Mold Temperature	150	°C

### Injection Notes

#### Mold Temperature:

- Minimum mold temperature for typical article thickness is 150°C (302°F). Higher tool temperature might be required for thin wall sections.

#### 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.

## Notes

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

<sup>1</sup> Pressure = 500 bar

<sup>2</sup> Pressure = 750 bar

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