

EnCom PPE-PA 290

Polyamide + PPE

EnCom, Inc.

Message:

PPE / PA Alloy

General Information			
Uses	Automotive Applications		
Appearance	Black		
	Grey		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.08	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (280°C/2.16 kg)	4.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	1.0	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	55.2	MPa	ASTM D638
Flexural Modulus	2070	MPa	ASTM D790
Flexural Strength (Yield)	86.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	210	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	143	°C	
1.8 MPa, Unannealed	124	°C	
Injection	Nominal Value	Unit	
Drying Temperature	93.3 to 107	°C	
Drying Time	2.0 to 4.0	hr	
Drying Time, Maximum	7.0	hr	
Suggested Max Moisture	5.0E-4	%	
Suggested Shot Size	40 to 75	%	
Rear Temperature	260 to 299	°C	
Middle Temperature	266 to 299	°C	
Front Temperature	271 to 299	°C	
Nozzle Temperature	277 to 299	°C	
Processing (Melt) Temp	277 to 299	°C	
Mold Temperature	65.6 to 121	°C	

Back Pressure	0.172 to 0.689	MPa
Screw Speed	20 to 100	rpm
Vent Depth	0.038 to 0.076	mm

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