Generic PPE+PS+Nylon

Polyphenylene Ether + PS + Nylon

Generic

Message:

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General Information			
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.07 - 1.12	g/cm³	ASTM D792
23°C	1.07 - 1.25	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (280°C/5.0 kg)	8.0 - 21	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (280°C/5.0 kg)	7.50 - 19.0	cm³/10min	ISO 1133
Molding Shrinkage			ASTM D955
Flow: 23°C	1.2 - 1.8	%	ASTM D955
Transverse flow: 23°C	1.1 - 1.3	%	ASTM D955
Water Absorption			
23°C, 24 hr	0.39 - 0.60	%	ASTM D570
Saturated, 23°C	3.5 - 4.2	%	ISO 62
Equilibrium, 23°C, 50% RH	1.2	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness	75.0 - 90.0	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
23°C	1820 - 3320	MPa	ASTM D638
23°C	2000 - 3050	MPa	ISO 527-2
Tensile Strength			
Yield, 23°C	53.5 - 65.6	MPa	ASTM D638
Yield, 23°C	50.0 - 65.2	MPa	ISO 527-2
Fracture, 23°C	49.8 - 60.2	MPa	ASTM D638
Fracture, 23°C	45.0 - 55.5	MPa	ISO 527-2
Tensile Elongation			
Yield, 23°C	4.7 - 5.0	%	ASTM D638
Yield, 23°C	3.5 - 5.1	%	ISO 527-2
Fracture, 23°C	2.2 - 100	%	ASTM D638
Fracture, 23°C	2.8 - 51	%	ISO 527-2
Flexural Modulus			
23°C	1840 - 2730	MPa	ASTM D790
23°C	1860 - 2850	MPa	ISO 178

Flexural Strength			
23°C	73.5 - 85.7	MPa	ASTM D790
23°C	70.0 - 103	MPa	ISO 178
Yield, 23°C	74.7 - 99.3	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength (23°C)	11 - 55	kJ/m^2	ISO 179
Notched Izod Impact			
23°C	73 - 680	J/m	ASTM D256
23°C	9.5 - 55	kJ/m^2	ISO 180
Instrumented Dart Impact (23°C)	4.00 - 60.0	J	ASTM D3763
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			
0.45 MPa, not annealed	154 - 196	°C	ASTM D648
0.45 MPa, not annealed	174 - 193	°C	ISO 75-2/B
1.8 MPa, not annealed	83.9 - 197	°C	ASTM D648
Vicat Softening Temperature			
--	178 - 233	°C	ASTM D1525
--	169 - 246	°C	ISO 306
Linear thermal expansion coefficient			
Flow	7.5E-5 - 9.8E-5	cm/cm/°C	ASTM E831
Flow	8.0E-5 - 1.0E-4	cm/cm/°C	ISO 11359-2
Lateral	5.9E-5 - 1.0E-4	cm/cm/°C	ASTM E831
Lateral	8.9E-5 - 9.1E-5	cm/cm/°C	ISO 11359-2
Thermal Conductivity (23°C)	0.23 - 0.24	W/m/K	ISO 8302
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity (23°C)	4.0E+3 - 1.1E+15	ohms·cm	ASTM D257
Relative Permittivity (23°C)	3.17		IEC 60250
Dissipation Factor (23°C)	0.024 - 0.072		IEC 60250
Injection	**Nominal Value**	**Unit**	
Drying Temperature	99.7 - 110	°C	
Drying Time	2.5 - 3.5	hr	
Drying Time, Maximum	8.0	hr	
Suggested Max Moisture	0.069 - 0.070	%	
Suggested Shot Size	40	%	
Hopper Temperature	70.0 - 70.5	°C	
Rear Temperature	269 - 280	°C	
Middle Temperature	275 - 292	°C	
Front Temperature	279 - 306	°C	
Nozzle Temperature	281 - 295	°C	
Processing (Melt) Temp	282 - 305	°C	
Mold Temperature	78.1 - 100	°C	
Back Pressure	0.847 - 0.862	MPa	

Screw Speed	60	rpm

Injection instructions

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Recommended distributors for this material

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