Generic PPE+PS+Nylon - Glass Fiber

Polyphenylene Ether + PS + Nylon

Generic

Message:

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General Information			
Filler / Reinforcement	Glass fiber reinforced material		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity			
--	1.16 - 1.37	g/cm³	ASTM D792
23°C	1.16 - 1.38	g/cm³	ISO 1183
Molding Shrinkage			ASTM D955
Flow: 23°C	0.23 - 0.91	%	ASTM D955
Transverse flow: 23°C	0.72 - 0.98	%	ASTM D955
Water Absorption			
23°C, 24 hr	0.50 - 0.51	%	ASTM D570
Saturated, 23°C	3.7 - 4.0	%	ISO 62
Equilibrium, 23°C, 50% RH	0.49 - 1.2	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus			
23°C	3570 - 12000	MPa	ASTM D638
23°C	4810 - 12100	MPa	ISO 527-2
Tensile Strength			
Yield, 23°C	84.0 - 185	MPa	ASTM D638
Yield, 23°C	86.0 - 185	MPa	ISO 527-2
Fracture, 23°C	85.4 - 185	MPa	ASTM D638
Fracture, 23°C	85.0 - 188	MPa	ISO 527-2
Tensile Elongation			
Yield, 23°C	3.0 - 3.1	%	ASTM D638, ISO 527-2
Fracture, 23°C	3.0 - 12	%	ASTM D638
Fracture, 23°C	2.8 - 7.0	%	ISO 527-2
Flexural Modulus			
23°C	3790 - 9400	MPa	ASTM D790
23°C	4540 - 9460	MPa	ISO 178
Flexural Stress			
23°C	144 - 271	MPa	ISO 178
Yield, 23°C	141 - 270	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**

Charpy Notched Impact Strength (23°C)	7.0 - 11	kJ/m²	ISO 179
Notched Izod Impact			
23°C	79 - 85	J/m	ASTM D256
23°C	6.9 - 10	kJ/m²	ISO 180
Instrumented Dart Impact (23°C)	9.87 - 17.0	J	ASTM D3763
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			
0.45 MPa, not annealed	214 - 254	°C	ASTM D648
0.45 MPa, not annealed	215 - 241	°C	ISO 75-2/B
1.8 MPa, not annealed	200 - 242	°C	ASTM D648
Vicat Softening Temperature			
--	210 - 249	°C	ASTM D1525
--	209 - 246	°C	ISO 306
Linear thermal expansion coefficient			
Flow	2.2E-5 - 5.1E-5	cm/cm/°C	ASTM E831
Flow	2.2E-5 - 4.2E-5	cm/cm/°C	ISO 11359-2
Lateral	7.4E-5 - 8.0E-5	cm/cm/°C	ASTM E831, ISO 11359-2
Injection	**Nominal Value**	**Unit**	
Drying Temperature	100 - 101	°C	
Drying Time	3.4 - 3.5	hr	
Drying Time, Maximum	8.0	hr	
Suggested Max Moisture	0.070	%	
Suggested Shot Size	40	%	
Rear Temperature	284 - 285	°C	
Middle Temperature	287 - 288	°C	
Front Temperature	290 - 291	°C	
Nozzle Temperature	293 - 294	°C	
Processing (Melt) Temp	290 - 294	°C	
Mold Temperature	98.5 - 99.4	°C	
Back Pressure	0.853 - 0.862	MPa	

Injection instructions

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