

Edgetek™ MP-10GF/000 BLACK

Polyphenylene Ether + PS

PolyOne Corporation

Message:

Edgetek™MP-10GF/000 BLACK is a polyphenylene ether + PS (PPE + PS) product, which contains a 10% glass fiber reinforced material. It can be processed by injection molding and is available in the Asia-Pacific region. The main characteristics are: flame retardant/rated flame.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 10% filler by weight		
Appearance	Black		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.13	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow	0.30	%	ASTM D955
Transverse flow	0.50	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	4140	MPa	ASTM D638
Tensile Strength ²	85.0	MPa	ASTM D638
Tensile Elongation ³ (Break)	5.0	%	ASTM D638
Flexural Modulus ⁴	4000	MPa	ASTM D790
Flexural Strength ⁵	165	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	110	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	128	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	HB		Internal method
Injection	Nominal Value	Unit	
Drying Temperature	90.0 - 100	°C	
Drying Time	3.0 - 4.0	hr	
Rear Temperature	270 - 300	°C	
Middle Temperature	270 - 300	°C	
Front Temperature	270 - 300	°C	
Mold Temperature	65.0 - 95.0	°C	
Injection instructions			
Injection Pressure: MED-HIGHHold Pressure: MED-HIGHScrew Speed: MODERATEBack Pressure: LOW			
NOTE			

1.	5.0 mm/min
2.	5.0 mm/min
3.	5.0 mm/min
4.	1.3 mm/min
5.	1.3 mm/min

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

