

SEPAZ™ VL140

Polyphthalamide

Mando Advanced Materials Co., Ltd.

Message:

SEPAZ™VL140 is a polyxylylene amide (PPA) product. It is available in the Asia-Pacific region. The main characteristics are: flame retardant/rated flame.

General Information			
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.60	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow	0.50	%	ASTM D955
Transverse flow	0.60	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.20	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break)	108	MPa	ASTM D638
Tensile Elongation ² (Break)	1.5	%	ASTM D638
Flexural Modulus ³	7160	MPa	ASTM D790
Flexural Strength ⁴	160	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	29	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	306	°C	ASTM D648
1.8 MPa, not annealed	255	°C	ASTM D648
Peak Melting Temperature	320	°C	ASTM D3418
Flammability	Nominal Value		Test Method
Flame Rating	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	90.0 - 110	°C	
Drying Time	4.0 - 5.0	hr	
Rear Temperature	300 - 320	°C	
Middle Temperature	305 - 325	°C	
Front Temperature	310 - 330	°C	
Nozzle Temperature	310 - 330	°C	
Processing (Melt) Temp	310 - 330	°C	
Mold Temperature	70.0 - 100	°C	
Injection instructions			
Injection Speed: 40 to 70%Injection Pressure - 1st: 20 to 50%Injection Pressure - 2nd: 20 to 50%Injection Pressure - Back Pressure: 0 to 20%			
NOTE			
1.	5.0 mm/min		

2.	5.0 mm/min
3.	3.0 mm/min
4.	3.0 mm/min

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