

XYRON™ X604H

Polyphenylene Ether + PS
Asahi Kasei Chemicals Corporation

Message:
Modified PPE
40% Filler reinforced Non-Flame retardant
Stiffness High, Warpage Ultra-Low

General Information			
UL YellowCard	E82268-250949		
Filler / Reinforcement	Filler,40% Filler by Weight		
Features	High Stiffness		
	Low Warpage		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.40	g/cm ³	ISO 1183
Molding Shrinkage ¹ (2.00 mm)	0.15 to 0.30	%	Internal Method
Water Absorption (23°C, 24 hr)	0.060	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield, 23°C)	63.0	MPa	ISO 527-2
Tensile Strain (Break, 23°C)	2.0	%	ISO 527-2
Flexural Modulus (23°C)	7140	MPa	ISO 178
Flexural Stress (23°C)	109	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ² (23°C)	3.0	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed	130	°C	ASTM D648
1.8 MPa, Unannealed	128	°C	ISO 75-2/A
CLTE - Flow (-30 to 65°C)	3.0E-5	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+16	ohms	IEC 60093
Volume Resistivity (23°C)	1.0E+16	ohms · cm	IEC 60093
Dielectric Constant			IEC 60250
100 Hz	3.40		
1 MHz	3.30		
Dissipation Factor			IEC 60250
100 Hz	7.0E-3		
1 MHz	9.0E-3		
Flammability	Nominal Value	Unit	Test Method

Flame Rating (0.750 mm)	HB	UL 94
Injection	Nominal Value	Unit
Drying Temperature	90.0 to 100	°C
Drying Time	2.0 to 4.0	hr
Processing (Melt) Temp	260 to 300	°C
Mold Temperature	60.0 to 100	°C
NOTE		
1.	150x150x2 mm	
2.	4 mm	

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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

