

【Inquiries】

AsahiKASEI Engineering Plastics Information Comprehensive Site

URL : <https://www.asahi-kasei-plastics.com/en/contact/>

AsahiKASEI



XYRON™ X604H

Asahi Kasei Corporation - Polyphenylene Ether + PS

Wednesday, February 28, 2024

General Information

Product Description

Modified PPE

40% Filler reinforced Non-Flame retardant

Stiffness High, Warpage Ultra-Low

General

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Asia Pacific • Europe • North America
Filler / Reinforcement	• Glass Flake, 40% Filler by Weight
Features AKEP website	• Warpage, Low
Processing Method	• Injection Molding
Part Marking Code (ISO11469) (ISO 11469)	• >PPE+PS-GS40<

Other Documentation

Literature	• Molding Conditions • SDS • Technical Handbook
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ASTM & ISO Properties¹

Physical	Nominal Value	Unit	Test Method
Density	1.38	g/cm ³	ISO 1183
Molding Shrinkage ² (2.00 mm)	0.17 to 0.27	%	Internal Method
Water Absorption (24 hr, 23°C)	0.060	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield, 23°C)	56.0	MPa	ISO 527
Tensile Strain (Break, 23°C)	3.0	%	ISO 527
Flexural Modulus (23°C)	6200	MPa	ISO 178
Flexural Stress (23°C)	106	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³ (23°C)	4.0	kJ/m ²	ISO 179

Disclaimer:

- Data shown are typical values obtained by proper testing methods and should not be used for specification purpose. Please use these data for selecting the most appropriate grade suitable for specific usage.

These data may be changed because of improvement in properties.

- Be sure to read the relevant SDS before handling and use, and always follow the Important Precautions.

- Do not use plastics in any of the following orally- or medically-related applications.

- Orally-related applications: any part, device or component which may come into direct oral contact or into direct contact with drinking foods or beverages.

For drinking water application, please consult Asahi Kasei Corporation.

- Medically-related applications: any part, device or component which may be used intracorporeally or which may in dialysis or other processes come into direct or indirect contact with body tissue, body fluids or transfusion fluids.

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Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 1.8 MPa, Unannealed	124	°C	ISO 75-2/A
CLTE			ISO 11359-2
Flow : -30 to 65°C	3.2E-5	cm/cm/°C	
Transverse : -30 to 65°C	4.9E-5	cm/cm/°C	
Heat Deflection Temperature - (1.8MPa, Unannealed)	130	°C	ASTM D648
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 (0.75 mm)	HB		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature - Hot Air Dryer	90 to 100	°C
Drying Time - Hot Air Dryer	2.0 to 4.0	hr
Processing (Melt) Temp	260 to 300	°C
Mold Temperature	60 to 100	°C

Notes

¹ Typical properties: these are not to be construed as specifications.

² 150x150x2 mm

³ 4 mm

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