

WeConnectScience



XR404-G

Description

XR404-G has well-balanced properties with high heat, targeted for injection molding

Key Features

High Heat Resistance, Paintability

Properties	Condition	Method	Unit	XR404-G
Physical				
Specific Gravity	23°C	ASTM D792		1.05
Mold Shrinkage	23°C, 3.2mm	ASTM D955	%	0.4 ~ 0.7
Melt Flow Index	220°C, 10kg	ASTM D1238	g/10min	8
Mechanical				
Tensile Strength at Yield	23°C, 50mm/min, 3.2mm	ASTM D638	MPa	47
Tensile Elongation at Break	23°C, 50mm/min, 3.2mm	ASTM D638	%, (Min)	15
Flexural Strength	23°C, 15mm/min, 3.2mm	ASTM D790	MPa	73
Flexural Modulus	23°C, 15mm/min, 3.2mm	ASTM D790	MPa	2600
Izod Impact Strength	Notched, 3.2mm, 23°C	ASTM D256	J/m	105
Izod Impact Strength	Notched, 6.4mm, 23°C	ASTM D256	J/m	130
Rockwell Hardness	R-Scale	ASTM D785		109
Thermal				
Heat Deflection Temperature	Edgewise, 1.82MPa, 6.4mm, Unannealed	ASTM D648	°C	102
Vicat Softening Temperature	50N, 50°C/h	ASTM D1525	°C	112
Flammability	1.5mm	UL 94		HB
Flammability	3.0mm	UL 94		HB
Relative Temperature Index(RTI)	Electrical	UL746B	°C	60
Relative Temperature Index(RTI)	Mechanical with Impact	UL746B	°C	60
Relative Temperature Index(RTI)	Mechanical without Impact	UL746B	°C	60

Note

Typical values can be used only for the purpose of selecting material, and there can be variation within normal tolerances for various colors.

Values given should not be interpreted as specification and not be used for designing part or tool.

All properties, except melt flow index are measured by injection molded specimens after 48 hours storage at 23°C, 50% relative humidity.

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Processing Guide (Injection Molding)

Processing Parameters	Unit	Value
Drying Temperature	°C	80 ~ 90
Drying Time	hrs	3 ~ 4
Injection Temperature	°C	220 ~ 250
Mold Temperature	°C	40 ~ 60
Screw Speed	rpm	Low speed

Note

Injection Temperature & Screw Speed are only mentioned as general guidelines.

These may not apply or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding.

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