



PRODUCT INFORMATION

Material: Modified-PPO
Grade: PPX-SF2
Description: Structural Foam Grade, Standard Flow

Effective Date: June-03

TYPICAL PROPERTIES	VALUE	UNIT	TEST METHOD
Physical*			
Melt Flow Rate 250C/11.6kg	25-45	g/10 min	ASTM D1238
Specific Gravity	1.09		ASTM D792
Mold Shrinkage	6-9	E-3 in/in	ASTM D955
Mechanical*			
Tensile Strength, Break	7,500	psi	ASTM D638
Tensile Strength, Yield	7,600	psi	ASTM D638
Flexural Strength	12,000	psi	ASTM D790
Flexural Modulus	350	psi x 1000	ASTM D790
Impact*			
Notched Izod Impact Strength	3.0	ft-lb/in.	ASTM D256
Gardner Falling Dart Impact (minimum)	NA	in-lbs.	ASTM D3029
Thermal*			
HDT @ 66 psi	220	°F	ASTM D648
HDT @ 264 psi	210	°F	ASTM D648
Flammability			
UL File Number, USA	not listed		
UL 94 rating	V-0 (6.0 mm)		

* All physical, mechanical and thermal testing conducted on 1/8-inch thick, un-pigmented, test samples. Nylon grades are tested dry as molded(DAM) and foam grades tested with un-foamed parts.

TYPICAL PROCESSING CONDITIONS

Processing Method: Foam Molding			
Drying Temperature	160-180	°F	
Drying Time	3-4	Hours	Do not exceed 8 hours
Melt Temperature	520-580	°F	
Mold Temperature	150-180	°F	
Front Zone	520-580	°F	
Middle Zone	520-580	°F	
Rear Zone	450-500	°F	

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