



**PRODUCT INFORMATION**

**Material:** Modified-PPO  
**Grade:** PPX-FR1  
**Description:** UL 94 V-0 with HDT of 190 F

**Effective Date:** June-03

| TYPICAL PROPERTIES                    | VALUE           | UNIT       | TEST METHOD |
|---------------------------------------|-----------------|------------|-------------|
| <b>Physical*</b>                      |                 |            |             |
| Melt Flow Rate 250C/11.6kg            | 25-50           | g/10 min   | ASTM D1238  |
| Specific Gravity                      | 1.08            |            | ASTM D792   |
| Mold Shrinkage                        | 5-7             | E-3 in/in  | ASTM D955   |
| <b>Mechanical*</b>                    |                 |            |             |
| Tensile Strength, Break               | 6,000           | psi        | ASTM D638   |
| Tensile Strength, Yield               | 6,500           | psi        | ASTM D638   |
| Flexural Strength                     | 8,000           | psi        | ASTM D790   |
| Flexural Modulus                      | 300             | psi x 1000 | ASTM D790   |
| <b>Impact*</b>                        |                 |            |             |
| Notched Izod Impact Strength          | 5.0             | ft-lb/in.  | ASTM D256   |
| Gardner Falling Dart Impact (minimum) | 150             | in-lbs.    | ASTM D3029  |
| <b>Thermal*</b>                       |                 |            |             |
| HDT @ 66 psi                          | 190             | °F         | ASTM D648   |
| HDT @ 264 psi                         | 180             | °F         | ASTM D648   |
| <b>Flammability</b>                   |                 |            |             |
| UL File Number, USA                   | E113219         |            |             |
| UL 94 rating                          | V-0 (0.125 in)  |            |             |
|                                       | V-0 (0.0625 in) |            |             |

\* 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**

| <b>Processing Method: Injection Molding</b> |         |       |                       |
|---|---------|-------|-----------------------|
| Drying Temperature                          | 160-180 | °F    |                       |
| Drying Time                                 | 3-4     | Hours | Do not exceed 8 hours |
| Melt Temperature                            | 475-525 | °F    |                       |
| Mold Temperature                            | 130-170 | °F    |                       |
| Front Zone                                  | 460-530 | °F    |                       |
| Middle Zone                                 | 440-520 | °F    |                       |
| Rear Zone                                   | 420-510 | °F    |                       |

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