



PRODUCT INFORMATION

Material: Modified-PPO
Grade: PPX-EN-FR3
Description: UL 94 V-1 with HDT of 265 F, Extrusion Grade

Effective Date: June-03

TYPICAL PROPERTIES	VALUE	UNIT	TEST METHOD
Physical*			
Melt Flow Rate 250C/11.6kg	4-8	g/10 min	ASTM D1238
Specific Gravity	1.06		ASTM D792
Mold Shrinkage	5-7	E-3 in/in	ASTM D955
Mechanical*			
Tensile Strength, Break	9,000	psi	ASTM D638
Tensile Strength, Yield	9,300	psi	ASTM D638
Flexural Strength	13,000	psi	ASTM D790
Flexural Modulus	350	psi x 1000	ASTM D790
Impact*			
Notched Izod Impact Strength	4.0	ft-lb/in.	ASTM D256
Gardner Falling Dart Impact (minimum)	150	in-lbs.	ASTM D3029
Thermal*			
HDT @ 66 psi	265	°F	ASTM D648
HDT @ 264 psi	250	°F	ASTM D648
Flammability			
UL File Number, USA	E113219		
UL 94 rating	V-1 (0.125 in)		
	V-1 (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

Processing Method: Extrusion			
Drying Temperature	220-230	°F	
Drying Time	3-4	Hours	Do not exceed 8 hours
Melt Temperature	450-500	°F	
Mold Temperature		°F	
Front Zone		°F	
Middle Zone		°F	
Rear Zone		°F	

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