

**PRODUCT INFORMATION****Material:** Modified-PPO**Effective Date:** June-03**Grade:** PPX-SF1**Description:** Structural Foam Grade, Easy Flow

TYPICAL PROPERTIES	VALUE	UNIT	TEST METHOD
<b>Physical*</b>			
Melt Flow Rate 250C/11.6kg	30-50	g/10 min	ASTM D1238
Specific Gravity	1.12		ASTM D792
Mold Shrinkage	6-9	E-3 in/in	ASTM D955
<b>Mechanical*</b>			
Tensile Strength, Break	9,000	psi	ASTM D638
Tensile Strength, Yield	9,200	psi	ASTM D638
Flexural Strength	12,000	psi	ASTM D790
Flexural Modulus	460	psi x 1000	ASTM D790
<b>Impact*</b>			
Notched Izod Impact Strength	2.0	ft-lb/in.	ASTM D256
Gardner Falling Dart Impact (minimum)	NA	in-lbs.	ASTM D3029
<b>Thermal*</b>			
HDT @ 66 psi	220	°F	ASTM D648
HDT @ 264 psi	210	°F	ASTM D648
<b>Flammability</b>			
UL File Number, USA	<a href="#">E113219</a>		
UL 94 rating	5VA (3.8 mm) V-0 (3 mm)		

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

Nylon grades are

**TYPICAL PROCESSING CONDITIONS****Processing Method: Foam Molding**

Drying Temperature	160-180	°F	
Drying Time	3-4	Hours	Do not exceed 8 hours
Melt Temperature	500-550	°F	
Mold Temperature	100-180	°F	
Front Zone	520-580	°F	
Middle Zone	520-580	°F	
Rear Zone	450-500	°F	

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