

XYRON™ XP640

Asahi Kasei Corporation - Polyphthalamide + PPE

General Information

Product Description

Modified PPE
PPA/PPE alloy
40% Filler reinforced
Flame retardant HB
High heat resistance

General

Filler / Reinforcement	• Glass Fiber, 40% Filler by Weight
Additive	• Flame Retardant
Features AKEP website	• Dimensional Stability, Good
Forms	• Pellets
Processing Method	• Injection Molding
Part Marking Code (ISO11469) (ISO 11469)	• >PPA+PPE-GF40<

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.45	g/cm ³	ISO 1183
Molding Shrinkage (2.00 mm)	0.30 to 0.80	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	173	MPa	ISO 527
Tensile Strain (Break)	2.0	%	ISO 527
Flexural Modulus	12500	MPa	ISO 178
Flexural Stress	257	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	10	kJ/m ²	ISO 179



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Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 1.8 MPa, Unannealed	274	°C	ISO 75-2/A
CLTE			ISO 11359-2
Flow : -30 to 65°C	1.4E-5	cm/cm/°C	
Transverse : -30 to 65°C	5.4E-5	cm/cm/°C	
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.75 mm)	HB		UL 94

Processing Information			
Injection	Nominal Value	Unit	
Drying Temperature - Hot Air Dryer	110 to 120	°C	
Drying Time - Hot Air Dryer	3.0 to 4.0	hr	
Processing (Melt) Temp	320 to 340	°C	
Mold Temperature	130 to 150	°C	

Notes

¹ Typical properties: these are not to be construed as specifications.

