

XYRON™ X7744

Asahi Kasei Corporation - Polyphenylene Ether + PS

General Information

Product Description

Modified PPE
35% Filler reinforced Flame retardant V-1
Stiffness High, Warpage Low

General

Filler / Reinforcement	• Glass Fiber\Mineral, 35% Filler by Weight
Additive	• Flame Retardant
Features AKEP website	• Flame Retardant • Halogen Free • Warpage, Low
Processing Method	• Injection Molding
Part Marking Code (ISO11469) (ISO 11469)	• >PPE+PS-(GF+PS)35FR(40)<

Other Documentation

Literature	• Moldflow Data • Molding Conditions • SDS • Technical Handbook
------------	--

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.39	g/cm ³	ISO 1183
Molding Shrinkage ² (2.00 mm)	0.13 to 0.41	%	Internal Method
Water Absorption (24 hr, 23°C)	0.060	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield, 23°C)	98.0	MPa	ISO 527
Tensile Strain (Break, 23°C)	1.0	%	ISO 527
Flexural Modulus (23°C)	10900	MPa	ISO 178
Flexural Stress (23°C)	160	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³ (23°C)	6.0	kJ/m ²	ISO 179



XYRON™ X7744

Asahi Kasei Corporation - Polyphenylene Ether + PS

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 1.8 MPa, Unannealed	116	°C	ISO 75-2/A
CLTE			ISO 11359-2
Flow : -30 to 65°C	2.0E-5	cm/cm/°C	
Transverse : -30 to 65°C	5.4E-5	cm/cm/°C	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+16	ohms	IEC 60093
Volume Resistivity (23°C)	1.0E+16	ohms·cm	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.2 mm	V-1		
3.0 mm	5VB		

Processing Information

Injection	Nominal Value	Unit
Drying Temperature - Hot Air Dryer	90 to 100	°C
Drying Time - Hot Air Dryer	2.0 to 4.0	hr
Processing (Melt) Temp	250 to 300	°C
Mold Temperature	70 to 90	°C

Notes

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

² 150x150x2 mm

³ 4 mm

