

XYRON™ X404H

Asahi Kasei Corporation - Polyphenylene Ether + PS

General Information

Product Description

Modified PPE
40% Filler reinforced Non-Flame retardant
Stiffness High, Warpage Ultra-Low

General

Filler / Reinforcement	• Glass Flake, 45% Filler by Weight
Features AKEP website	• Warpage, Low
Processing Method	• Injection Molding
Part Marking Code (ISO11469) (ISO 11469)	• >PPE+PS-GS45<

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.43	g/cm ³	ISO 1183
Molding Shrinkage ² (2.00 mm)	0.15 to 0.30	%	Internal Method
Water Absorption (24 hr, 23°C)	0.060	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield, 23°C)	62.0	MPa	ISO 527
Tensile Strain (Break, 23°C)	2.0	%	ISO 527
Flexural Modulus (23°C)	8270	MPa	ISO 178
Flexural Stress (23°C)	111	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³ (23°C)	3.0	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 1.8 MPa, Unannealed	108	°C	ISO 75-2/A
CLTE - Flow (-30 to 65°C)	3.0E-5	cm/cm/°C	ISO 11359-2
Heat Deflection Temperature - (1.8MPa, Unannealed)	110	°C	ASTM D648



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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
Dielectric Constant			IEC 60250
100 Hz	3.40		
1 MHz	3.30		
Dissipation Factor			IEC 60250
100 Hz	7.0E-3		
1 MHz	9.0E-3		
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.8 mm)	HB		UL 94

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	60 to 90	°C	

Notes

- ¹ Typical properties: these are not to be construed as specifications.
- ² 150x150x2 mm
- ³ 4 mm

