

XYRON™ AT610

Asahi Kasei Corporation - Polyamide + PPE

General Information

Product Description

Modified PPE
PA/PPE alloy
Non-reinforced Non-Flame retardant

General

Features AKEP website	• Flow, High
Automotive Specifications	• GM GMP.PA66+PPE.003 Color: U7011 Black
Processing Method	• Injection Molding
Part Marking Code (ISO11469) (ISO 11469)	• >PA66+PPE<

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.10	g/cm ³	ISO 1183
Molding Shrinkage ² (3.00 mm)	1.3 to 1.4	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield, 23°C)	65.0	MPa	ISO 527
Tensile Strain (Break, 23°C)	54	%	ISO 527
Flexural Modulus (23°C)	2600	MPa	ISO 178
Flexural Stress (23°C)	101	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³ (23°C)	15	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 0.45 MPa, Unannealed	169	°C	ISO 75-2/B
CLTE			ISO 11359-2
Flow : -30 to 65°C	8.1E-5	cm/cm/°C	
Transverse : -30 to 65°C	8.4E-5	cm/cm/°C	



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Electrical	Nominal Value	Unit	Test Method
Volume Resistivity (23°C)	7.6E+15	ohms·cm	IEC 60093
Dielectric Constant			IEC 60250
100 Hz	3.10		
1 MHz	2.90		
Dissipation Factor			IEC 60250
100 Hz	5.0E-3		
1 MHz	0.011		

Processing Information		
Injection	Nominal Value	Unit
Drying Temperature - Hot Air Dryer	110 to 130	°C
Drying Time - Hot Air Dryer	2.0 to 4.0	hr
Processing (Melt) Temp	280 to 300	°C
Mold Temperature	60 to 120	°C

Injection Notes

Recommended processing (melt) temperature of XYRON™ Polyamide + PPE is 280-300°C. Lower temperatures may lead to local degradation in properties due to non-uniform plasticization, while higher temperatures tend to cause silver streaking, other appearance problems and decomposition.

Notes

- ¹ Typical properties: these are not to be construed as specifications.
- ² 120x80x3 mm
- ³ 4 mm

