

XYRON™ AT602

Asahi Kasei Corporation - Polyamide + PPE

General Information

Product Description	
Modified PPE	
PA/PPE alloy	
20% Filler reinforced Non-Flame retardant	
General	
Filler / Reinforcement	• Mineral, 20% Filler by Weight
Processing Method	• Injection Molding
Part Marking Code (ISO11469) (ISO 11469)	• >PA6+PPE-TD20<

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.26	g/cm ³	ISO 1183
Molding Shrinkage ² (3.00 mm)	0.60 to 0.70	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield, 23°C)	59.0	MPa	ISO 527
Tensile Strain (Break, 23°C)	5.0	%	ISO 527
Flexural Modulus (23°C)	4300	MPa	ISO 178
Flexural Stress (23°C)	97.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³ (23°C)	4.0	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 0.45 MPa, Unannealed	195	°C	ISO 75-2/B
CLTE			ISO 11359-2
Flow : -30 to 65°C	5.6E-5	cm/cm/°C	
Transverse : -30 to 65°C	7.3E-5	cm/cm/°C	



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Electrical	Nominal Value	Unit	Test Method
Volume Resistivity (23°C)	4.5E+15	ohms·cm	IEC 60093
Dielectric Constant			IEC 60250
100 Hz	3.30		
1 MHz	3.10		
Dissipation Factor			IEC 60250
100 Hz	7.0E-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

