

XYRON™ XP650

Asahi Kasei Corporation - Polyphthalamide + PPE

General Information
Product Description

 Modified PPE
 PPA/PPE alloy
 50% Filler reinforced
 High heat resistance

General

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Asia Pacific • North America
Filler / Reinforcement	• Mineral, 50% Filler by Weight
Features	• Good Dimensional Stability
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.56	g/cm ³	ISO 1183
Molding Shrinkage (0.0787 in)	0.17 to 0.22	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	17700	psi	ISO 527
Tensile Strain (Break)	2.0	%	ISO 527
Flexural Modulus	1.86E+6	psi	ISO 178
Flexural Stress	25400	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	1.9	ft·lb/in ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	487	°F	Internal Method
CLTE - Flow (-22 to 149°F)	8.3E-6	in/in/°F	ISO 11359-2
CLTE - Transverse (-22 to 149°F)	1.6E-5	in/in/°F	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Dielectric Constant (10.0 GHz)	4.00		SPDR
Dissipation Factor (10.0 GHz)	8.0E-3		SPDR

Processing Information

Injection	Nominal Value	Unit
Drying Temperature - Hot Air Dryer	230 to 248	°F
Drying Time - Hot Air Dryer	3.0 to 4.0	hr
Processing (Melt) Temp	608 to 644	°F
Mold Temperature	266 to 302	°F

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