

**ColorFast® FRPPO250**
*Americhem - Polyphenylene Ether*
**General Information**
**Product Description**

PPE + PS blend. Unfilled FR system

**General**

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Additive	• Flame Retardant		
Features	• Excellent Colorability	• Flame Retardant	
Uses	• Consumer Applications	• Household Goods	• Industrial Applications
Forms	• Pellets		
Processing Method	• Injection Molding		

**Properties <sup>1</sup>**

<b>Physical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Density / Specific Gravity	1.09		ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/2.16 kg)	5.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	5.0E-3 to 7.0E-3	in/in	ASTM D955
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Strength <sup>2</sup> (Yield)	8000	psi	ASTM D638
Tensile Strength <sup>2</sup> (Break)	7700	psi	ASTM D638
Tensile Elongation <sup>2</sup> (Yield)	8.0	%	ASTM D638
Tensile Elongation <sup>2</sup> (Break)	25	%	ASTM D638
Flexural Modulus <sup>2</sup>	340000	psi	ASTM D790
Flexural Strength	11500	psi	ASTM D790
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact (73°F)	5.0	ft-lb/in	ASTM D256
<b>Hardness</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Rockwell Hardness (R-Scale)	120		ASTM D785
<b>Thermal</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Deflection Temperature Under Load (66 psi, Unannealed, 0.126 in)	225	°F	ASTM D648

**Processing Information**

<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>
Drying Temperature	200	°F
Drying Time	3.0 to 4.0	hr
Drying Time, Maximum	8.0	hr
Suggested Shot Size	30 to 60	%
Rear Temperature	440 to 530	°F
Middle Temperature	460 to 540	°F
Front Temperature	460 to 540	°F
Nozzle Temperature	480 to 550	°F
Processing (Melt) Temp	500 to 550	°F
Mold Temperature	160 to 200	°F
Back Pressure	50.0 to 100	psi
Screw Speed	30 to 75	rpm

