

# EnCom GF15 PPE-PS

Polyphenylene Ether + PS

EnCom, Inc.

Message:

Molding Grade 15 % Glass Filled PPE/PS

| General Information                |                                  |                   |             |
|------------------------------------|----------------------------------|-------------------|-------------|
| Filler / Reinforcement             | Glass Fiber,15% Filler by Weight |                   |             |
| Uses                               | Automotive Applications          |                   |             |
|                                    | Business Equipment               |                   |             |
| Appearance                         | Black                            |                   |             |
|                                    | Colors Available                 |                   |             |
|                                    | Natural Color                    |                   |             |
| Forms                              | Pellets                          |                   |             |
| Processing Method                  | Injection Molding                |                   |             |
| Physical                           | Nominal Value                    | Unit              | Test Method |
| Specific Gravity                   | 1.20                             | g/cm <sup>3</sup> | ASTM D792   |
| Molding Shrinkage - Flow (3.18 mm) | 0.20 to 0.40                     | %                 | ASTM D955   |
| Water Absorption (24 hr)           | 0.10                             | %                 | ASTM D570   |
| Hardness                           | Nominal Value                    | Unit              | Test Method |
| Rockwell Hardness (L-Scale)        | 105                              |                   | ASTM D785   |
| Mechanical                         | Nominal Value                    | Unit              | Test Method |
| Tensile Strength (Yield)           | 90.7                             | MPa               | ASTM D638   |
| Tensile Elongation (Break)         | 5.0                              | %                 | ASTM D638   |
| Flexural Modulus                   | 2450                             | MPa               | ASTM D790   |
| Impact                             | Nominal Value                    | Unit              | Test Method |
| Notched Izod Impact (23°C)         | 100                              | J/m               | ASTM D256   |
| Thermal                            | Nominal Value                    | Unit              | Test Method |
| Deflection Temperature Under Load  |                                  |                   | ASTM D648   |
| 0.45 MPa, Unannealed               | 138                              | °C                |             |
| 1.8 MPa, Unannealed                | 132                              | °C                |             |
| Flammability                       | Nominal Value                    |                   | Test Method |
| Flame Rating (3.18 mm)             | V-0                              |                   | UL 94       |
| Injection                          | Nominal Value                    | Unit              |             |
| Drying Temperature                 | 98.9 to 110                      | °C                |             |
| Drying Time                        | 2.0 to 4.0                       | hr                |             |
| Drying Time, Maximum               | 7.0                              | hr                |             |
| Suggested Max Moisture             | 0.020                            | %                 |             |

|                        |                |     |
|------------------------|----------------|-----|
| Suggested Shot Size    | 40 to 75       | %   |
| Rear Temperature       | 249 to 304     | °C  |
| Middle Temperature     | 260 to 310     | °C  |
| Front Temperature      | 271 to 316     | °C  |
| Nozzle Temperature     | 282 to 316     | °C  |
| Processing (Melt) Temp | 282 to 316     | °C  |
| Mold Temperature       | 76.7 to 104    | °C  |
| Back Pressure          | 0.345 to 0.689 | MPa |
| Screw Speed            | 20 to 100      | rpm |
| Vent Depth             | 0.038 to 0.076 | mm  |

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