

# TEKAPPO™ JF2

Polyphenylene Ether + PS  
Mando Advanced Materials Co., Ltd.

Message:  
JF2 is PPO/PS unreinforced product and heat resistant chemical resistance product.

| General Information                                                                                                                          |                          |                   |             |
|----------------------------------------------------------------------------------------------------------------------------------------------|--------------------------|-------------------|-------------|
| Features                                                                                                                                     | Good chemical resistance |                   |             |
|                                                                                                                                              | Heat resistance, medium  |                   |             |
| Physical                                                                                                                                     | Nominal Value            | Unit              | Test Method |
| Specific Gravity                                                                                                                             | 1.06                     | g/cm <sup>3</sup> | ASTM D792   |
| Molding Shrinkage - Flow                                                                                                                     | 0.50 - 0.70              | %                 | ASTM D955   |
| Water Absorption (23°C, 24 hr)                                                                                                               | 0.060                    | %                 | ASTM D570   |
| Mechanical                                                                                                                                   | Nominal Value            | Unit              | Test Method |
| Tensile Strength <sup>1</sup> (Break)                                                                                                        | 71.6                     | MPa               | ASTM D638   |
| Tensile Elongation <sup>2</sup> (Break)                                                                                                      | 30                       | %                 | ASTM D638   |
| Flexural Modulus <sup>3</sup>                                                                                                                | 2650                     | MPa               | ASTM D790   |
| Flexural Strength <sup>4</sup>                                                                                                               | 113                      | MPa               | ASTM D790   |
| Impact                                                                                                                                       | Nominal Value            | Unit              | Test Method |
| Notched Izod Impact (23°C, 3.18 mm)                                                                                                          | 110                      | J/m               | ASTM D256   |
| Thermal                                                                                                                                      | Nominal Value            | Unit              | Test Method |
| Deflection Temperature Under Load                                                                                                            |                          |                   | ASTM D648   |
| 0.45 MPa, not annealed                                                                                                                       | 150                      | °C                | ASTM D648   |
| 1.8 MPa, not annealed                                                                                                                        | 145                      | °C                | ASTM D648   |
| Flammability                                                                                                                                 | Nominal Value            | Test Method       |             |
| Flame Rating                                                                                                                                 | HB                       | UL 94             |             |
| Injection                                                                                                                                    | Nominal Value            | Unit              |             |
| Drying Temperature                                                                                                                           | 100 - 110                | °C                |             |
| Drying Time                                                                                                                                  | 4.0 - 6.0                | hr                |             |
| Rear Temperature                                                                                                                             | 270 - 310                | °C                |             |
| Middle Temperature                                                                                                                           | 270 - 310                | °C                |             |
| Front Temperature                                                                                                                            | 270 - 310                | °C                |             |
| Nozzle Temperature                                                                                                                           | 280 - 320                | °C                |             |
| Processing (Melt) Temp                                                                                                                       | 280 - 310                | °C                |             |
| Mold Temperature                                                                                                                             | 60.0 - 100               | °C                |             |
| Injection instructions                                                                                                                       |                          |                   |             |
| Injection Speed: 30 to 70%Injection Pressure - 1st: 20 to 50%Injection Pressure - 2nd: 20 to 50%Injection Pressure - Back Pressure: 0 to 20% |                          |                   |             |
| NOTE                                                                                                                                         |                          |                   |             |
| 1.                                                                                                                                           | 50 mm/min                |                   |             |

|    |            |
|----|------------|
| 2. | 50 mm/min  |
| 3. | 3.0 mm/min |
| 4. | 3.0 mm/min |

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