

EnCom PPE-PA 2030GF BK43001

Polyamide + PPE

EnCom, Inc.

Message:

30% Glass Filled PPE/PA Alloy

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Uses	Automotive Applications		
	Business Equipment		
	Thin-walled Parts		
Appearance	Black		
	Colors Available		
	Natural Color		
Forms	Pellets		
Processing Method	Injection Molding		
	Profile Extrusion		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.32	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.30 to 0.50	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	138	MPa	ASTM D638
Tensile Elongation (Break)	5.0	%	ASTM D638
Flexural Modulus	7580	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	96	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	232	°C	ASTM D648
CLTE - Flow	6.0E-6	cm/cm/°C	ASTM D696
Flammability	Nominal Value	Test Method	
Flame Rating (1.57 mm)	HB	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	93.3 to 107	°C	
Drying Time	2.0 to 4.0	hr	
Drying Time, Maximum	7.0	hr	
Suggested Max Moisture	5.0E-4	%	

Suggested Shot Size	40 to 75	%
Rear Temperature	260 to 299	°C
Middle Temperature	266 to 299	°C
Front Temperature	271 to 299	°C
Nozzle Temperature	277 to 299	°C
Processing (Melt) Temp	277 to 299	°C
Mold Temperature	65.6 to 121	°C
Back Pressure	0.172 to 0.689	MPa
Screw Speed	20 to 100	rpm
Vent Depth	0.038 to 0.076	mm

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