

PRL PPX-FR4

Polyphenylene Ether + PS

Polymer Resources Ltd.

Message:

PRL PPX-FR4 is a Polyphenylene Ether + PS (PPE+PS) product. It can be processed by injection molding and is available in North America.

Characteristics include:

- RoHS Compliant
- Flame Retardant
- Halogen Free
- Heat Resistant

General Information			
Additive	Flame Retardant		
Features	Bromine Free		
	Chlorine Free		
	Flame Retardant		
	Medium Heat Resistance		
	Self Extinguishing		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.10	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/11.6 kg)	35 to 50	g/10 min	ASTM D1238
Molding Shrinkage			ASTM D955
Flow : 3.18 mm	0.50 to 0.70	%	
Across Flow : 3.18 mm	0.50 to 0.70	%	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	117		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
Yield, 3.18 mm	48.3	MPa	
Break, 3.18 mm	46.9	MPa	
Tensile Elongation			ASTM D638
Yield, 3.18 mm	6.0	%	
Break, 3.18 mm	20	%	
Flexural Modulus (3.18 mm)	2210	MPa	ASTM D790
Flexural Strength (3.18 mm)	72.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256

-30°C, 3.18 mm	80	J/m	
23°C, 3.18 mm	270	J/m	
Gardner Impact (3.18 mm)	14.1	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.18 mm	85.0	°C	
1.8 MPa, Unannealed, 3.18 mm	76.7	°C	
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+16	ohms·cm	ASTM D257
Injection	Nominal Value	Unit	
Drying Temperature	76.7 to 82.2	°C	
Drying Time	3.0 to 4.0	hr	
Drying Time, Maximum	8.0	hr	
Rear Temperature	216 to 266	°C	
Middle Temperature	227 to 271	°C	
Front Temperature	238 to 277	°C	
Processing (Melt) Temp	246 to 274	°C	
Mold Temperature	65.6 to 82.2	°C	

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