EnCom PPE-PS 211-64

Polyphenylene Ether + PS

EnCom, Inc.

Message:

High Flow, High Impact PPE / HIPS Alloy

General Information			
Features	High Flow High Impact Resistance		
Uses	Automotive Applications		
Appearance	Black Colors Available Natural Color		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.06	g/cm³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.50 to 0.70	%	ASTM D955
Water Absorption (24 hr)	0.10	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Yield)	0.0414	MPa	ASTM D638
Flexural Modulus	1940	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (23°C)	340	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	108	°C	
1.8 MPa, Unannealed	99.4	°C	
Injection	**Nominal Value**	**Unit**	
Drying Temperature	87.8 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	238 to 293	°C	
Middle Temperature	243 to 299	°C	
Front Temperature	254 to 304	°C	
Nozzle Temperature	271 to 304	°C	

Processing (Melt) Temp	271 to 299	°C
Mold Temperature	65.6 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

Recommended distributors for this material

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