

4TECH® 9S33500 H

Polyphenylene
4Plas

Message:

4TECH 9S33500 H is a High Flow Halogen Free FR-V0 Heat Stabilised PPO

General Information			
Additive	heat stabilizer		
Features	High liquidity		
	Thermal Stability		
	Halogen-free		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.08	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/10.0 kg)	30	g/10 min	ISO 1133
Moisture Content	< 2000	ppm	ISO 960
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2750	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	70.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	20	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ISO 180/1A
-30°C	6.0	kJ/m ²	ISO 180/1A
23°C	7.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	130	°C	ISO 75-2/A
Vicat Softening Temperature	135	°C	ISO 306/B
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.750 mm	V-0		UL 94
1.60 mm	V-0		UL 94
Glow Wire Flammability Index (0.500 mm)	960	°C	IEC 60695-2-12
Injection	Nominal Value	Unit	
Drying Temperature	70.0 - 90.0	°C	
Drying Time	2.0 - 3.0	hr	
Suggested Max Moisture	0.020	%	
Processing (Melt) Temp	240 - 330	°C	
Mold Temperature	60.0 - 120	°C	

Injection Rate	Moderate-Fast	
Holding Pressure	60.0 - 120	MPa
Screw Speed	250	rpm

Injection instructions

Feed Throat Temperature: 60 - 80 °CBack Pressure: Low

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