

4TECH® 9S30000

Polyphenylene
4Plas

Message:

4TECH 9S30000 is a High Flow Unfilled PPO

General Information			
Features	High liquidity		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.04	g/cm ³	ISO 1183
Molding Shrinkage			
Vertical flow direction	0.60	%	
Flow direction	0.60	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2250	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	40.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	30	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	10	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	95.0	°C	ISO 75-2/A
Vicat Softening Temperature	115	°C	ISO 306/B
Flammability	Nominal Value		Test Method
Flame Rating (1.60 mm)	HB		UL 94
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 - 260	°C	
Mold Temperature	60.0 - 80.0	°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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