

XYRON™ AT610

Polyamide + PPE

Asahi Kasei Chemicals Corporation

Message:

Modified PPE
PA/PPE alloy
Non-reinforced Non-Flame retardant

General Information			
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.09	g/cm ³	ISO 1183
Molding Shrinkage ¹ (3.00 mm)	1.4 to 2.0	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield, 23°C)	66.0	MPa	ISO 527-2
Tensile Strain (Break, 23°C)	35	%	ISO 527-2
Flexural Modulus (23°C)	2300	MPa	ISO 178
Flexural Stress (23°C)	99.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ² (23°C)	20	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	113	°C	ISO 75-2/A
CLTE - Flow (-30 to 65°C)	9.0E-5	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity (23°C)	7.6E+15	ohms · cm	IEC 60093
Electric Strength ³ (2.00 mm)	25	kV/mm	IEC 60243-1
Dielectric Constant			IEC 60250
100 Hz	3.10		
1 MHz	2.90		
Dissipation Factor			IEC 60250
100 Hz	5.0E-3		
1 MHz	0.011		
Injection	Nominal Value	Unit	
Drying Temperature	110 to 130	°C	
Drying Time	2.0 to 4.0	hr	
Processing (Melt) Temp	280 to 300	°C	
Mold Temperature	60.0 to 120	°C	
NOTE			
1.	120x80x3 mm		
2.	4 mm		

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