

EnCom PPE-PS 160-06

Polyphenylene Ether + PS

EnCom, Inc.

Message:

PPE / HIPS Alloy

General Information			
Uses	Automotive Applications		
Appearance	Black		
	Colors Available		
	Natural Color		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.13	g/cm ³	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)	67.9	MPa	ASTM D638
Flexural Modulus	2420	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	300	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	80.0	°C	
1.8 MPa, Unannealed	70.0	°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

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