

XR404

Injection Molding

Description

- Heat Resistance

Applications

- Electric & Electronic Housing (Frame etc.)Automotive Interior & Exterior Housing (Garnish etc.)

Properties	Method	Unit	XR404
Physical			
Specific Gravity , 23°C	ISO 1183		1.05
Mold Shrinkage , 23°C, 3.2mm , 23°C	ISO 294-4	%	0.4 ~ 0.7
Melt Volume Rate , 220°C, 10kg	ISO 1133	cm ³ /10min	7
Mechanical			
Tensile Strength at Yield , 23°C, 50mm/min, 4mm	ISO 527	MPa	54
Tensile Elongation at Break , 23°C, 50mm/min, 4mm	ISO 527	%, (Min)	15
Tensile Modulus , 23°C, 50mm/min, 4mm	ISO 527	MPa	2450
Flexural Strength , 23°C, 2mm/min, 4mm	ISO 178	MPa	82
Flexural Modulus , 23°C, 2mm/min, 4mm	ISO 178	MPa	2550
Izod Impact Strength , Notched, 4mm, 23°C	ISO 180/1A	kJ/m ²	13
Izod Impact Strength , Notched, 4mm, -30°C	ISO 180/1A	kJ/m ²	6
Charpy Impact Strength , 4mm, 23°C	ISO 179/1eA	kJ/m ²	12
Charpy Impact Strength , 4mm, -30°C	ISO 179/1eA	kJ/m ²	6
Rockwell Hardness , R-Scale	ISO 2039		114
Thermal			
HDT , Flatwise, 1.8MPa, 4mm, Unannealed	ISO 75	°C	93
HDT , Flatwise, 0.45MPa, 4mm, Unannealed	ISO 75	°C	101
HDT , Flatwise, 1.8MPa, 4mm, Annealed	ISO 75	°C	101
HDT , Flatwise, 0.45MPa, 4mm, Annealed	ISO 75	°C	106
VICAT , 50N, 50°C/h	ISO 306	°C	112
RTI , Electrical	UL 746B	°C	60
RTI , Mechanical with Impact	UL 746B	°C	60
RTI , Mechanical without Impact	UL 746B	°C	60
Flammability, 1.5mm	UL 94		HB
Flammability, 3.0mm	UL 94		HB

Note

Typical values can be used only for the purpose of selecting material, and there can be variation within normal tolerances for various colors.

Values given should not be interpreted as specification and not be used for designing part or tool.

All properties, except melt flow rate are measured by injection molded specimens after 48 hours storage at 23°C, 50% relative humidity.

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Processing Guide (Injection Molding)

Processing Parameters	Unit	Value
Drying Temperature	°C	80 ~ 90
Drying Time	hrs	3 ~ 4
Maximum Moisture Content	%	~ 0.07
Melt Temperature	°C	230 ~ 260
Nozzle Temperature	°C	230 ~ 290
Mold Temperature	°C	40 ~ 80
Back Pressure, Hydraulic Type	kg/cm ²	10 ~ 30

Note

Back Pressure & Measuring Speed are only mentioned as general guidelines.

These may not apply or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding.

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