XYRON™ 644Z

Polyphenylene Ether + PS

Asahi Kasei Chemicals Corporation

Message:

Modified PPE
Unreinforced Flame retardant V-0
Heat resistance High

General Information			
UL YellowCard	E82268-100150215	E82268-633502	
Additive	Flame Retardant		
Features	Flame Retardant High Heat Resistance		
Processing Method	Injection Molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	1.09	g/cm³	ISO 1183
Molding Shrinkage [1] (2.00 mm)	0.50 to 0.80	%	Internal Method
Water Absorption (23°C, 24 hr)	0.10	%	ISO 62
Outdoor Suitability (Black)	f1		UL 746C
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress (Yield, 23°C)	74.0	MPa	ISO 527-2
Nominal Tensile Strain at Break (23°C)	9.0	%	ISO 527-2
Flexural Modulus (23°C)	2440	MPa	ISO 178
Flexural Stress (23°C)	110	MPa	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength [2] (23°C)	21	kJ/m²	ISO 179
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature (1.8 MPa, Unannealed)	129	°C	ISO 75-2/A
CLTE - Flow (-30 to 65°C)	7.0E-5	cm/cm/°C	ISO 11359-2
RTI Elec	125	°C	UL 746
RTI Imp	125	°C	UL 746
RTI Str	125	°C	UL 746
Flammability	**Nominal Value**		**Test Method**
Flame Rating			UL 94
1.00 mm	V-0		
2.00 mm	5VA		
Injection	**Nominal Value**	**Unit**	
Drying Temperature	90.0 to 100	°C	
Drying Time	2.0 to 4.0	hr	

Processing (Melt) Temp	260 to 320	°C
Mold Temperature	60.0 to 100	°C

NOTE	
1.	150x150x2 mm
2.	4 mm

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