



## Edgetek™ MP-20GF/000 BK088

### Polyphenylene Ether + PS

#### Key Characteristics

Product Description	
20% glass fiber reinforced PPO compound.	
General	
Material Status	• Commercial: Active
Regional Availability	• Asia Pacific
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight
Appearance	• Black
Forms	• Pellets
Processing Method	• Injection Molding

#### Technical Properties <sup>1</sup>

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.20	1.20	ASTM D792
Molding Shrinkage - Flow	1.0E-3 to 3.0E-3 in/in	0.10 to 0.30 %	ASTM D955
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Strength <sup>2</sup>	13800 psi	95.0 MPa	ASTM D638
Flexural Modulus <sup>3</sup>	870000 psi	6000 MPa	ASTM D790
Flexural Strength <sup>3</sup>	23200 psi	160 MPa	ASTM D790
Impact	Typical Value (English)	Typical Value (SI)	Test Method
Notched Izod Impact			ASTM D256
73°F (23°C), 0.126 in (3.20 mm)	2.2 ft-lb/in	120 J/m	
Thermal	Typical Value (English)	Typical Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
264 psi (1.8 MPa), Unannealed, 0.126 in (3.20 mm)	266 °F	130 °C	
Electrical	Typical Value (English)	Typical Value (SI)	Test Method
Surface Resistivity	1.0E+15 ohms	1.0E+15 ohms	ASTM D257
Flammability	Typical Value (English)	Typical Value (SI)	Test Method
Flame Rating (0.06 in (1.5 mm))	HB	HB	UL 94

#### Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	194 to 212 °F	90 to 100 °C
Drying Time	4.0 to 6.0 hr	4.0 to 6.0 hr
Rear Temperature	518 to 572 °F	270 to 300 °C
Middle Temperature	518 to 572 °F	270 to 300 °C
Front Temperature	518 to 572 °F	270 to 300 °C
Mold Temperature	149 to 203 °F	65 to 95 °C

Injection Notes
Injection Pressure: MED-HIGH
Hold Pressure: MED-HIGH
Screw Speed: MODERATE
Back Pressure: LOW

**Notes**

<sup>1</sup> Typical values are not to be construed as specifications.

<sup>2</sup> 0.20 in/min (5.0 mm/min)

<sup>3</sup> 0.051 in/min (1.3 mm/min)



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