

**Xyron™ L654V**

PPE-X40

Asahi Kasei

<b>Mechanical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Tensile Strength	<b>105</b>	MPa	ISO 527
Flexural modulus, 23°C	<b>9180</b>	MPa	ISO 178
Flexural strength	<b>150</b>	MPa	ISO 178
Charpy notched impact strength, +23°C	<b>6</b>	kJ/m <sup>2</sup>	ISO 179/1eA

<b>Thermal properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	<b>133</b>	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	<b>30</b>	E-6/K	ISO 11359-1/-2
Burning behav. at thickness h	<b>V-1</b>	class	IEC 60695-11-10
Thickness tested	<b>1.6</b>	mm	-
<b>ASTM Data</b>			
DTUL @ 264 psi	<b>130</b>	°C	ASTM D 648

<b>Electrical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Volume resistivity	<b>1E14</b>	Ohm*m	IEC 62631-3-1
Surface resistivity	<b>1E16</b>	Ohm	IEC 62631-3-2

<b>Other properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Density	<b>1420</b>	kg/m <sup>3</sup>	ISO 1183

<b>Processing Recommendation Injection Molding</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Pre-drying - Temperature	<b>100 - 110</b>	°C	-
Pre-drying - Time	<b>2 - 4</b>	h	-
Melt temperature	<b>270 - 310</b>	°C	-
Mold temperature	<b>60 - 120</b>	°C	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

North America, Europe, Asia Pacific

**Features**

Low Warpage