



## Typical Properties of XYDAR<sup>®</sup> M-450B

Property	Method	Unit	<b>M-450B</b>
Specific gravity	ASTM D792	–	1.84
Tensile strength	ASTM D638	MPa	86
Tensile Modulus	ASTM D638	GPa	12.9
Elongation	ASTM D638	%	1.6
Flexural strength	ASTM D790	MPa	95
Flexural modulus	ASTM D790	GPa	12.8
Izod impact strength (unnotched)	ASTM D256	kJ/m <sup>2</sup>	33
Deflection Temperature under Load 18.2MPa	ASTM D648	°C	295
Flammability rating	UL94 V-0	mm	0.50
Dielectric strength	ASTM D149	kV/mm	35.4
Volume resistivity	ASTM D257	X10 <sup>15</sup> Ω · cm	40.0
Surface resistivity		X10 <sup>15</sup> Ω	20.0
Dielectric constant 10 <sup>6</sup> Hz	ASTM D150	–	3.5
Dissipation Factor 10 <sup>6</sup> Hz	ASTM D150	–	0.034



## Recommended Molding Condition for XYDAR<sup>®</sup> #400

Condition		M-450B
Temperature (°C)	Cylinder : Rear	320 – 350
	Cylinder : Center	340 – 370
	Cylinder : Front	370 – 390
	Nozzle	370 – 390
	Mold	60 – 150
Injection Speed		middle – High speed
Drying Condition		over 150°C, over 8hr