

# XR409H

## Description

XR409H has well-balanced properties with extremely high heat (VST≥1160C), targeted for injection molding

## Key Features

Standard Purpose, Ultra High Heat Resistance, Non Painting

## Application

Cockpit,Door Trim,Fire Alarm,Hair Dryer,Interior ETC,Microwave Oven,Rear Combination Lamp,Set-Top Box,Tractor,Wireless Router

Properties	Condition	Method	Unit	XR409H
<b>Physical</b>				
Specific Gravity	23°C	ISO 1183		1.06
Mold Shrinkage	23°C, 3.2mm	ISO 294-4	%	0.4 ~ 0.7
Melt Flow Rate	220°C, 10kg	ISO 1133	g/10min	3
<b>Mechanical</b>				
Tensile Strength at Yield	23°C, 50mm/min, 4mm	ISO 527	MPa	49
Tensile Elongation at Break	23°C, 50mm/min, 4mm	ISO 527	%, (Min)	15
Tensile Modulus	23°C, 1mm/min, 4mm	ISO 527	MPa	2350
Flexural Strength	23°C, 2mm/min, 4mm	ISO 178	MPa	77
Flexural Modulus	23°C, 2mm/min, 4mm	ISO 178	MPa	2400
Izod Impact Strength	Notched, 4mm, 23°C	ISO 180/1A	kJ/m <sup>2</sup>	16
Izod Impact Strength	Notched, 4mm, -30°C	ISO 180/1A	kJ/m <sup>2</sup>	8
Charpy Impact Strength	Notched, 4mm, 23°C	ISO 179/1eA	kJ/m <sup>2</sup>	15
Charpy Impact Strength	Notched, 4mm, -30°C	ISO 179/1eA	kJ/m <sup>2</sup>	8
Rockwell Hardness	R-Scale	ISO 2039		114
<b>Thermal</b>				
Heat Deflection Temperature	Flatwise, 1.8MPa, 4mm, Unannealed	ISO 75	°C	99
Heat Deflection Temperature	Flatwise, 0.45MPa, 4mm, Unannealed	ISO 75	°C	106
Heat Deflection Temperature	Flatwise, 1.8MPa, 4mm, Annealed	ISO 75	°C	107
Heat Deflection Temperature	Flatwise, 0.45MPa, 4mm, Annealed	ISO 75	°C	111
Vicat Softening Temperature	50N, 50°C/h	ISO 306	°C	117

## 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 index 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
Injection Temperature	°C	220 ~ 290
Mold Temperature	°C	40 ~ 80
Screw Speed	rpm	30 ~ 60

## Note

Injection Temperature & Screw 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.