



## Typical properties of Xydar<sup>®</sup> MG-350HF

Properties	Unit	Method (ASTM)	MG-350HF
Tensile strength (3.2mmT)	MPa	D638	108
Tensile Modulus (3.2mmT)	GPa		13.6
Elongation (3.2mmT)	%		2.2
Flexural strength (3.2mmT)	MPa	D790	145
Flexural modulus (3.2mmT)	GPa		13.9
Poisson's ratio	—	—	0.33
Izod impact strength (un-notched)	kJ/m <sup>2</sup>	D256	45
Rockwell hardness	R scale	D785	97
Specific gravity	—	D792	1.76
Water absorption	%	D570	0.02
Deflection temperature under load (load 1.82MPa)	degree C	D648	265
Thermal conductivity	kcal/m·hr·°C	F433	0.310
Flammability rating (V-0 applied thickness)	mm	UL94	0.30
Oxygen index	%	D2863	46
Dielectric strength	KV/mm	D149	34.9
Arc resistance	sec	D495	—
Volume resistivity	×10 <sup>15</sup> Ω·cm	D257	26.0
Surface resistivity	×10 <sup>15</sup> Ω		18.5
Dielectric constant	10 <sup>2</sup> Hz	D150	4.2
	10 <sup>6</sup> Hz		4.2
Dielectric dissipation factor	10 <sup>2</sup> Hz	D150	0.013
	10 <sup>6</sup> Hz		0.029



Coefficient of Linear Thermal Expansion

Unit:  $10^{-5}$ cm/cm/°C

Grade	Direction *	Range of Temperature (°C)			
		50-100	100-150	150-200	200-250
NC-301 BL	MD	0.8	0.9	0.8	0.5
	TD	4.5	5.6	6.5	7.3

Direction\* : MD = Machine Direction

TD = Transversal Direction

Molding Conditions

		Conditions
Cylinder Temperature (°C)	Aft	300~320
	Mid	320~350
	Front	340~360
Nozzle Temperature (°C)		340~360
Mold Temperature (°C)		40~120
Injection Pressure (MPa)		30~120
Injection Speed		Mid ~ High

Remark)

\* Please apply Drying @150°C over 8 hours. This procedure is definitely necessary in order to prevent decay of material.