

Technical Data Sheet

Heat Resistance Modifier APH 1550F

Features N-PMI type heat resist co-polymer
Applications Heat booster compounded with ABS, PC, PP, PVC, EP etc.

Physical	Test Method	Value
Density	ISO 1183	1.07 g/cm ³
Melt Flow Index	(230°C, 3.8kg) ISO 1133	2.1 g/10min 0.5 g/10min
Mold Shrinkage	ISO 294-4	0.2 ~ 0.6 %
Water absorption	ISO 62	0.3 %

Mechanical	Test Method	Value
Tensile Strength	ISO 527	56 Mpa
Elongation	ISO 527	4.5 %
Flexural Strength	ISO 178	76 MPa
Flexural Modulus	ISO 178	3,400 Mpa
Izod Impact Strength(3.2mm)	ISO 180/1A	2.5 KJ/m ²
Rockwell Hardness(M scale)	ISO 2039-2	100

Thermal	Test Method	Value
Heat Deflection Temperature(1.8Mpa)	ISO 75-2	122 °C
Vicat Softening Temperature(1kg, 50°C/h)	ISO 306	132 °C

Flammability	Test Method	Value
Flame Rating - UL (1.6mm)	UL 94	HB

Notes

These are just typical properties, not specifications. Users should confirm results by their own test.

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Processing guide

Injection Guide	Unit	Value
Nozzle	°C	240~260
Front	°C	230~250
Middle	°C	200~230
Rear	°C	190~210
Hopper Throat	°C	45
Mold	°C	70~80

Drying	Unit	Value
Temperature	°C	80~85
Time	hr	2~4

Notes

These are only mentioned as general guidelines.