

**RheTech Products FT1004-625UV Thermoplastic Polyolefin, UV Stabilized, Interior DX9 Black**

Category : Polymer , Thermoplastic , Polyolefin

Material Notes:

Applications: Step padsHitch padsScuff platesInjection molding conditions reported in table.Information provided by RheTech Products.

Order this product through the following link:  
[http://www.lookpolymers.com/polymer\\_RheTech-Products-FT1004-625UV-Thermoplastic-Polyolefin-UV-Stabilized-Interior-DX9-Black.php](http://www.lookpolymers.com/polymer_RheTech-Products-FT1004-625UV-Thermoplastic-Polyolefin-UV-Stabilized-Interior-DX9-Black.php)

| Physical Properties   | Metric                                              | English                                             | Comments           |
|-----------------------|-----------------------------------------------------|-----------------------------------------------------|--------------------|
| Specific Gravity      | 0.930 g/cc                                          | 0.930 g/cc                                          | 23/23°C; ASTM D792 |
| Filler Content        | 4 %                                                 | 4 %                                                 | ASTM D5630         |
| Linear Mold Shrinkage | 0.0115 cm/cm                                        | 0.0115 in/in                                        | ASTM D955          |
| Melt Flow             | 13 g/10 min<br>@Load 2.16 kg,<br>Temperature 230 °C | 13 g/10 min<br>@Load 4.76 lb,<br>Temperature 446 °F | ASTM D1238         |

| Mechanical Properties     | Metric                            | English                               | Comments            |
|---------------------------|-----------------------------------|---------------------------------------|---------------------|
| Hardness, Shore D         | 62                                | 62                                    | ASTM D2240          |
| Tensile Strength at Break | 17.9 MPa                          | 2600 psi                              | 2 in/min; ASTM D638 |
| Flexural Modulus          | 0.758 GPa                         | 110 ksi                               | Tangent; ASTM D790  |
| Izod Impact, Notched      | 8.01 J/cm<br>@Temperature 23.0 °C | 15.0 ft-lb/in<br>@Temperature 73.4 °F | ASTM D256           |
| Gardner Impact            | 18.0 J                            | 13.3 ft-lb                            | ASTM D5420          |

| Thermal Properties                          | Metric  | English | Comments  |
|---------------------------------------------|---------|---------|-----------|
| Deflection Temperature at 0.46 MPa (66 psi) | 76.7 °C | 170 °F  | ASTM D648 |
| Deflection Temperature at 1.8 MPa (264 psi) | 48.9 °C | 120 °F  | ASTM D648 |

| Processing Properties     | Metric       | English      | Comments |
|---------------------------|--------------|--------------|----------|
| Rear Barrel Temperature   | 188 - 216 °C | 370 - 420 °F |          |
| Middle Barrel Temperature | 193 - 221 °C | 380 - 430 °F |          |
| Front Barrel Temperature  | 199 - 227 °C | 390 - 440 °F |          |
|                           |              |              |          |

| Nozzle Temperature<br>Processing Properties | 204 - 216 °C<br>Metric | 400 - 420 °F<br>English | Comments    |
|---------------------------------------------|------------------------|-------------------------|-------------|
| Mold Temperature                            | 26.7 - 48.9 °C         | 80.0 - 120 °F           |             |
| Drying Temperature                          | 65.6 - 82.2 °C         | 150 - 180 °F            |             |
| Dry Time                                    | 1 - 2 hour             | 1 - 2 hour              |             |
| Moisture Content                            | <= 0.050 %             | <= 0.050 %              | Recommended |
| Injection Pressure                          | 2.76 - 10.3 MPa        | 400 - 1500 psi          |             |
| Hold Pressure                               | 2.07 - 8.27 MPa        | 300 - 1200 psi          |             |
| Back Pressure                               | 0.345 - 1.03 MPa       | 50.0 - 150 psi          |             |

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