

RheTech Products FT4650-583UV Thermoplastic Polyolefin, UV Stabilized, Exterior DX9 Black

Category : Polymer , Thermoplastic , Polyolefin

Material Notes:

Applications: Scuff plates Exterior grilles Bodyside moldings Injection molding conditions reported in table. Information provided by RheTech Products.

Order this product through the following link:

http://www.lookpolymers.com/polymer_RheTech-Products-FT4650-583UV-Thermoplastic-Polyolefin-UV-Stabilized-Exterior-DX9-Black.php

Physical Properties	Metric	English	Comments
Specific Gravity	0.960 g/cc	0.960 g/cc	23/23°C; ASTM D792
Filler Content	8 %	8 %	ASTM D5630
Linear Mold Shrinkage	0.0090 cm/cm	0.0090 in/in	ASTM D955
Melt Flow	17 g/10 min @Load 2.16 kg, Temperature 230 °C	17 g/10 min @Load 4.76 lb, Temperature 446 °F	ASTM D1238

Mechanical Properties	Metric	English	Comments
Hardness, Shore D	60	60	ASTM D2240
Tensile Strength at Break	19.3 MPa	2800 psi	2 in/min; ASTM D638
Flexural Modulus	1.21 GPa	175 ksi	Tangent; ASTM D790
Izod Impact, Notched	1.87 J/cm @Temperature 23.0 °C	3.50 ft-lb/in @Temperature 73.4 °F	ASTM D256
Gardner Impact	22.6 J	16.7 ft-lb	ASTM D5420

Thermal Properties	Metric	English	Comments
Deflection Temperature at 0.46 MPa (66 psi)	86.7 °C	188 °F	ASTM D648
Deflection Temperature at 1.8 MPa (264 psi)	51.7 °C	125 °F	ASTM D648

Processing Properties	Metric	English	Comments
Rear Barrel Temperature	199 - 227 °C	390 - 440 °F	
Middle Barrel Temperature	204 - 232 °C	400 - 450 °F	
Front Barrel Temperature	210 - 238 °C	410 - 460 °F	

Processing Properties	Metric	English	Comments
Nozzle Temperature	216 - 227 °C	420 - 440 °F	
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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