

RheTech Thermoplastic Polyolefin

FT7030-01UVEG

Polyolefin
RheTech, Inc.

Message:
Thermoplastic Polyolefin, 275K Flexural Modulus, UV Stabilized, Black, Extrusion Grade

General Information			
Filler / Reinforcement	Filler, 25% filler by weight		
Additive	UV stabilizer		
Features	Good UV resistance		
Appearance	Black		
Processing Method	Extrusion		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.10	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	1.3	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	67		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	24.1	MPa	ASTM D638
Flexural Modulus	1900	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	130	J/m	ASTM D256
Dart Drop Impact	15.8	J	ASTM D5420
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	111	°C	ASTM D648
1.8 MPa, not annealed	56.7	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	65.6 - 82.2	°C	
Drying Time	1.0 - 2.0	hr	
Suggested Max Moisture	0.050	%	
Rear Temperature	193 - 221	°C	
Middle Temperature	199 - 227	°C	
Front Temperature	204 - 232	°C	
Nozzle Temperature	199 - 227	°C	
Mold Temperature	21.1 - 65.6	°C	
Injection Pressure	2.76 - 10.3	MPa	

Holding Pressure	2.07 - 8.27	MPa
Back Pressure	0.345 - 1.03	MPa
Injection instructions		

Injection Speed: Variable - application dependent Screw RPM: Recovery 3 seconds before mold opens Cycle Time: Wall thickness dependent

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