

RheTech Thermoplastic Polyolefin

FT4650-583UV

Polyolefin

RheTech, Inc.

Message:

Thermoplastic Polyolefin, 175K Flexural Modulus, UV Stabilized, Exterior DX9 Black

General Information			
Filler / Reinforcement	Filler, 8.0% filler by weight		
Additive	UV stabilizer		
Features	Good UV resistance		
Appearance	Black		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.958	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	17	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	60		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	19.3	MPa	ASTM D638
Flexural Modulus	1210	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	190	J/m	ASTM D256
Dart Drop Impact	22.6	J	ASTM D5420
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	86.7	°C	ASTM D648
1.8 MPa, not annealed	51.7	°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	199 - 227	°C	
Middle Temperature	204 - 232	°C	
Front Temperature	210 - 238	°C	
Nozzle Temperature	216 - 227	°C	
Mold Temperature	26.7 - 48.9	°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 Dependant Screw RPM: Recovery 3 seconds before mold opens Cycle Time: Wall Thickness Dependant

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

