

RheTech Thermoplastic Polyolefin FT4700-01

Polyolefin
RheTech, Inc.

Message:
Thermoplastic Polyolefin, 170K Flexural Modulus, Non-UV Stabilized, Black.

General Information			
Filler / Reinforcement	Filler, 12% filler by weight		
Appearance	Black		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.988	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	11	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	66		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	20.0	MPa	ASTM D638
Flexural Modulus	1170	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	350	J/m	ASTM D256
Dart Drop Impact	36.2	J	ASTM D5420
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	102	°C	ASTM D648
1.8 MPa, not annealed	52.2	°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	210 - 221	°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 DependentScrew RPM: Recovery 3 seconds before mold opensCycle Time: Wall Thickness Dependent

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