

Riteflex® XFR 655

Thermoplastic Copolyester Elastomer

Celanese Corporation

Message:

Riteflex XFR 655 is a thermoplastic polyester elastomer featuring a halogen-free flame retardant system and is UL certified to be V-0 at 1.5 mm in all colors. It has shore D hardness of 55 and an excellent balance of mechanical properties, flame retardant efficiency and processability.

General Information			
UL YellowCard	E45575-100088088		
Additive	Flame retardancy		
Features	Workability, good		
	Halogen-free		
	Flame retardancy		
RoHS Compliance		Contact manufacturer	
Physical	Nominal Value	Unit	Test Method
Density	1.23	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	8.7	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (250°C/2.16 kg)	20.0	cm ³ /10min	ISO 1133
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D, 15 sec)	55		ISO 868
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	360	MPa	ISO 527-2/1A/1
Tensile Stress			ISO 527-2/1A/50
Fracture	16.0	MPa	ISO 527-2/1A/50
50% strain	14.0	MPa	ISO 527-2/1A/50
Tensile Strain (Break)	250	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	> 50	%	ISO 527-2/1A/50
Elastomers	Nominal Value	Unit	Test Method
Tear Strength - Flow ¹	55	kN/m	ISO 34-1
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	13	kJ/m ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Melting Temperature ²	200	°C	ISO 11357-3
Electrical	Nominal Value	Unit	Test Method
Dielectric Strength	15	kV/mm	IEC 60243-1
Comparative Tracking Index	> 600	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	V-0		UL 94

Oxygen Index	37	%	ISO 4589-2
Injection	Nominal Value	Unit	
Suggested Max Regrind	25	%	
Rear Temperature	200 - 215	°C	
Middle Temperature	215 - 230	°C	
Front Temperature	215 - 230	°C	
Nozzle Temperature	215 - 235	°C	
Processing (Melt) Temp	220 - 235	°C	
Mold Temperature	20.0 - 55.0	°C	
Injection Rate	Fast		
Back Pressure	0.00 - 0.345	MPa	
Injection instructions			
Zone 4 Temperature: 215 to 235°C Screw Speed: Medium			
NOTE			
1.	Die C		
2.	10°C/min		

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