

# SEQUEL® 2326

Thermoplastic Polyolefin Elastomer

LyondellBasell Industries

## Message:

Sequel 2326 thermoplastic polyolefin material is designed for molded-in-color automotive interior applications that require energy-management properties. This product is typically supplied in natural or an OEM matched interior color with UV protection.

Typical Customer Applications:

Interior Applications

General Information			
Filler / Reinforcement	Filler, 10% filler by weight		
Features	Good UV resistance		
	Good coloring		
	Low temperature impact resistance		
	ductility		
Uses	Application in Automobile Field		
	Car interior equipment		
Appearance	Available colors		
	Natural color		
Forms	Particle		
Physical	Nominal Value	Unit	Test Method
Density	0.960	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	15	g/10 min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress <sup>1</sup> (Yield)	16.0	MPa	ISO 527-2/50
Flexural Modulus (23°C, 4.00 mm)	1100	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ISO 180
-40°C	6.0	kJ/m <sup>2</sup>	ISO 180
23°C	No Break		ISO 180
Instrumented Dart Impact <sup>2</sup>			ASTM D3763
-30°C	24.0	J	ASTM D3763
23°C	18.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	75.0	°C	ISO 75-2/B
1.8 MPa, not annealed	54.0	°C	ISO 75-2/A

Injection	Nominal Value	Unit
Drying Temperature	50.0 - 80.0	°C
Drying Time	2.0 - 6.0	hr
Suggested Max Moisture	0.050	%
Rear Temperature	205	°C
Middle Temperature	210	°C
Front Temperature	215	°C
Nozzle Temperature	215	°C
Processing (Melt) Temp	190 - 240	°C
Mold Temperature	30.0	°C
Injection Pressure	3.50 - 10.5	MPa
Back Pressure	0.350 - 2.00	MPa
Screw Speed	50 - 100	rpm
Cushion	6.00 - 13.0	mm

#### Injection instructions

Hot Runner Manifold and Tips: 215°C Mold Cavity Temperature: 30°C Mold Core Temperature: 24°C Injection Pressure, High (first stage): 35 to 105 bar Injection Pressure, Low (second stage): 25 to 70 bar Injection Velocity: 10 to 80 mm/sec

#### NOTE

- 150x10x4mm specimen
- 6.70 m/sec

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#### Recommended distributors for this material

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