

Riteflex® 655HS

Thermoplastic Copolyester Elastomer

Celanese Corporation

Message:

55 Shore D Hardness heat stabilized

General Information			
Additive	heat stabilizer		
Features	Thermal Stability		
RoHS Compliance	Contact manufacturer		
Processing Method	Blow molding		
	Extrusion		
	Injection molding		

Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.20	g/cm ³	ASTM D792
--	1.19	g/cm ³	ISO 1183
Specific Volume	0.842	cm ³ /g	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/2.16 kg)	9.0	g/10 min	ISO 1133
Molding Shrinkage			
Flow	1.0	%	ASTM D955
Vertical flow direction	1.7 - 2.1	%	ISO 294-4
Flow direction	1.6 - 1.9	%	ISO 294-4

Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	55		ASTM D2240

Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break, 23°C)	26.2	MPa	ASTM D638
Tensile Elongation (Break, 23°C)	330	%	ASTM D638
Flexural Modulus (23°C)	205	MPa	ISO 178
Flexural Stress (3.5% Strain)	7.00	MPa	ISO 178

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C, Partial Break)	65	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179/1eU

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	45.0	°C	ISO 75-2/A
Vicat Softening Temperature	178	°C	ASTM D1525

Peak Melting Temperature	200	°C	ASTM D3418
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity			
--	5.0E+12	ohms·cm	ASTM D257
--	2.0E+15	ohms·cm	IEC 60093
Dielectric Strength			
-- ¹	14	kV/mm	ASTM D149
--	14	kV/mm	IEC 60243-1
Relative Permittivity (1 MHz)	4.00		IEC 60250
Dissipation Factor (1 MHz)	0.040		IEC 60250
Comparative Tracking Index	> 600	V	IEC 60112, ASTM D3638
Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	100 - 110	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.050	%	
Suggested Max Regrind	25	%	
Hopper Temperature	20.0 - 50.0	°C	
Rear Temperature	200 - 215	°C	
Middle Temperature	205 - 230	°C	
Front Temperature	205 - 230	°C	
Nozzle Temperature	205 - 235	°C	
Processing (Melt) Temp	205 - 235	°C	
Mold Temperature	20.0 - 55.0	°C	
Injection Rate	Moderate-Fast		
Back Pressure	0.00 - 0.345	MPa	
Injection instructions			
Manifold Temperature: 205 to 235°CZone 4 Temperature: 205 to 235°CFeed Temperature: 200 to 215°C			
NOTE			
1.	Method A (short time)		

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