

RheTech Thermoplastic Polyolefin FT4600-152

Polyolefin

RheTech, Inc.

Message:

Thermoplastic Polyolefin, 190K Flexural Modulus, UV Stabilized, JA6A Black.

General Information			
Filler / Reinforcement	Filler, 5.0% filler by weight		
Additive	UV stabilizer		
Features	Good UV resistance		
Appearance	Black		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.928	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	8.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	72		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	28.4	MPa	ASTM D638
Flexural Modulus	1310	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	69	J/m	ASTM D256
Dart Drop Impact	13.9	J	ASTM D5420
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	104	°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	188 - 216	°C	
Middle Temperature	199 - 221	°C	
Front Temperature	199 - 227	°C	
Nozzle Temperature	204 - 216	°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 DependantScrew RPM: Recovery 3 seconds before mold opensCycle Time: Wall Thickness

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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

