

RheTech Thermoplastic Polyolefin

FT2500-630UV

Polyolefin
RheTech, Inc.

Message:
Thermoplastic Polyolefin, 90K Flexural Modulus, UV Stabilized, 500F Light Charcoal.

General Information			
Additive	UV stabilizer		
Features	Good UV resistance		
Appearance	Light gray		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.908	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)	63		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	16.5	MPa	ASTM D638
Flexural Modulus	621	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	800	J/m	ASTM D256
Dart Drop Impact	20.3	J	ASTM D5420
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	79.4	°C	ASTM D648
1.8 MPa, not annealed	54.4	°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	193 - 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
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Injection instructions

Injection Speed: Variable - Application DependentScrew RPM: Recovery 3 seconds before mold opensCycle Time: Wall Thickness Dependent

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